

## INSTRUCTIONS FOR ADDING SOMOS FD-STABILIZER TO VATS

These instructions are for adding the stabilizer, FD (Stabilizer for Somos Photopolymer Families) to your Somos resin in a Stereolithography Machine. ***Please note that everyone should wear eye protection and other personal protective clothing when handling stereolithography liquids.***

1. Check the vat to see if there are parts from build crashes at the bottom. If so remove them and any jelly (very thick resin) at the bottom of the vat.
2. Place the unopened stabilizer in the build chamber and allow it to warm up to temperature (10 minutes approx.). This will minimize the hydroscopic affect which will maximize the acid absorption.
3. Lower the vat 1/2", remove the platform from the vat, and lower the elevator arms 10" (250mm).
4. Uncap the bottle of stabilizer and disperse 1/2 the contents evenly onto the surface of the resin. A salt shaker works good at even dispersion as long as it has been warmed as well. Wait 10 minutes. Move the recoater to the back of the vat and disperse the other half of the stabilizer. Try to get as close to the vat sides as you can.
5. Allow the stabiliser to settle for 30 minutes.
6. Stir the vat contents with a paint paddle or spatula briefly if there is any stabilizer on the top surface of the resin.
7. Raise the elevator arms to the top and scrape off any stabilizer on the top surfaces allowing it to drop back into the vat.
8. The vat should now be ready to build parts.
9. Refill resin should only be added to the sides of the vat never the middle.
10. If there are any questions, please contact: