



3D Printer Settings

[Ackuretta Sol](#)
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[Asiga Max UV / 2*](#)
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[Shining 3D L4K](#)

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- ** [Formlabs Form 4B Printer Settings](#)

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01
MASTER
MODEL

01
CLASSIC
MODEL

01
BASIC
MODEL

03
DENTAL
CAST



Software | Alpha AI

Model Classic				
Layer Thickness	50 µm	Scaling ratio	x	1,00692
Illumination	2,2 s		y	1,00503
			z	1,01762
Layer Thickness	100 µm			
Illumination	3,0 s			
Model Basic				
Layer Thickness	50 µm	Scaling ratio	x	1,00442
Illumination	2,0 s		y	1,00533
			z	1,01391
Layer Thickness	100 µm			
Illumination	3,0 s			
Dental Cast				
Layer Thickness	50 µm	Scaling ratio	x	1,01294
Illumination	1,6 s		y	1,01421
			z	1,00182
Layer Thickness	100 µm			
Illumination	1,9 s			





Software | Chitubox (Download Profile)

Model Master / Classic / Basic	
Layer Thickness	50 µm
Exposure Time	3,2 s
Bottom Exposure Time	25 s
Lift-Speed	60 mm/min
Retract Speed	120 mm/min
Dental Cast	
Layer Thickness	50 µm
Exposure Time	3 s
Bottom Exposure Time	30 s
Lift-Speed	60 mm/min
Retract Speed	120 mm/min





Software | Chitubox (Download Profile)

Model Master / Classic / Basic	
Layer Thickness	50 µm
Exposure Time	5,5 s
Bottom Exposure Time	40 s
Lift-Speed	60 mm/min
Retract Speed	120 mm/min
Dental Cast	
Layer Thickness	50 µm
Exposure Time	4,5 s
Bottom Exposure Time	40 s
Lift-Speed	60 mm/min
Retract Speed	120 mm/min





Software | Chitubox (Download Profile)

Model Classic / Basic

Layer Thickness	50 µm
Exposure Time	4,5 s
Bottom Exposure Time	35 s
Lift-Speed	60 mm/min
Retract Speed	120 mm/min



Model Classic / Basic

Layer Thickness	100 µm
Exposure Time	6,7 s
Bottom Exposure Time	50 s
Lift-Speed	45 mm/min
Retract Speed	120 mm/min



Dental Cast

Layer Thickness	50 µm
Exposure Time	5 s
Bottom Exposure Time	40 s
Lift-Speed	45 mm/min
Retract Speed	120 mm/min





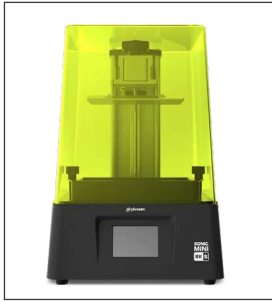
Phrozen Sonic Mini 4K



Software | Chitubox (Download Profile)

Model Master / Classic / Basic	
Layer Thickness	50 µm
Exposure Time	5,5 s
Bottom Exposure Time	40 s
Lift-Speed	60 mm/min
Retract Speed	120 mm/min
Dental Cast	
Layer Thickness	50 µm
Exposure Time	6 s
Bottom Exposure Time	40 s
Lift-Speed	60 mm/min
Retract Speed	120 mm/min





Software | Chitubox (Download Profile)

Model Master / Classic / Basic	
Layer Thickness	50 µm
Exposure Time	4,5 s
Bottom Exposure Time	40 s
Lift-Speed	60 mm/min
Retract Speed	120 mm/min
Dental Cast	
Layer Thickness	50 µm
Exposure Time	5 s
Bottom Exposure Time	40 s
Lift-Speed	60 mm/min
Retract Speed	120 mm/min





Software | Accuware

Model Master / Classic / Basic	
Layer Thickness Select [shining 3D] DM03-0,05µm and change following values	50 µm
Fill Exposure Time	4 s
Boundary Exposure Time	4 s
Slow return speed	72 mm/min
Layer Thickness Select [shining 3D] DM03-0,1µm and change following values	100 µm
Fill Exposure Time	5,1 s
Boundary Exposure Time	5,1 s
Slow return speed	72 mm/min
Dental Cast	
Layer Thickness Select [shining 3D] DC12-0,05µm and change following values	50 µm
Fill Exposure Time	4,7 s
Boundary Exposure Time	4,7 s
Slow return speed	90 mm/min

