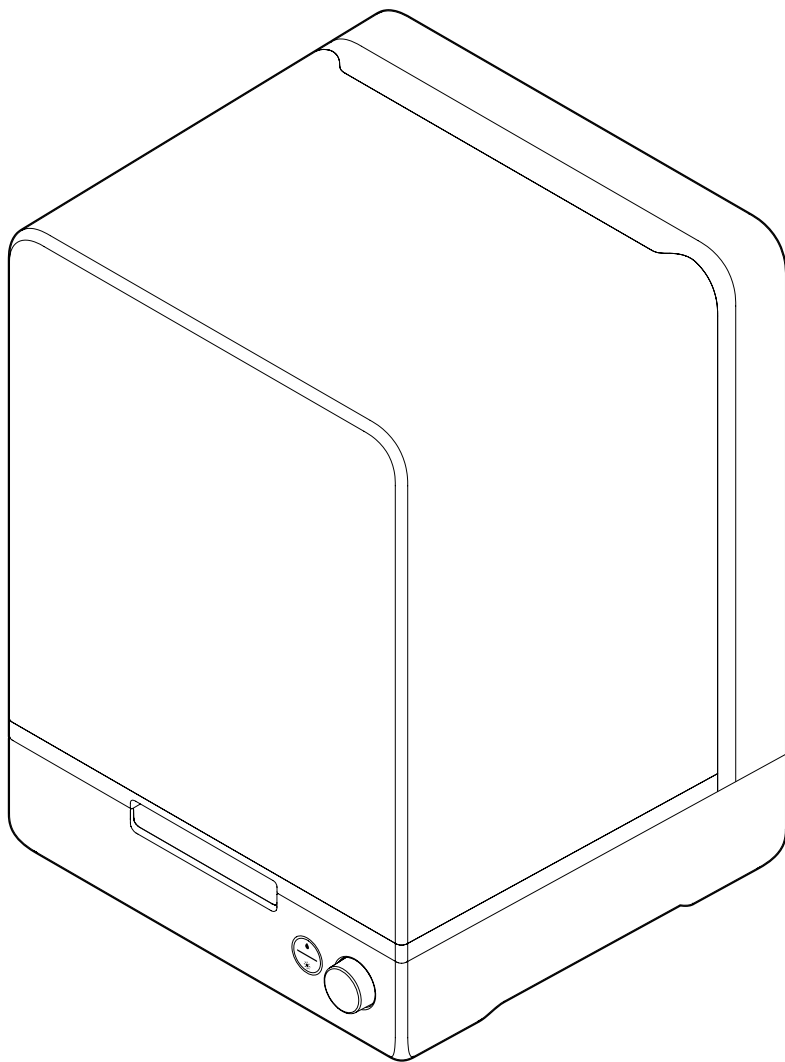


MANUAL

FORM

WASH+CURE



Installation and Usage Instructions

FORM STUDIO WASH+CURE

Desktop Stereolithography Print Cleaner
and Post-Cure Chamber

Original English instructions

Read this manual carefully and keep it for future reference.

September 2026

REV 01

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Read and understand this manual and its safety instructions before using the Form Studio Wash+Cure. Failure to do so can result in serious injury or death.

DISCLAIMER

Formlabs has made every effort to ensure these instructions are as clear, complete, and correct as possible. The information provided in this documentation contains general descriptions and/or technical characteristics of the performance of the products contained herein. This documentation is not intended as a substitute for, and is not to be used for, determining suitability or reliability of these products for specific user applications. It is the duty of any such user or integrator to perform the appropriate and complete risk analysis, evaluation, and testing of the products with respect to the relevant specific application or use thereof. Neither Formlabs nor any of its affiliates or subsidiaries shall be responsible or liable for misuse of the information that is contained herein. If you have any suggestions for improvements or amendments or have found errors in this publication, please notify us.

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DOCUMENT REVISIONS

Date	Version	Document changes
Sept 2026	REV 01	Initial publication

1. PREFACE

Congratulations on purchasing the Form Studio Wash+Cure. On behalf of the employees who create and support Formlabs technology, we thank you for your purchase.

The Form Studio Wash+Cure is a stereolithography (SLA) print cleaner and post-cure chamber. Washing printed SLA parts removes excess uncured liquid resin. Post-curing printed parts in the Form Studio Wash+Cure strengthens them 405 nm light and brings them to their optimal mechanical properties.

This manual explains how to set up, use, and properly maintain the Form Studio Wash+Cure and provides design guidance for optimizing print results.

The manual is intended for anyone who is installing, operating, maintaining, or otherwise interacting with the Form Studio Wash+Cure. Supervise young or inexperienced users to ensure enjoyable and safe operation.

1.1 Read and retain instructions

Read and understand this manual and its safety instructions before using the Form Studio Wash+Cure. Failure to do so can result in serious injury or death. Keep all safety information and instructions for future reference and provide them to subsequent users of the product.

Follow all the instructions. This will avoid fire, explosions, electric shocks, or other hazards that may result in damage to property and/or severe or fatal injuries.

The Form Studio Wash+Cure shall only be used by persons who have fully read and understood the contents of this usage manual. Ensure that each person who uses the Form Studio Wash+Cure has read these warnings and instructions and follows them. Formlabs is not liable for cases of material damage or personal injury caused by incorrect handling or non-compliance with the safety instructions. In such cases, the warranty will be voided.

1.2 Obtaining documentation and information

Visit formlabs.com/support to:

- Access the latest version of all Formlabs product documentation.
- Contact Formlabs to request documentation, usage instructions, and technical information.
- Submit any comments or feedback regarding what is good and what can be improved.
- Request additional training.

1.2.1 Support and service

Retain a record of the original purchase to request warranty services. Service options depend on the status of the specific product's warranty. Include the serial name of the product when contacting [Formlabs Support](#) or a [certified service provider](#) for product support. For products purchased from authorized resellers, contact the original service provider for assistance before contacting Formlabs Support.

Instead of a serial number, Formlabs products have a serial name, which is a unique identifier to track the history of manufacturing, sales, and repair, and to distinguish usage when connected to a network. The serial name is on the back panel of the machine in the format **FormWashCure-ColorAdjectiveAnimal**.

Service providers of Formlabs products also provide support and service. To the extent that Formlabs or a certified service provider offers other or extended warranties, the terms of the separate offer may apply.

For any support or service requests, including product information, technical assistance, or assistance with instructions, contact [Formlabs Support](#):

USA Formlabs, Inc. 35 Medford St. Somerville, MA, USA, 02143	USA Formlabs, Inc. 220 E Buffalo St. Milwaukee, WI, USA 53202
Hungary Formlabs Andrássy út 9 1061 Budapest, Hungary	Germany Formlabs GmbH Mühlenstr. 15 10243 Berlin, Germany
Japan 1F Kitashinagawa Ubiz Shinagawa 3 Chome-6-9 Kitashinagawa Shinagawa City, Tokyo 140-0001, Japan	China Formlabs China 形朗科技（深圳）有限公司 Room 601, Building E, Tongfang Information Port, No. 11 Langshan Road, Songpingshan Community, Xili Subdistrict, Nanshan District, Shenzhen City, Guangdong Province, China

1.2.2 **Returns**

Formlabs accepts returns for unopened, unused, undamaged SLA products within 14 days of the shipment date. Returns must be authorized by Formlabs. Visit [Formlabs.com](#) for more detailed information about returning your purchase.

1.2.3 **Warranty**

This product is protected under warranty. Formlabs offers a warranty for all Formlabs branded hardware. Unless otherwise expressly stated, the **Terms of Service**, including the **Warranty**, constitute the entire agreement between you and Formlabs with respect to the **Service** and any product you purchase from Formlabs and supersedes all prior or contemporaneous communications, proposals, and agreements, whether electronic, oral, or written, between you and Formlabs. Read the warranty for more details on the Formlabs warranty for your region:

US	formlabs.com/terms-of-service
EU (EN)	formlabs.com/eu/terms-of-service
EU (DE)	formlabs.com/de/terms-of-service
EU (FR)	formlabs.com/fr/terms-of-service

EU (ES)	formlabs.com/es/terms-of-service
EU (IT)	formlabs.com/it/terms-of-service
Latin America (ES)	formlabs.com/latam/terms-of-service
Asia and Oceania (EN)	formlabs.com/asia/terms-of-service
Japan (JA)	formlabs.com/jp/terms-of-service

2. INTRODUCTION

2.1 Intended use

The Form Studio Wash+Cure washes and post-cures 3D printed parts. The final performance characteristics of cured photopolymer resin may vary according to your compliance with the instructions for use, application, operating conditions, material combined with, end use, or other factors.



NOTICE

In some cases, the additive manufacturing process may inherently result in variable performance characteristics between manufacturing runs or within a specific part. Such variances may not be apparent and may result in unexpected defects in additively fabricated parts.



WARNING

You shall independently verify the suitability of additive manufacturing, stereolithography (SLA), the Form Studio Wash+Cure, and any specific designs or materials employed for the application and intended purpose before use. In no event shall Formlabs be liable for any loss, death, or bodily injury that you suffer, or that you cause to any third party, in connection with your use of Formlabs products. To the fullest extent legally permitted Formlabs EXPRESSLY DISCLAIMS ANY IMPLIED OR EXPLICIT WARRANTY OF FITNESS for a particular usage, the particular nature and circumstances of said usage being unforeseen and unforeseeable to Formlabs.



WARNING

Formlabs is not a manufacturer of medical devices. Formlabs provides tools and materials that may be used in many applications, but makes no claims as to the safety or effectiveness of any specific devices made using Formlabs products. Certain Formlabs products, such as those commonly known in the industry as "biocompatible" materials, have been engineered to comply with relevant industry standards. The specific standards and most relevant technical specifications may be identified within the technical data sheets and have been tested according to relevant testing protocols for those standards and specifications. Biocompatible materials are a speciality product, developed for use by medical professionals, and should be used in accordance with the instructions for use. The Form Studio Wash+Cure has not been designed or tested for use with these materials.



WARNING

Do not modify. The Form Studio Wash+Cure is intended for use as-is. Modifying the machine without explicit approval and directions from Formlabs or a certified service provider will void your warranty, and could potentially damage the machine and cause bodily harm.

2.2 Technical specifications

2.2.1 General specifications

Parameter	Unit
Unit	Form Studio Wash+Cure
Installation surface	Desktop unit
Minimum dimensions for convenient access (W × D × H)	46 × 43 × 84 cm 18.1 × 16.9 × 33 in
Product dimensions (W × D × H)	33 × 30 × 44 cm 13 × 11.8 × 17.3 in
Product weight	9 kg 19.8 lb
Shipping weight	10.5 kg 23.1 lb
Available modes	Wash mode Cure mode Automatic mode switch with removal/insertion of the wash bucket
Operating environment	18–28 °C 64–82 °F
Power requirements	Input: 100–240 VAC, 50/60 Hz, maximum 1 A Output: 24 VDC, 60 W
Sound emission	Does not exceed 60 dB(A).

2.2.2 Washing specifications

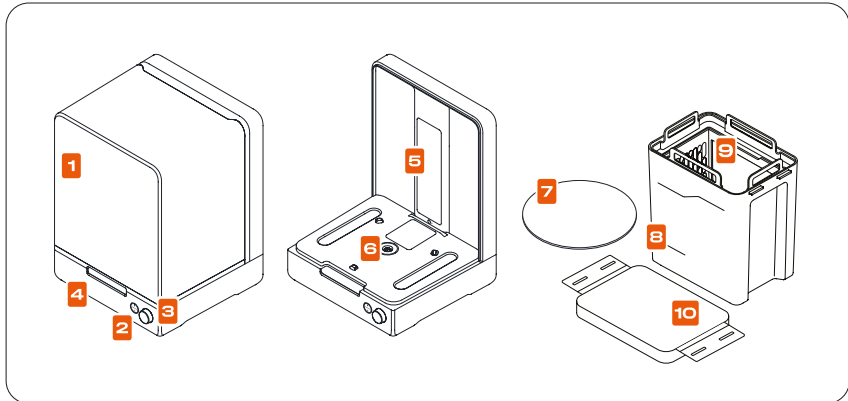
Parameter	Unit
Wash bucket volume	10 L
Maximum part dimensions for washing (W × D × H)	20.0 × 12.5 × 24.5 cm 7.87 × 4.92 × 9.65 in
Agitation method	Magnetically-coupled impeller
Speed selection	Low speed for water and other solvent wash High speed for IPA wash

2.2.3 Post-cure specifications

Parameter	Unit
Post-curing turntable diameter	24.0 cm 9.45 in
Maximum part height for post-curing	22.5 cm 8.9 in
Maximum part height for post-curing (W × D × H)	20.0 × 12.5 × 22.5 cm 7.87 × 4.92 × 8.9 in
Light source	24 multi-directional LEDs
UV LED electrical power	48 W

Parameter	Unit
UV LED radiant power (total)	27.8 W
UV LED wavelength	405 nm

2.3 Product components



- 1 Cover:** Orange cover blocks curing light when in cure mode.
- 2 Mode button:** Shows which mode is active (wash or cure). Press to manually change the mode.
- 3 Knob:** Turn or press to change mode or confirm speed selection.
- 4 Display:** Shows status, time, and speed options.
- 5 LEDs:** Two arrays with a total of 24 405 nm LEDs help to post-cure parts.
- 6 Turntable mount:** Rotates the turntable to balance post-curing across all exposed surfaces.
- 7 Turntable:** Rotating plastic plate ensures balanced post-curing across all exposed surfaces.
- 8 Wash bucket:** Holds a maximum of 10 L of solvent. Mounts into Form Studio Wash+Cure base for washing printed parts.
- 9 Wash basket:** Contains printed parts during washing.
- 10 Wash bucket cover:** Latching cover keeps solvent from evaporating or spilling when not in use.
- 11 Rinse bottle (not pictured):** Squeeze bottle for manually rinsing printed parts.
- 12 Power cable (not pictured):** Provides power to the Form Studio Wash+Cure.
- 13 Impeller (not pictured):** Located in the wash bucket. Couples to the Form Studio Wash+Cure with magnets and agitates solvent during a wash cycle.

2.4 Form Studio Wash+Cure controls

For detailed guidance and visual assistance, visit formlabs.com/support.

When connected to power, use the knob and button to program and operate the Form Studio Wash+Cure:

- Rotate the knob to adjust cycle time, indicated in minutes and seconds (mm:ss).
- Short press the knob to start a cycle, confirm a selection, or pause a cycle.
- Long press the knob to end a paused cycle or exit the current selection without saving.
- Short press the button to change the current mode.
- Long press the button to select the impeller speed in wash mode. Choose between low speed (for water and other solvent wash) or high speed (for IPA wash).

Check each material's recommended washing or post-curing time before beginning a cycle.

Short press the knob during a cycle to pause and to turn off the impeller or LEDs, while preserving the remaining time in the cycle. When post-curing, opening the cover automatically pauses the cure cycle.

3. SAFETY



Read and understand this manual and its safety instructions before using the Form Studio Wash+Cure. Failure to do so can result in serious injury or death.

Supervise young or inexperienced users to ensure enjoyable and safe operation. The instructions contain warnings and safety information, as explained below:



DANGER indicates a hazard with a high level of risk which, if not avoided, will result in death or serious injury.



WARNING indicates a hazard with a medium level of risk which, if not avoided, could result in death or serious injury.



CAUTION indicates a hazard with a low level of risk which, if not avoided, could result in minor or moderate injury.



NOTICE indicates information considered important, but not hazard-related.



DANGER: Isopropyl alcohol is a flammable chemical.



ENVIRONMENTAL HAZARD: Uncured photopolymer resin is classified as hazardous to aquatic life.



MANDATORY ACTION: Refer to instruction manual/booklet.



MANDATORY ACTION: Disconnect before carrying out maintenance or repair.



MANDATORY ACTION: Wear eye protection.



MANDATORY ACTION: Wear thermal-insulating silicone gloves when handling hot build chambers.

3.1 Component and subsystem safety

3.1.1 General

The Form Studio Wash+Cure is a professional appliance that includes electronic components. As with any such appliance:

- Do not operate the device with a damaged cord or plug.
- Ensure reliable grounding before connecting the device to power.
- Always disconnect power before cleaning.
- Only use well-maintained equipment.
- Operate on a clear and level surface.



Keep the area surrounding the turntable clean, and only post-cure parts that have been completely dried. Accumulation of cured material creates the possibility of malfunction.

The Form Studio Wash+Cure uses 405 nm light to post-cure 3D printed parts. The cover includes an interlock system that is designed to automatically extinguish the cure lights when the cover is open.

3.1.2 Resin

Respect Formlabs resin like any household chemical. Follow standard chemical safety procedures and Formlabs resin handling instructions. Refer to information about each specific resin for more detail.



Resin and solvents may cause skin irritation or an allergic skin reaction. Wear gloves when handling liquid resin, liquid solvent, or resin-coated surfaces. Wash skin with plenty of soap and water. Do not use alcohol or other solvents to remove resin from skin.



Consult the safety data sheet (SDS) as the primary source of information to understand safety and handling of Formlabs resins. Respect Formlabs resin like any household chemical. Follow standard chemical safety procedures and Formlabs resin handling instructions. In general, Formlabs resin is not approved for use with food, drink, or medical applications on the human body. Refer to the safety data sheet (SDS) for each specific resin as well as formlabs.com/support for more detail.

3.1.3 Radio interference

This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to CFR Title 47, Part 15 of FCC Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications.

Changes or modifications to this product not authorized by Formlabs could void the electromagnetic compatibility (EMC) and wireless compliance and negate your authority to operate the product.

This product has demonstrated EMC compliance under conditions that included the use of compliant peripheral devices and shielded cables between system components. It is important that you use compliant peripheral devices and shielded cables between system components to reduce the possibility of causing interference to radios, televisions, and other electronic devices.

3.1.4 Isopropyl alcohol (IPA)



Isopropyl alcohol is a flammable chemical. Keep away from ignition sources, including open flames, sparks or concentrated sources of heat. Allow any printed part cleaned with isopropyl alcohol to dry completely before post-curing.



Formlabs does not manufacture isopropyl alcohol. Consult the chemical manufacturer or supplier for detailed safety information. Carefully follow the safety instructions provided with the isopropyl alcohol that you purchase. Isopropyl alcohol can be flammable, even explosive, and should be kept away from heat, fire, or sparks. Any containers holding isopropyl alcohol should be kept closed or covered when not in use. We also recommend that you wear protective gloves and have good ventilation when working with isopropyl alcohol.

3.1.5 Tripropylene glycol monomethyl ether (TPM)



Formlabs does not manufacture tripropylene glycol monomethyl ether. Consult the chemical manufacturer or supplier for detailed safety information. Carefully follow the safety instructions provided with the tripropylene glycol monomethyl ether you purchase. We also recommend that you wear protective gloves when working with tripropylene glycol monomethyl ether.

3.2 Personal protective equipment (PPE)

Safe operation of the Form Studio Wash+Cure can be achieved by using the following equipment:

- Non-reactive nitrile gloves
- Safety glasses



Resin and solvents may cause skin irritation or an allergic skin reaction. Wear gloves when handling liquid resin, liquid solvent, or resin-coated surfaces. Wash skin with plenty of soap and water.



Some methods of support removal may cause small pieces of supports to break away. Beware of flying debris. Wear eye protection and gloves to protect the skin and eyes.

3.3 Specifications of tools to be used

The Form Studio Wash+Cure shall only be used with supplied accessories and additional tools recommended by Formlabs. Third-party accessories and materials may cause damage. Third-party accessories and materials may cause damage. Refer to sections [3.2 Personal protective equipment \(PPE\)](#) and [6.1 Tools and supplies for more information](#).

Purchase additional supplies:

- Apron
- General purpose cleaner (e.g., glass cleaner)
- Low-fiber paper towels
- Non-reactive nitrile gloves
- Safety glasses
- Shoe covers
- Sandpaper
- Mineral oil
- Primer and paints

3.4 Sensitive components

The Form Studio Wash+Cure has multiple components that are vulnerable to permanent damage if not periodically inspected and properly maintained. Using any tools, cleaning agents, or methods not mentioned in this manual may result in permanent damage to these components.

- **LED modules**

The Form Studio Wash+Cure uses two LED arrays to expose printed parts to 405 nm light during post-curing. Refer to section [6.4.2 Maintaining the light diffuser](#) for more information.

- **Magnetic coupler**

The Form Studio Wash+Cure uses a magnetic coupler to spin the impeller during a wash cycle. Refer to section [7.3 Disassembly and repair](#) for more information.

- **Turntable**

The Form Studio Wash+Cure uses a turntable that rotates throughout the post-cure cycle, ensuring that printed parts are evenly exposed to light. Refer to section [6.3.1 Maintaining the turntable](#) for more information.

3.5 Emergency and exceptional situations

Formlabs has made every effort to provide updated safety data sheets (SDS) for every resin product, in accordance with the latest government guidelines. Always consult the safety data sheet (SDS) as the primary source of information to understand safety and handling of Formlabs materials and required accessories. Visit formlabs.com/sds to download safety data sheets for Formlabs materials.

3.5.1 Chemical spills

Prepare for a possible chemical spill of flammable materials, such as isopropyl alcohol. Your spill response procedure should contain the following:

- A listing of personal protective equipment (PPE), safety equipment, and cleanup materials required for spill cleanup and an explanation of their proper use.

- Appropriate evacuation zones and procedures.
- Availability of fire suppression equipment.
- Disposal of containers for spill cleanup materials.
- The first aid procedures that might be required.

3.5.2

Fire



Do not use water to extinguish an electrical fire. Dousing an electrical fire with water increases the risk of electrocution, and may cause the fire to spread by allowing electricity to conduct across additional flammable surfaces.

If a localized fire develops either inside or outside of the machine, immediately take the following actions.

If the fire is inside the device:

1. Immediately disconnect the machine from its power source.
2. If the door of the Form Studio Wash+Cure is open, close its door if possible.
 - If a part inside the Form Studio Wash+Cure is on fire, do not close its door. Place a fire blanket over the unit.
3. Use an ABC fire extinguisher to cover the affected area generously.

If the fire is too large to control:

1. Immediately leave the area and close the door of the room behind you.
2. Evacuate the building according to your organization's emergency protocols.
3. Call emergency services once you have reached a safe distance from the fire.

3.5.3

Isopropyl alcohol (IPA)



When handling isopropyl alcohol, always consult the safety data sheet (SDS) from the isopropyl alcohol supplier as the primary source of information. Handle isopropyl alcohol with gloves in a well-ventilated area. Keep away from heat, sparks, and open flame. Isopropyl alcohol evaporates rapidly, so keep the wash bucket and bottles closed whenever possible.

3.5.4

Resin



Never ingest resin in liquid or solid form. If swallowed, immediately call a poison center or medical professional. Contact Chemtrec at +1 800 424 9300 for global 24-hour emergency assistance.



Promptly clean and inspect the device after a resin spill to minimize any cosmetic or functional damage to the machine. If you have experienced an accidental resin spill, document the problem with photos and clean the device as best as possible. Contact Formlabs Support or a certified service provider as soon as possible.

4. PREPARATION AND SETUP

4.1 Location and environment

Prepare a space to install and operate the Form Studio Wash+Cure and house the necessary accessories and consumables.

To prepare the workspace:

1. Choose a stable, level workspace to install and operate the Form Studio Wash+Cure. Ensure that the workspace meets the following requirements:
 - Dry, indoor location
 - Low ambient humidity (20–70% RH)
 - Temperature of 18–28 °C (64–82 °F)
 - Altitude < 2000 m (6561.7 ft)
 - Position the device so that it is easy to operate the power switch of the unit.
 - Dedicate a power outlet and circuit to the device capable of delivering 60 W of power at 100–240 VAC, 50/60 Hz.
2. Reserve the following minimum dimensions for the most convenient access:
 - Width: 46 cm (18.1 in)
 - Depth: 43 cm (16.9 in)
 - Height: 84 cm (33 in)
 - The cover lifts upwards to allow access to the wash bucket or turntable. The dimensions above include space for the door to open.
3. Allow additional space for accessories and other devices, such as a Formlabs SLA printer.

4.2 Unboxing the Form Studio Wash+Cure

For detailed guidance and visual assistance, visit formlabs.com/support.

Prior to unboxing, ensure that the suitable workspace has been prepared according to section [4.1 Location and environment](#).

The Form Studio Wash+Cure ships in a cardboard carton, protected by foam inserts above and below the machine. The upper foam insert also contains the accessories. During unboxing, inspect the Form Studio Wash+Cure for any damage or missing items. In the case of damage or missing items, contact Formlabs or the certified service provider.

To unbox the machine:

1. Open the box from the top.
2. Lift and remove the accessories from on top of the Form Studio Wash+Cure.
3. Lift the top foam off of the machine.
4. Lift the Form Studio Wash+Cure out of the box and set it on its work surface.
5. Lift the shipping bag off of the Form Studio Wash+Cure.
6. Open the Form Studio Wash+Cure cover.
7. Remove the foam protecting the front corners of the wash bucket.
8. Remove the wash bucket and set it aside.
9. Remove the foam in front of the turntable.
10. The turntable is taped to the back wall of the Form Studio Wash+Cure. Remove the tape and set the turntable aside.



Remove all packaging material before connecting power. Retain all packaging and inserts for warranty service.

4.3 Installing the Form Studio Wash+Cure:

To install the Form Studio Wash+Cure:

1. Find a clean, level surface with a nearby power source.
2. Connect the power cable to the Form Studio Wash+Cure and a power source. Power on the machine using the switch on the back of the unit.

The Form Studio Wash+Cure switches modes based on whether the turntable or wash bucket is installed. For more information, see [5.2 Washing printed parts](#) or [5.4 Post-curing printed parts](#).

4.4 Transporting the Form Studio Wash+Cure

Refer to [2.2 Technical Specifications](#) for product weight and dimensions. Keep the packaging for transportation or shipping.

The Form Studio Wash+Cure complete packaging kit consists of:

- 1 outer cardboard box
- 1 foam bottom insert
- 2 foam top inserts, which hold the small accessory boxes
- 1 foam turntable protector
- 2 foam wash bucket corner protectors
- 1 polyethylene bag

To prepare the machine:

1. Always empty and dry the wash bucket and remove the turntable and any printed parts before moving or packaging the machine.
2. Wipe residual liquid resin and solvent from the machine.



Do not ship the machine with any liquid resin or solvent inside. Liquids left inside the machine can leak during transit, which may result in additional fees, void the warranty, or present a safety hazard.

3. Reassemble the box.
4. Place the bottom foam insert in the box.



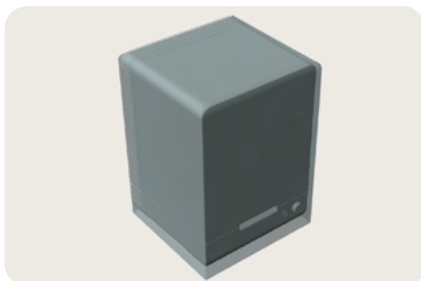
5. Open the Form Studio Wash+Cure cover.
6. Tape the turntable against the back wall of the machine. Place the foam turntable protector vertically in front of it.



7. Place the wash bucket (with wash basket and lid) onto the Form Studio Wash+Cure base.
8. Place the two foam wash bucket corner protectors in front of the bucket's front corners.



9. Close the Form Studio Wash+Cure cover.
10. Lower the polyethylene shipping bag over the machine.



11. Place the Form Studio Wash+Cure on top of the bottom foam insert.
12. Place the two top foam inserts on top of the Form Studio Wash+Cure.
13. Seal the box with adhesive packing tape.



NOTICE

When shipping a machine to Formlabs for service, do not ship the accessories or the power cable. Accessories will not be returned after service. The product's original packaging is required for warranty service. Contact other authorized resellers for unique guidance on shipping requirements.

5. USAGE

5.1 Operational environment

Operate the Form Studio Wash+Cure in a well-ventilated room with a temperature of 18–28 °C (64–82 °F). For optimal performance, do not exceed this range.

- **Ventilation:** Well-ventilated area
- **Temperature:** 18–28 °C (64–82 °F)
- **Power:**
 - Dedicated power outlet capable of delivering 60 W of power at 100–240 VAC, 50/60 Hz
 - Easy access to the power switch and power cord of the device
- **Location:** Dry, indoor
- **Altitude:** Maximum 2000 m (6561.7 ft)
- **Humidity:** Low ambient humidity (20–70% RH)

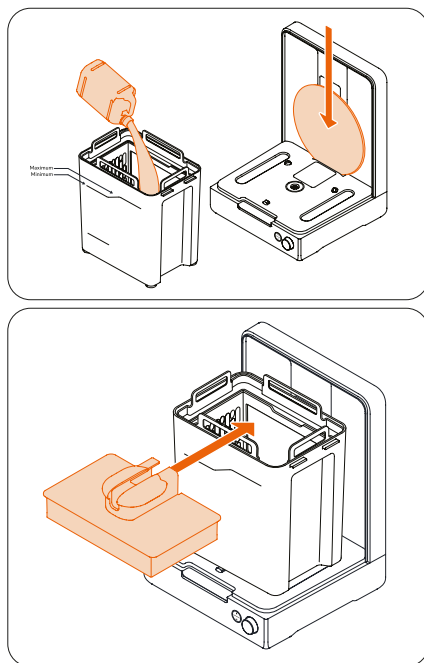
5.2 Washing printed parts

When an SLA 3D print finishes, the printed parts are still coated in liquid resin. They must be washed in a solvent to clean off this liquid resin and prepare the parts for post-curing and other post-processing. The Form Studio Wash+Cure helps ensure consistent thorough washing by agitating the wash solvent with an impeller. For detailed guidance and visual assistance, visit formlabs.com/support.

5.2.1 Inserting prints

To wash a printed part:

1. If you have not already, insert the wash basket into the wash bucket. Fill the bucket with solvent, ensuring the solvent level is between the minimum and maximum (10 L) marks.
2. Open the Form Studio Wash+Cure cover.
3. Remove the turntable or place it into its designated slot in front of the LED arrays.
4. Place the wash bucket on the Form Studio Wash+Cure base. The machine automatically switches to wash mode.
5. Place your build platform with printed parts attached on top of the wash basket, or place loose printed parts in the basket directly.
6. Optional: Latch the wash bucket lid onto the bucket. This is not required for washing but helps to reduce solvent evaporation.
7. Close the Form Studio Wash+Cure cover.



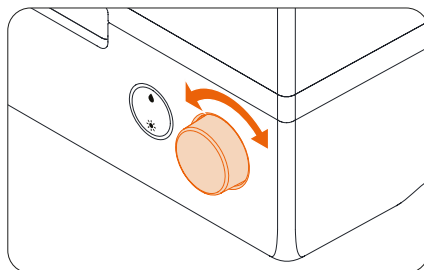
Parts must be washed on the build platform or in the basket. Ensure parts are fully secured to the build platform when washing parts without the basket installed. Washing loose parts directly in the wash bucket—whether intentionally or accidentally—may damage printed parts, create noise, and interfere with solvent agitation.

Parts can also be washed in the basket, either as an alternative or in addition to the platform mount. Place parts directly in the basket after removing them from the build platform using the removal tool, scraper, or flush cutters.

5.2.2 **Setting up and starting a wash cycle**

To set up and start a wash cycle:

1. Select a wash speed:
 - a. Long press the button. The wash speed selection screen appears.
 - c. Turn the knob to select a wash speed. Short press to confirm
2. Use the knob to select the time for the wash cycle, then short press to confirm and start the cycle.



Part washing time depends on the resin and solvent used. Check formlabs.com/support for specific wash time recommendations. Wash for additional time when using partially resin-concentrated solvent.

To pause a wash cycle:

1. While a wash cycle is in progress, short press the knob to pause. The timer pauses, and the display blinks the remaining time.
2. Short press the knob a second time to continue the wash cycle.
 - To exit a paused wash cycle, long press the knob to reset the wash time to zero. Otherwise, wait for the wash cycle to finish.

To pause a wash cycle:

1. When the wash cycle timer reaches zero, the display blinks the remaining time (00:00). The machine will beep and start a count up to remind you to remove the printed parts from the solvent.
2. Interact with the machine (turn or press the knob, open the cover, or remove the bucket) to return to the home screen.



NOTICE

Remove the parts from IPA or other solvent immediately after the washing cycle is completed to avoid damage to or degradation of the printed part.

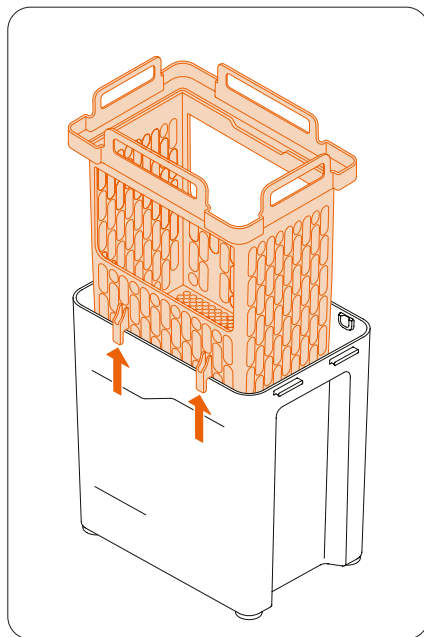
The Form Studio Wash+Cure will periodically beep (every two minutes) as a reminder to remove the parts. It also tracks the time since the cycle ended; beyond 30 minutes, the counter will be visible on the display.

5.2.3 Draining and drying prints

After the wash cycle is complete, thoroughly drain solvent from printed parts; carefully check and drain concave or hollow geometries that may hold additional solvent. Allow parts that have been washed in any solvent that evaporates readily to air dry for at least 30 minutes after washing and draining. Solvents that do not evaporate readily, such as tripropylene monomethyl ether (TPM), should be washed off the parts with a secondary water rinse. Consult formlabs.com/support for additional information about working with specific solvents.

You can either drain and dry the prints in the Form Studio Wash+Cure or outside of it:

1. Open the Form Studio Wash+Cure cover.
2. For drying inside the machine:
 - a. Unlatch and remove the bucket lid (if you placed the lid on the bucket during the wash).
 - b. Lift the wash basket out of the bucket and use the tabs to hook it onto the edge of the wash bucket.
3. For drying outside the machine:
 - a. Remove the wash bucket from the machine and place it on a flat, stable surface in a workspace with good ventilation.
 - b. If you placed the lid on the wash bucket, unlatch and remove the lid.
 - c. Lift the wash basket out of the bucket and use the tabs to hook it onto the edge of the wash bucket.



Ensure appropriate ventilation while the solvent evaporates. Observe necessary safety precautions, according to the solvent supplier's SDS. Options for drying include air drying or forced air. Forced air, such as a fan or clean compressed air, may dry parts more quickly.



NOTICE

Check inside cavities and channels for uncured resin or liquid solvent. Remove residual liquid before drying to avoid fully or partially cured resin in unwanted areas. Compressed air may be helpful to empty internal channels before drying.

To begin the next wash immediately, dry the parts outside of the Form Studio Wash+Cure. Take extra care with sharp objects and slippery surfaces when removing wet parts from the build platform.

5.2.4 **Collecting your prints**

Remove the build platform or parts from the basket, depending on the wash method used in [5.2.1 Inserting prints](#).

5.3 **Considerations for washing specific geometries**

Consider the specific geometry of each part when choosing a method to wash the part and the sequence of steps. Take special care when washing parts that are large, hollow, concave or cup shaped, or have internal chambers or channels that hold solvent, air, or uncured resin inside.

5.3.1 **Hollow geometries**

Design hollow parts with drainage holes for successful printing. During the washing process, the drainage hole allows the solvent to flow inside and clean the internal surfaces. Take care when removing hollow parts from the alcohol bath. Check to ensure that all solvent drains out of the chamber before transferring the part to another surface.

5.3.2 **Internal channels**

Thin channels, such as those used in micro-fluidic designs, may not drain entirely on their own. Use a syringe filled with clean solvent to flush out internal channels. After cleaning, use compressed air to fully drain and dry the channel.

5.3.3 **Large parts**

Parts move around the basket with the circulation of solvent in the wash bucket. Parts that hang outside the basket perimeter may block the cover from closing or not be cleaned properly.

Whether using the build platform or basket as a wash method, the maximum single part size that can be washed in the Form Studio Wash+Cure is 20.0 × 12.5 × 22.5 cm (7.87 × 4.92 × 9.65 in).

5.3.4 **Concave surfaces, printed and washed on the build platform**

Hollowed parts—such as hollowed dental models—printed directly on the build platform can trap resin inside during the wash cycle, when they are still attached to the build platform. Consider washing these parts in the Form Studio Wash+Cure basket or adding a second wash cycle after removing them from the build platform to remove uncured resin that is not removed when washing on the build platform alone.

5.3.5 **Solvent overflow**

The solvent in the Form Studio Wash+Cure can overflow when washing parts that are larger than 1.6 L of enclosed volume with a build platform or 2.6 L of enclosure volume without a build platform. Consider how much solvent a printed part will displace before washing in the Form Studio Wash+Cure. Remove some solvent from the wash bucket before washing a large print.

5.4 **Post-curing printed parts**

Many resin types require post-curing to achieve their optimal mechanical properties. The Form Studio Wash+Cure helps ensure consistent post-curing by rotating printed parts

during the post-cure cycle and exposing the part to light from all directions. For detailed guidance and visual assistance, visit formlabs.com/support.

5.4.1 **Inserting washed and dried printed parts**

Fully dry all solvent off of printed parts after washing. Check all surfaces, because curing non-dried parts may trap solvent inside the part, prevent parts from strengthening, and affect quality.

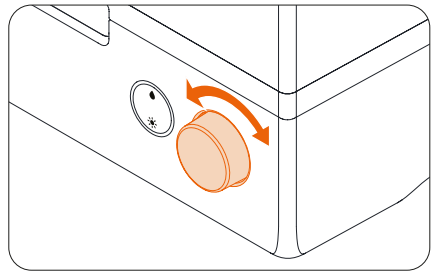
Once parts are dry:

1. Open the cover.
2. If you have not done so already, remove the wash bucket from the machine. The Form Studio Wash+Cure automatically switches to cure mode.
3. Place the turntable on its mount.
4. Distribute parts on the round turntable. Place parts with the most even spacing possible to allow light to reach all areas.
5. Gently close the cover.

5.4.2 **Setting up and starting a post-cure cycle**

To set up and start a post-cure cycle:

1. With the Form Studio Wash+Cure in cure mode, use the knob to select the time for the post-cure cycle.
2. Short press to confirm and start the cycle.



See formlabs.com/support for specific post-cure settings for each resin type.

To pause a post-cure cycle:

1. While a post-cure cycle is in progress, short press the knob to pause. The timer pauses, and the display blinks the remaining time.
2. Short press the knob a second time to continue the post-cure cycle.

To end a post-cure cycle:

1. When the post-cure cycle timer reaches zero, the display blinks the remaining time (00:00) and the machine beeps once.
2. Interact with the machine (turn or press the knob or open the cover) to return to the home screen.

5.4.3 **Additional finishing steps**

Once parts are post-cured, use flush cutters to carefully cut the supports attached to the part(s). Supports can also be removed before post-curing, but parts may warp without structural support.



Some methods of support removal may cause small pieces of supports to break away. Beware of flying debris. Wear eye protection and gloves to protect the skin and eyes.

In addition to removing supports, use sanding, polishing, priming, or painting to improve presentation, or use other equipment to create molds from printed parts.

5.5 Considerations for post-curing specific geometries

For detailed guidance and visual assistance, visit formlabs.com/support.

Consider the specific geometry of each part when starting the cycle. Modify the post-cure process for parts that are large or long, have dense support structures, or have thick or thin features.

5.5.1 Dense supports

Some parts require more dense or thicker support structures. These can inadvertently block light from reaching some part surfaces during post-curing. The Form Studio Wash+Cure helps ensure even post-curing by rotating the part during the cure cycle and exposing the part to light from all directions. Remove some supports, only as needed, to ensure that light can easily reach all part surfaces. Leave some supports in place whenever possible to prevent features from warping during post-curing.

5.5.2 Long and tall parts

The Form Studio Wash+Cure turntable has a diameter of 24.0 cm (9.45 in), and the maximum part height that can be post-cured in the Form Studio Wash+Cure is 22.5 cm (8.9 in). Most parts should be post-cured before removing support structures to preserve their shape and prevent warping. While some parts may fit on the turntable more easily without supports, long or tall prints may require special arrangements to stand on the turntable without support. Consider the part dimensions when designing the support structures or planning the post-cure steps.

5.5.3 Thin features

Warping during post-curing may occur if a part is especially thin, inadequately supported, or unevenly exposed to light. The Form Studio Wash+Cure helps prevent warping by rotating the part during the cure cycle and by exposing the part to light from all directions. Use support settings or manual editing to design sufficient supports so that thin features do not warp during post-curing. In the case of a thin, flat, sheet-like object, placing the part directly on the turntable may offer the best support during post-curing.

5.6 Considerations for post-curing specific geometries

For the best results, use the [recommended time settings](#) tested specifically for use with the Form Studio Wash+Cure.

Each material's print settings are designed and refined to print parts successfully at optimal speeds. Additional post-curing further improves the functional properties of the materials. Post-curing exposes parts to light and strengthens crosslinks in the polymer

structure, improving the parts' strength, stiffness, and temperature resistance. Due to the increased number of bonds the material becomes more tightly packed and will shrink slightly. Each material's print settings are designed to account for the expected shrinkage during printing and post-curing.

Note that, unlike the Form Cure and Form Cure L, the Form Studio Wash+Cure does not include a heater, so not all Formlabs materials can be post-cured in the unit. For example, some high-performance engineering resins, such as Rigid 10K Resin, require extended curing at an elevated temperature, which the Form Studio Wash+Cure cannot provide.

- Standard materials like Alpha Resins are fully cured in 5 minutes with no added heat.
- Some engineering resins, such as Tough 1500 Resin, cure fully in about 30 minutes with no added heat. Note that mechanical properties may not reach those attainable with a Form Cure or Form Cure L.

5.7 Managing the machine

5.7.1 Turning off

Turn off the Form Studio Wash+Cure completely when moving or storing the device and to conserve power. Flip the breaker switch on the back of the unit to the **OFF** position to turn off the machine completely and conserve power. When moving or storing the machine, unplug the unit from its power source in addition to flipping the breaker switch.

5.7.2 Accessing the serial name

The serial name is on the back panel of the machine in the format **FormWashCure-ColorAdjectiveAnimal**.

5.7.3 Extending solvent lifetime

The solvent in the Form Studio Wash+Cure builds up a higher concentration of resin after each wash, as liquid resin from each wash cycle accumulates over time. As the solvent becomes more resin-concentrated, a layer of diluted resin coats the outermost surface of printed parts after washing. As the solvent dries, a thin layer of liquid resin is left behind on the part's surface, causing the surface to feel tacky. Thus, the part is only as clean as the cleaning solution.

When washing parts on the build platform, scrape excess liquid resin back into the resin tank before placing the build platform in the Form Studio Wash+Cure.

To achieve the cleanest parts, replace used solvent with fresh solvent frequently or consider a multi-step washing process. As solvent evaporates, add fresh solvent to keep the fill level between the minimum and maximum lines.

Maintain separate wash buckets for each resin type or similar colors to preserve the best possible surface quality and performance. For example:

- Castable Wax Resin - to avoid color transfer
- Castable Resin - to avoid color transfer

- Rigid Resin - to prevent glass particles adhering to parts printed with other resins
- Ceramic Resin - to prevent ceramic particles adhering to parts printed with other resins

Solvent lifetime depends in part on the chemical properties of the solvent. Visit formlabs.com/support for detailed information about different solvents and solvent performance.

5.7.4

Measuring the resin concentration of solvent

As more parts are cleaned, the solvent gradually becomes more concentrated with liquid resin, reducing the effectiveness of the Form Studio Wash+Cure. Replace solvent when the wash is no longer effective and when parts have tacky surfaces after washing.

TIP: To significantly prolong the lifetime of the solvent before replacement, consider implementing a preliminary rinse with a small volume of solvent before inserting printed parts into the Form Studio Wash+Cure.

Use a calibrated hydrometer to check the solvent's resin concentration between cleaning cycles and help determine when to replace the solvent. Note that different solvents may require different hydrometers. For example, TPM requires a hydrometer that can measure a specific gravity of 0.9–1.2, and a specific gravity greater than 1.0 indicates that the TPM will not be fully effective as a final wash. Formlabs Resin Washing Solution requires a hydrometer that can measure a specific gravity of 0.9–1.0. The specific gravity of fresh Formlabs Resin Washing Solution is 0.94. When the specific gravity of the used Resin Washing Solution is above 0.975, it will not be fully effective as a final wash.

6. MAINTENANCE

To maintain the most efficient and long-lasting machine, ensure regular conservation. Formlabs provides instructions to advise in installing, operating, and maintaining the machine. The Form Studio Wash+Cure shall only be maintained by a qualified and trained person. Unauthorized disassembly or repair procedures may damage the machine.

There are two groups of maintenance procedures: regular, which should be done after every use, and intermittent maintenance, which only needs to be done occasionally. Please keep a log detailing when each intermittent maintenance procedure was last performed.

For detailed guidance and visual assistance, visit formlabs.com/support.



Tampering with or disassembling the device prior to disconnecting the power cable and waiting at least five minutes can subject users to potentially fatal electrical hazards. When removing the exterior paneling, disconnect the machine from its power source before maintenance.



Wear personal protective equipment (PPE) when performing maintenance tasks. Use tools only as described.



- Do not open the Form Studio Wash+Cure and/or investigate internal components unless under the guidance of Formlabs Support or a certified service provider. Contact [Formlabs Support](#) or a [certified service provider](#) for any additional guidance.
- Unauthorized disassembly or repair procedures may damage the machine and void the warranty.

6.1 Tools and supplies

- **General purpose cleaner (e.g., glass cleaner) and/or soapy water:** For cleaning the outer shells and display.
- **Isopropyl alcohol (IPA), 90% or higher:** For cleaning the work surface and tools.
- **Low-fiber paper towels:** For cleaning the work surface and tools and for wiping residue grease, resin, or solvent.
- **Non-abrasive microfiber cloth:** For cleaning the outer shells and display.

6.2 Inspection and maintenance

6.2.1 Before each use

Inspect	Refer to	Section
Installation environment	Location and environment	4.1
Turntable	Maintaining the turntable	6.3.1

Inspect	Refer to	Section
Parts to be post-cured	Considerations for post-curing specific geometries	5.5
	Drying parts and keeping equipment clean	6.3.2

6.2.2 Periodic maintenance

Inspect	Refer to	Section
Interior surfaces	Maintaining interior surfaces	6.4.1
Light diffusers	Maintaining the light diffusers	6.4.2
Cover	Maintaining the cover	6.4.3
Display and knob	Maintaining the display	6.4.4

6.3 Tasks between uses

Over time, debris or contaminants may collect in the Form Studio Wash+Cure or on its internal surfaces, particularly if printed parts are not fully dried before post-curing. In order to preserve the reliability of the Form Studio Wash+Cure, it is important to regularly inspect and clean its various components and assemblies.

6.3.1 Maintaining the turntable

The Form Studio Wash+Cure relies on the turntable's rotation to expose part surfaces to even amounts of light and heat. The turntable must have sufficient clearance to continue rotating.

To maintain the turntable:

- Periodically lift the turntable to inspect underneath it for small pieces of cured resin. Remove particles of cured resin from above and below the turntable to ensure the turntable can rotate without interruption.
- Clean the turntable and the surface underneath as needed.
- Use isopropyl alcohol to clean the turntable or the base if necessary, and allow isopropyl alcohol to fully evaporate before starting a post-cure cycle.

6.3.2 Drying parts and keeping equipment clean

Completely wash and dry all parts before post-curing in the Form Studio Wash+Cure. Do not operate the Form Studio Wash+Cure with uncured resin, partially cured resin, or other liquids on the turntable.

6.4 Periodic maintenance

The Form Studio Wash+Cure requires regular maintenance and care. The standard cycle for the following procedures is every one to three months of use.

6.4.1 Maintaining interior surfaces

Visually inspect the internal surfaces of the Form Studio Wash+Cure for traces of resin, cracks, or other damage.

Resin will harden during post-curing. Cured resin blocks light and must be removed. If parts are washed but not fully dry before post-curing, certain washing solvents, such as tripropylene monomethyl ether, may evaporate and form deposits on the interior surfaces of the Form Studio Wash+Cure. Clean surfaces as needed with isopropyl alcohol and allow the solvent to fully evaporate before starting a post-cure cycle.

6.4.2 **Maintaining the light diffusers**

The 405 nm LEDs in the Form Studio Wash+Cure are covered by frosted light diffusing panels. These light diffusers spread the light from the LEDs and ensure that parts post-cure evenly. If the light diffusers are damaged or covered, parts may not post-cure properly. Visually inspect the light diffusers for traces of resin, cracks, or other damage. Resin will harden during the post-curing.

Cured resin blocks light and must be removed. If parts are washed but not fully dry before post-curing, certain part washing solvents, such as tripropylene monomethyl ether, may evaporate and form deposits on the interior surfaces of the Form Studio Wash+Cure.

These deposits will coat the light diffusers and prevent parts from post-curing properly. Clean the light diffusers as needed. Use isopropyl alcohol to clean the light diffusers and allow isopropyl alcohol to fully evaporate before starting a post-cure cycle.

6.4.3 **Maintaining the cover**

Visually inspect the door for traces of resin, cracks, or other damage. Clean the cover with a non-abrasive microfiber cloth and soapy water or a general purpose cleaner, such as glass cleaner.

6.4.4 **Maintaining the display**

Visually inspect the display and knob for any traces of resin. Check that the knob turns easily and that the display responds to inputs. Clean the display with a non-abrasive microfiber cloth and general purpose cleaner, such as glass cleaner.

7. TROUBLESHOOTING AND REPAIR

For detailed guidance and visual assistance, search on formlabs.com/support.

7.1 Power cycle the machine

If the display freezes during or after the firmware update, power cycle the Form Studio Wash+Cure unit:

1. Unplug the unit.
2. Wait at least 10 seconds to ensure a complete power cycle.
3. Reconnect the power cable to restart the unit.

7.2 Troubleshooting

In the case of an error or abnormal activity with the Form Studio Wash+Cure, reference the following errors, causes, and proposed solutions. Complete the initial troubleshooting steps and carefully document all results. Contact [Formlabs Support](#) or a [certified service provider](#) for additional guidance.

Error	Cause	Solution
Cannot start a wash cycle	Wash bucket is not inserted.	• Place the wash bucket on the Form Studio Wash+Cure base. • Check that the wash bucket is seated properly on the Form Studio Wash+Cure base. • Check that the mode button indicates that wash mode is active.
Cannot start a post-cure cycle	Cover is open.	• Close the cover. • Check that the mode button indicates that cure mode is active.
The display does not turn on	Power failure or a faulty electrical connection.	• Disconnect and reconnect the power. • Replace the power supply.
The 405 nm LEDs do not turn on	Power failure or a faulty electrical connection.	• Disconnect and reconnect the power. • Replace the power supply.
Some of the 405 nm LEDs turn on when the cover is opened	• Water damage to the LED module(s). • Electrical damage to the LED modules.	• Leave the Form Studio Wash+Cure with the door open in a ventilated area preferably with a fan blowing into the chamber for 12 hours. • If problems persist, consider replacing LED modules. See 7.3 Disassembly and repair.

Error	Cause	Solution
The turntable does not turn	• Turntable is obstructed. • Turntable is not fully seated. • Faulty or damaged motor assembly.	• Ensure that no cured resin or printed parts are blocking the turntable. Reorient large prints as necessary. • Reseat the turntable on its mount. See 5.4.1 Inserting washed and dried printed parts. • Replace the Form Studio Wash+Cure motor assembly. See 7.3 Disassembly and repair.
Parts are undercured or do not have desired mechanical properties	• Expired resin. • Part was washed but not fully dried before post-curing. • Dirty turntable.	• Check the expected lifetime of the resin used for the print. • Fully dry all solvent off of parts before post-curing. • Clean the turntable.
Post-cured parts have tacky or sticky surfaces	• Part was not washed before post-curing. • Part was washed but not fully dried before post-curing.	• Wash liquid resin off of printed parts before post-curing. • Fully dry all solvent off of parts before post-curing.
Display blinks OPEN error message	• Cover was opened during post-cure cycle • Cover not seated properly during post-cure cycle	Place and properly seat the cover on the Form Studio Wash+Cure.
Display blinks LOST error message	• Wash bucket was removed during wash cycle. • Wash bucket not seated properly during wash cycle.	Place and properly seat the wash bucket on the Form Studio Wash+Cure.
Display blinks STAL error message	• Impeller motor has stalled. • Incorrect impeller speed selected for current wash solvent.	Change impeller speeds and restart the wash cycle.

7.3 Disassembly and repair

Contact [Formlabs Support](#) or a [certified service provider](#) to receive repair instructions and authorization, including how to disassemble or remove the exterior paneling.

Task	Frequency
Replacing the motor assembly	The turntable has stopped functioning or behaves erratically.
Replacing the LED modules	The LED lights have stopped functioning or behave erratically.
Replacing the display	The display or knob is unresponsive.

8. DISPOSAL

8.1 Guidance for recycling and disposal

8.1.1 Disposal of electronic components



The symbol on the product, accessories, or packaging indicates that this device must not be treated as nor disposed of with household waste. When you decide to dispose of this product, do so in accordance with local environmental laws and guidelines. Dispose of the device via a collection point for the recycling of waste electrical and electronic equipment. By disposing of the device in the proper manner, you help to avoid possible hazards for the environment and public health that could otherwise be caused by improper treatment of waste equipment. The recycling of materials contributes to the conservation of natural resources. Therefore do not dispose of your old electrical and electronic equipment with the unsorted municipal waste.

8.1.2 Disposal of packaging waste

Keep the packaging for transporting your Form Studio Wash+Cure. Form Studio Wash+Cure packaging materials are designed to be kept and reused for transportation or shipping.

The packaging is made of cardboard and plastic-based materials. Dispose of packaging through your local waste and recycling facilities. By disposing of the packaging waste in the proper manner, you help to avoid possible hazards for the environment and public health.

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10. GLOSSARY

Term	Meaning
Cover	The orange cover protects against UV exposure and helps prevent solvent evaporation.
Display	The display shows cycle time and error messages.
Interlocks	The Form Studio Wash+Cure has interlocks to ensure the machine is safe for use: • If the wash bucket is not inserted, a wash cycle cannot be started. • If the cover is open, a post-cure cycle cannot be started.
Knob	The knob is the primary interface device for the Form Studio Wash+Cure. Turn the knob to navigate the display menu. Press the knob to select a feature or setting.
LEDs	Two arrays with a total of 24 405 nm LEDs help to post-cure parts.
Mode button	Shows which mode is active (wash or cure). Press to manually change the mode.
Motherboard	The motherboard is the main circuitry through which all systems in the Form Studio Wash+Cure communicate.
Motor assembly	The motor assembly rotates the turntable during the post-cure cycle.
Power cable	Provides power to the Form Studio Wash+Cure.
Turntable	A rotating plate ensures balanced post-curing across all exposed part surfaces. The turntable is made of plastic.