



Staff: Nexa3D XiP Intro

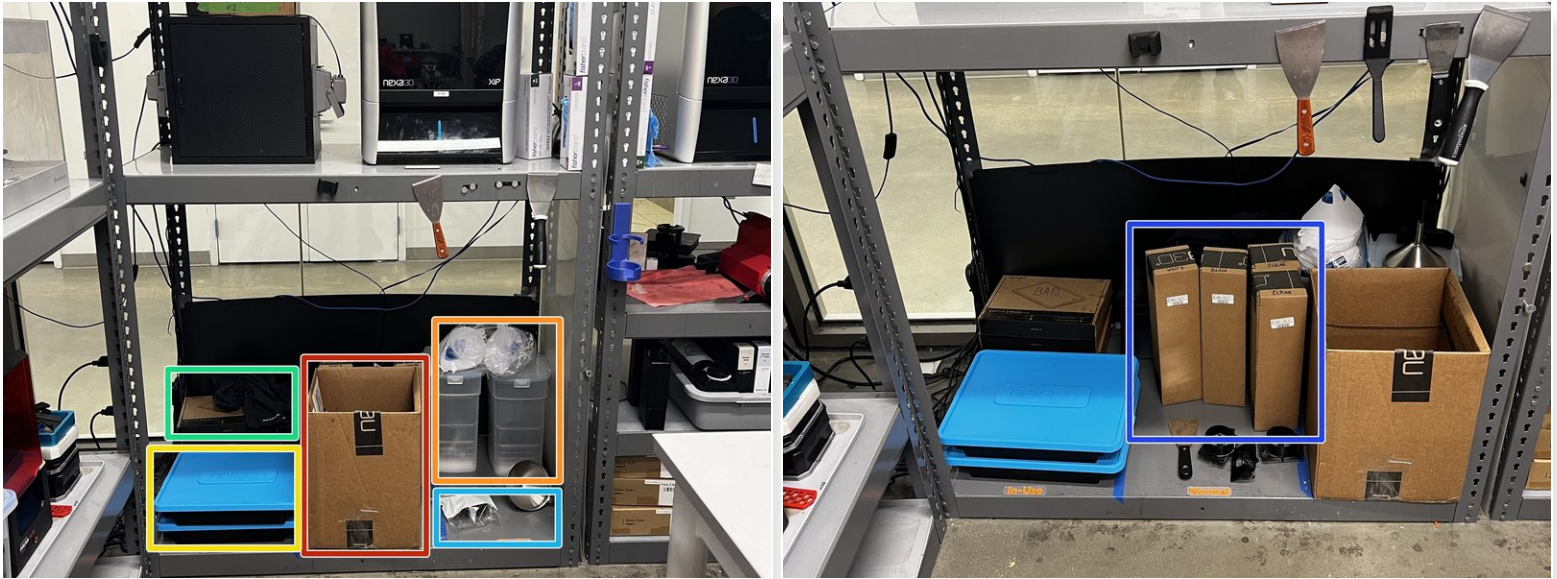
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Introduction

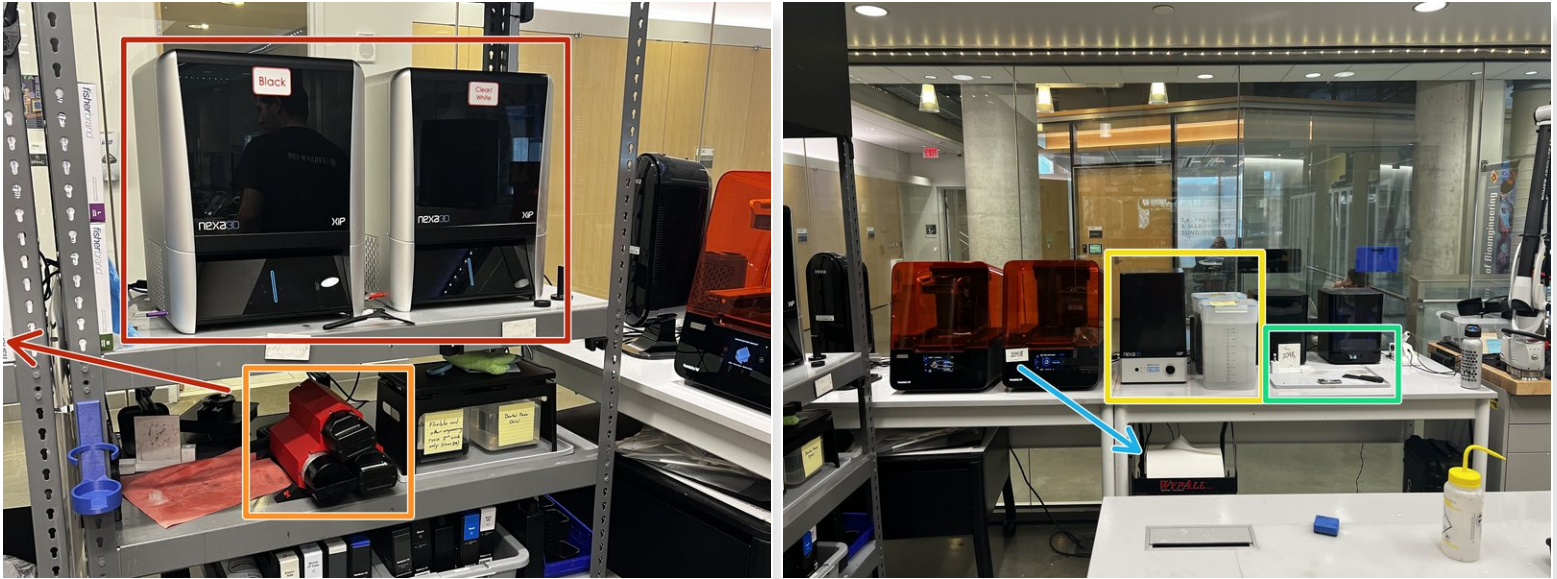
The XiP is an affordable desktop stereolithography printer, delivering high-resolution parts in a variety of consumer materials at incredibly fast printing speeds.

Step 1 — Location of Relevant Items



- ❶ The Nexa3D XiP canisters can be refilled.
- Empty resin canisters are stored in a cardboard box.
- Cleaning and post-processing supplies are stored in clear containers.
- Storage boxes for the resin tanks are located next to the empty canisters box.
- New/used membrane storage is behind the resin tank boxes.
- New/used resin spouts are stored in front of the clear containers.
- New resin canisters are also stored in this area.

Step 2 — Location of Relevant Items II



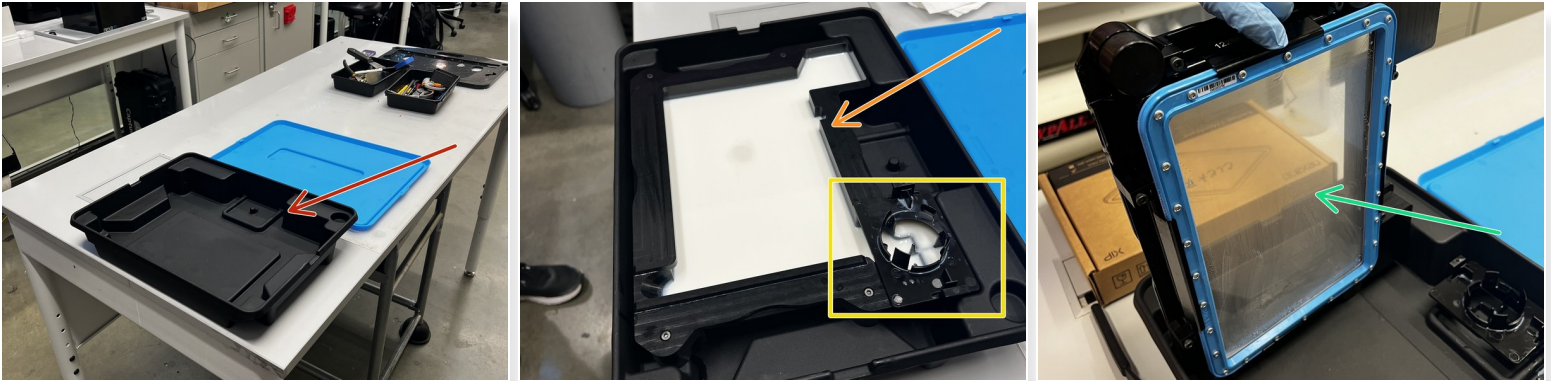
- Three Nexa3D XiPs are on the top shelf next to the Markforge printers.
 - In-use resin cartridges are stored in the cartridge honeycomb below the machines.
 - The Nexa3D Wash+Cure is on the table next to the Form 3+'s.
 - The resin post-processing area is next to the Wash+Cure.
 - Paper towels are below the Wash+Cure station.
- ⚠ Always make sure the cap is secured on the cartridge before storing in the cartridge honeycomb!

Step 3 — A Note: Materials



- ⚠ All Nexa3D materials are toxic and you should wear nitrile gloves at all times when handling any Nexa3D related parts.
- ⚠ Due to their toxicity we are NOT allowed to dispose of uncured resin in the garbage or down any drain, therefore we must cure all resin before disposal using UV light.
- The XiP machines are labeled by material.
- The XiP on the right is for clear and white resin.
- The XiP in the middle is for black resin.
- The XiP on the left is a floater machine for all other resins.

Step 4 — The Resin Tank



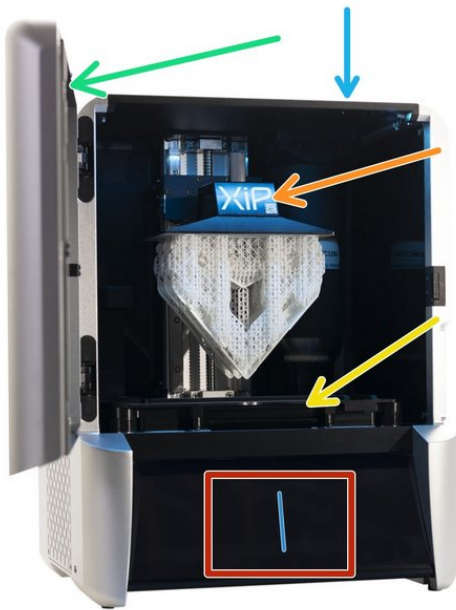
- The resin tanks must always be stored in one of the resin tank storage boxes. This helps keep the membrane intact.
- The resin tank is made from billet aluminum.
- A plastic spout is clipped onto the tank to help resin flow out of the cartridge in the machine.
- The membrane is located on the bottom of the tank. UV light passes through the membrane to cure the resin.
- ⚠ **Never touch the clear film on the membrane with anything. This will affect the machine's ability to cure the resin. Always hold the membrane from the blue frame.**
- Most of the time, the resin tanks will be stored in the machine.

Step 5 — Resin Cartridge



- There are two kinds of resin cartridges.
 - The metal 1kg canister is the older style, and it uses a special spout.
 - The plastic 1.5kg canisters are more commonly used. The 1.5kg canisters also use a specific spout.
 - Both kinds of canisters can be stored in the canister honeycomb.
- ⚠ Make sure the spout you are installing on the resin tank matches the canister you are inserting. Otherwise, resin will not flow into the tank properly.

Step 6 — Parts of the Machine



- The touch screen interface is located on the front of the machine.
- The Build Plate sits upside down on the z-axis arm.
- The door protects the resin from UV light which will solidify it if exposed for too long.
- ⚠ Do NOT leave the door open for extended periods of time - UV light cures the resin.
- The tank is secured below the build plate by electromagnets.
- The Resin Cartridge is lowered into the back of machine from the top.