



3D Printer Settings | Druckereinstellungen

NICHT-MEDIZINPRODUKTE



MEDIZINPRODUKTE



01
MASTER
MODEL



01
CLASSIC
MODEL



01
BASIC
MODEL



03
DENTAL
CAST



04
CUSTOM
TRAY



05
SURGICAL
GUIDE



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NICHT-MEDIZINPRODUKTE



Unsere Harze sind für folgende 3D-Drucker validiert:

[Ackuretta Sol](#)
[Anycubic Photon Mono 4k](#)
[Asiga Max UV / 2*](#)
[Asiga Pro 4k*](#)
[Asiga Ultra*](#)
[Elegoo Saturn 2](#)

[Elegoo Saturn 3](#)
[Formlabs Form 4B**](#)
[Phrozen Sonic Mini 4K](#)
[Phrozen Sonic Mini 8K](#)
[Shining 3D L4K](#)

* Asiga 3D Printer Settings



** Formlabs Form 4B Printer Settings





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Asiga Max UV / 2*
Asiga Pro 4k*
Asiga Ultra*

* Asiga 3D Printer Settings





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				

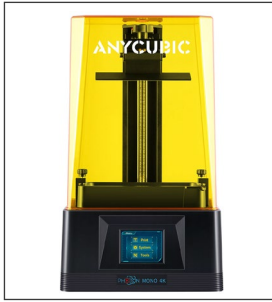


Model Basic					
Layer Thickness	50 µm	Scaling ratio	x	1,00442	
Illumination	2,0 s		y	1,00533	
			z	1,01391	
Layer Thickness	100 µm				
Illumination	3,0 s				



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

