

RESIN TIME SETTING

PROJECTOR SET	FIRST INITIAL LAYER (sec)	NUMBER OF INITIAL LAYER	CURING TIME (sec)	Z LAYER THICKNESS	OBJECT'S SIZE / WEIGHT / HEIGHT TYPE	DESIGN TYPE
175 µm	60	3	7	120 / 60 / 30	Medium / Small	Solid / Hollow
	80	3	7.5	120 / 60 / 30	Heavy	Solid / Hollow
	60	3	7	7.5	Light	Solid
	60	3	7.5	7.5	Large Area	Solid / Hollow
150 µm	60	3	7	120 / 60 / 30	Medium / Small	Solid / Hollow
	80	3	7.5	120 / 60 / 30	Heavy	Solid / Hollow
	60	3	7	7.5	Light	Solid
	60	3	7.5	7.5	Large Area	Solid / Hollow
125 µm	50	3	3.5	60 / 120 / 30	Over all sizes	Solid / Hollow
	50	3	3	37.5	Medium Heavy	Solid / Hollow
	50	3	2.5	7.5	Medium	Solid / Hollow
	30	3	2	7.5	Light	Hollow
100 µm	30	3	2-2.5		Medium Heavy	Solid / Hollow
	30	3	2		Medium Heavy	Solid / Hollow
	30	3	1.5		Light	Solid / Hollow

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175 µm	30	3	5.5			
150 µm	30	3	5.5			
125 µm	30	3	2.5			
100 µm	30	3	1.5-2.5			

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175 µm

60

3

7

150 µm

125 µm

100 µm

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175 µm	50	3	6			
150 µm						
125 µm						
100 µm						

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175 µm	60	3	7			
150 µm						
125 µm						
100 µm						

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175 µm	60	3	7			
150 µm						
125 µm						
100 µm						

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PROJECTOR SET	FIRST INITIAL LAYER (sec)	NUMBER OF INITIAL LAYER	CURING TIME (sec)	Z LAYER THICKNESS	OBJECT'S SIZE / WEIGHT / HEIGHT TYPE	DESIGN TYPE
175 µm	70	3	7			
150 µm						
125 µm						
100 µm						