



3D PRINTER SETTINGS

Asiga Max UV 385 Ackuretta Sol Shining 3D L4K Phrozen Sonic Mini 4K Phrozen Sonic Mini 8K Phrozen Sonic Mighty 4K Anycubic Photon Mono 4K Elegoo Saturn 2 8K

		Origin Date	22 Jan 2024
Printer Sett	Printer Settings Index	Revision Date	09 Feb 2024
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Sr.	Printer Models	Model	Model Std	Model Basic	Model	Dental Cast	Cast-L	C&B/C&B	Surgical Guide
NO	WOUCIS		Puckers	- Contraction of the second se		Cast		Co	Culde
1	A	\checkmark	\checkmark	\checkmark	X	\checkmark	X	✓	✓
	Asiga Max UV 385	50 to 150	50 to 150	50 to 150	NA	50 to 150	NA	50 to 150	50 to 150
2	•	X	\checkmark	\checkmark	X	\checkmark	X	~	\checkmark
	Ackuretta SOL	NA	50 to 150	50 to 150	NA	50 to 150	NA	70 to 150 C&B	50 to 150
3		\checkmark	\checkmark	\checkmark	X	\checkmark	\checkmark	\checkmark	\checkmark
	Shining 3D L4K	50 to 100	50 to 100	50 to 100	NA	50	50	50 C&B	50
4		\checkmark	\checkmark	X	\checkmark	✓	\checkmark	✓	√
	Phrozen Sonic Mini 4K	50	50	NA	50	50	50	50 C&B	50
5		\checkmark	\checkmark	\checkmark	\checkmark	\checkmark	\checkmark	\checkmark	\checkmark
	Phrozen Sonic Mini 8K	50	50	50	50	50	50	50 C&B	50
6		X	X	\checkmark	X	X	\checkmark	X	\checkmark
	Phrozen Sonic Mighty 4K	NA	NA	50 to 100	NA	NA	50 to 100	NA	50
7		~	\checkmark	✓	\checkmark	✓	\checkmark	✓	√
	Anycubic Photon Mono 4K	50	50	50	50	50	50	50 C&B	50
8		X	\checkmark	\checkmark	X	X	\checkmark	X	X
	Elegoo Saturn2 8K	NA	50	50	NA	NA	50	NA	NA

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Slicing Software – Composer V 2.0

- D Tech resins are already validated on Asiga printer
- You can download the "ini" file from Official Asiga website "https://www.asiga.com/
- Please follow the steps as below to access the open-material files from the library.



D Tech Dental Technologies www.dtechasia.com

Printer Settings Asiga

Od-techContentPrinter sAsiga Ma	Printer settings		Origin Date	22 Jan 2024
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- Download the ini file to your computer
- Import them in Asiga composer software (check for latest version of software)

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Slicing Software – Alpha Al V5.1.1

- D Tech resins are already validated in Ackuretta Software (Alpha Al version V5.1.1)
- Please check that your software is updated to the latest version.
- Then simply Select Printer (Ackuretta SOL), Brand (D Tech) & relevant resin from the Drop-down menu as shown below.

Crown & Bridge-

Parameter Editor

O Printer	O Brand		Resin	Layer
FreeShape 120 - No	v 2018 💿 Strauma	nn	⊙ C&B	Fine
FreeShape 120 - Feb	0 2019 💿 Trusana		O Dental Cast	Standard
FreeShape 120 - Ma	y 2019 💿 VOCO		Model Basic	Fast
O DENTIQ	WhipMix		Model Standard	
SOL Large L BP	💿 уамана	CHI	Surgical guide	
SOL Medium M BP	O YLLER_d	igital		
SOL Small S BP	⊘ d-tech			
Name Fine		Ð	C Import	Export
Layer Thickness	0.07 mm	Scaling Ratio	X 1.00965	
Illumination	1.70 s		Y 1.00842	
Adjustment	0.0 s		Z 1.00670	
Base Adjustment	0.0 s			

Apply

)

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* Model Standard-

Parameter Editor

O Printer	Brand	Resin	Layer
FreeShape 120 - Nov 2018	Straumann		Finest
FreeShape 120 - Feb 2019	Trusana	O Dental Cast	Fine
FreeShape 120 - May 2019	⊚ voco	Model Basic	Standard
O DENTIQ	WhipMix	O Model Standard	Fast
SOL Large L BP	УАМАНАСНІ	Surgical guide	
SOL Medium M BP	O YLLER_digital		
SOL Small S BP			
Name Fine		⊕ ⊖ ◘ Import Expor	t
Layer Thickness	0.07 mm	Scaling Ratio X 1.00692	
Illumination	2.60 s	Y 1.00503	
Adjustment	0.0 s	Z 1.01762	
Base Adjustment	0.0 s		

Apply

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* Model Basic-

Parameter Editor

O Printer	O Brand	Resin	Layer
FreeShape 120 - Nov 20	018 💿 Straumann	© C&B	Finest
FreeShape 120 - Feb 20	119 💿 Trusana	O Dental Cast	Fine
FreeShape 120 - May 2	019 💿 VOCO	Model Basic	Standard
O DENTIQ	WhipMix	Model Standard	Fast
SOL Large L BP	• УАМАНАСНІ	Surgical guide	
SOL Medium M BP	YLLER_digital		
◎ SOL Small S BP	⊚ d-tech		
Name Fine		⊕ ⊡ Import Exp	ort
Layer Thickness	0.07 mm	Scaling Ratio X 1.00442	
Illumination	2.10 s	Y 1.00533	
Adjustment	0.0 s	Z 1.01391	
Base Adjustment	0.0 s		

Apply

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Dental Cast-

Parameter Editor

O Printer	O Brand	Resin	Layer
FreeShape 120 - Nov 2018	Straumann	© C&B	Finest
FreeShape 120 - Feb 2019	Trusana	 Dental Cast 	Fine
FreeShape 120 - May 2019	⊚ voco	Model Basic	Standard
O DENTIQ	WhipMix	Model Standard	Fast
SOL Large L BP	УАМАНАСНІ	Surgical guide	
SOL Medium M BP	YLLER_digital		
SOL Small S BP			
Name Fine			xport
Layer Thickness	0.07 mm	Scaling Ratio X 1.01294	
Illumination	1.80 s	Y 1.01421	
Adjustment	0.0 s	Z 1.00182	
Base Adjustment	0.0 s		

Apply

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♦ Surgical Guide-

Parameter Editor

O Printer	O Brand	Resin	Layer
FreeShape 120 - Nov 2018	Straumann	© C&B	Finest
FreeShape 120 - Feb 2019	Trusana	 Dental Cast 	Fine
FreeShape 120 - May 2019	voco	Model Basic	Standard
DENTIQ	WhipMix	Model Standard	Fast
SOL Large L BP	УАМАНАСНІ	Surgical guide	
SOL Medium M BP	O YLLER_digital		
SOL Small S BP	o d-tech		
Name Fine		⊕ ⊖ ◘ Import Export	
Layer Thickness 0.6)7 mm Scali	ing Ratio X 1.00634	
Illumination 1.5	90 s	Y 1.00618	
Adjustment 0	.0 s	Z 1.01496	
Base Adjustment 0	.0 s		

Note – *In case your printer is old, it is possible that the light intensity may have reduced.*

If you experience failures, then layer curing time can be increased by 10 to 15% over the normal curingtime. For example, if the 50micron layer curing time is 2.2 secs, please increase to 2.4 or 2.5 secs.

Apply

	Printer s	settings	Origin Date	22 Jan 2024
<mark> </mark>	Shining	g 3D [˘] L4K	Revision Date	09 Feb 2024
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Slicing Software - Accuware V 3.1.8.35

inter Series						
uccuFab-L4K 💌	Laver Counts	5	▲ 27	,	0	
inter Serial No.	Exposure Level:	High Power Mode	High Power	Mode V	Mid Power Mod	e 1
•K1AP310-GJBB048F21 🔻	Fill Exposure Time (s):	11.00	\$ 5.00	\$	(4.00)	-
iterial Brand	Boundary Exposure Time (s):	5.00	\$ 3.00	\$	(4.00)	;
nining3D 💌	Support Exposure Time (s):	11.00	\$ 5.00	\$	4.20	;
aterial Name	Wait Time on Top (s):	0.50	\$ 0.50	\$	0.00	
hining3DIDM03=0.05	Wait Time before Exposure (s):	4.50	\$ 4.00	\$	3.00	
	Wait Time after Exposure (s):	0.00	\$ 0.00	\$	0.00	
pport Name	Slow Lift Length on z-axis (mm):	1.5	\$ 1.5	\$	1.0	
ie support 🔻	Slow Lift Speed on z-axis (mm/min):	30	\$ 60	\$	80	
	Quick Lift Length on z-axis (mm):	7.0	₹ 7.0	\$	7.0	
	Quick Lift Speed on z-axis (mm/min):	220	\$ 220	\$	330	
	Slow Return Length on z-axis (mm):	1.5	\$ 1.5	\$	1.0	
	Slow Return Speed on z-axis (mm/min):	72	◆ 72	\$	72	
	Quick Return Length on z-axis (mm):	7.0	₹ 7.0	\$	7.0	
	Quick Return Speed on z-axis (mm/min):	220	\$ 220	\$	330	
	Print Base Time (s):	20.00	\$ 15.00	\$	11.60	

Note- Please select [Shining 3D]DM03-0.05µm profile. Don't use as it is please change in general layer setting-

- 1. Fill exposure time change from 3.6 to 4
- 2. Boundary exposure time from 3.6 to 4
- 3. Slow return speed on Z-axis from **90** to **72**

Material Manager

	Printer s	settings	Origin Date	22 Jan 2024
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	Printer	Material	Support						
Printer Series				Enhanced La	ayer	Medium Lay	er	General Lay	er
AccuFab-L4K 💌	Laver Co	unts:		5	.▲	27		0	4
Printer Serial No.	Exposure	a Lovel:		High Power N	V Andra	High Power	Vada V	High Power N	Mode
L4K1AP310-GJBB048F21 🔹	Fill Expo	sure Time (s):		18 40		9 20		(510)	Houe +
laterial Brand	Boundar	ry Exposure Time	(s):	4.60	÷	4.60	÷	5.10	
5hining3D 🔹	Support	Exposure Time (s	5):	11.00	\$	5.00	\$	4.20	4
laterial Name	Wait Tim	ne on Top (s):		0.50	\$	0.50	\$	0.00	(
[Shining3D]DM03-0.1	Wait Tim	ne before Exposu	re (s):	4.50	\$	4.00	\$	3.00	(
upport Name	Wait Tim	ne after Exposure	(s):	0.00	\$	0.00	\$	0.00	;
die support	Slow Lift	t Length on z-axi	s (mm):	1.5	\$	1.5	\$	1.0	;
	Slow Lift	t Speed on z-axis	(mm/min):	30	\$	60	\$	80	;
	Quick Lif	ft Length on z-ax	is (mm):	7.0	\$	7.0	\$	7.0	;
	Quick Lif	ft Speed on z-axi	s (mm/min):	220	\$	220	\$	330	:
	Slow Ret	turn Length on z-	-axis (mm):	1.5	\$	1.5	\$	1.0	;
	Slow Ret	turn Speed on z-a	axis (mm/min):	72	\$	72	\$	72	;
	Quick Re	eturn Length on z	-axis (mm):	7.0	\$	7.0	\$	7.0	;
	Quick Re	eturn Speed on z-	axis (mm/min):	220	\$	220	\$	330	:
	Print Bas	se Time (s):		20.00	\$	15.00	\$	11.60	;
	Add Sugar		Delete	Channes Name	- (I This				

Note- Please select [Shining 3D]DM03-0.1µm profile. Don't use as it is please change in general layer setting-

- 1. Fill exposure time change from **4.6** to **5.1**
- 2. Boundary exposure time from **4.6** to **5.1**
- 3. Slow return speed on Z-axis from 90 to 72

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Printer Series	Printer Mate	Support						
Accurate 14K								
Accurab-L4K ¥	Layer Counts:		4	ŧ	25	ŧ	0	*
Printer Serial No.	Exposure Level:		High Power	Mode 🔻	High Power	Mode 🔻	High Power	Mode 🔻
L4K1AP310-GJBB048F21 🔻	Fill Exposure Tin	ne (s):	14.00	\$	4.70	\$	4.70	\$
Naterial Brand	Boundary Expos	sure Time (s):	0.50	\$	4.70	\$	4.70	\$
5hining3D 🔹	Support Exposu	re Time (s):	14.00	\$	5.50	\$	5.50	\$
laterial Name	Wait Time on To	p (s):	1.00	\$	1.50	\$	1.00	\$
	Wait Time befor	re Exposure (s):	3.50	\$	3.00	\$	2.00	\$
Shining3DJDC12-0.05	Wait Time after	Exposure (s):	0.00	\$	0.00	\$	0.00	\$
upport Name	Slow Lift Length	n on z-axis (mm):	1.5	\$	1.5	\$	1.0	\$
wax crown & frame support 🔹 🔻	Slow Lift Speed	on z-axis (mm/min):	45	\$	45	\$	60	ŧ
	Quick Lift Lengt	h on z-axis (mm):	6.5	\$	6.5	\$	6.0	\$
	Quick Lift Speed	l on z-axis (mm/min):	160	\$	180	\$	240	\$
	Slow Return Len	igth on z-axis (mm):	1.5	\$	1.5	\$	1.0	\$
	Slow Return Spe	eed on z-axis (mm/min):	60	\$	60	\$	90	\$
	Quick Return Lei	ngth on z-axis (mm):	6.5	\$	6.5	\$	6.0	\$
	Quick Return Sp	eed on z-axis (mm/min):	200	\$	240	\$	280	\$
	Print Base Time	(5):	15.00	\$	15.00	\$	15.59	\$
	Add Support	Delete	Change Nan	ne/Laver Thic	kness		∧ et	ivoto Mi

Note- Please select [Shining 3D]DC12-0.05µm material name.

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Printer Series	Printer Material Support						
initer series							
AccuFab-L4K 🔻	Layer Counts:	4	÷	25	ŧ	0	\$
Printer Serial No.	Exposure Level:	High Power N	Mode 🔻	High Power	Mode 🔻	High Power	Mode 🔻
L4K1AP310-GJBB048F21 🔹	Fill Exposure Time (s):	8.00	\$	2.50	*	2.50	\$
laterial Brand	Boundary Exposure Time (s):	1.00	\$	2.50	\$	2.50	*
historen a	Support Exposure Time (s):	8.00	\$	4.00	\$	3.30	\$
nining3D •	Wait Time on Top (s):	1.00	\$	1.50	\$	1.50	\$
aterial Name	Wait Time before Exposure (s):	4.00	\$	3.50	\$	1.50	\$
Shining3D]SG01-0.05	Wait Time after Exposure (s):	0.00	\$	0.00	\$	0.00	\$
pport Name	Slow Lift Length on z-axis (mm):	2.0	\$	2.0	\$	2.0	\$
uide support 🔹	Slow Lift Speed on z-axis (mm/min):	45	\$	45	\$	60	\$
	Quick Lift Length on z-axis (mm):	9.0	\$	9.0	\$	9.0	\$
	Quick Lift Speed on z-axis (mm/min):	160	\$	160	\$	300	÷
	Slow Return Length on z-axis (mm):	2.0	\$	2.0	\$	2.0	\$
	Slow Return Speed on z-axis (mm/min):	60	\$	72	\$	90	\$
	Quick Return Length on z-axis (mm):	9.0	\$	9.0	\$	9.0	\$
	Quick Return Speed on z-axis (mm/min):	265	\$	280	\$	300	\$
	Print Base Time (s):	16.46	\$	16.46	\$	16.51	\$
			-				

Note- Please select [Shining 3D]SG01-0.05µm material name.

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		Linnanceu Layer	Medium Layer	General Layer
ccuFab-L4K 🔻	Layer Counts:	4	8	0
inter Serial No.	Exposure Level:	Mid Power Mode 🔻	Mid Power Mode 🔻	Mid Power Mode 🔻
4K1AP310-GJBB048F21	Fill Exposure Time (s):	10.00	5.00	3.80 \$
aterial Brand	Boundary Exposure Time (s):	2.00	2.00	2.00
lextDent 🔻	Support Exposure Time (s):	10.00	5.00	5.00
aterial Name	Wait Time on Top (s):	2.00	2.00	2.00
vextDent]C&B MFH N2-0.05	Wait Time before Exposure (s):	2.00	2.00	2.00
nport Name	Wait Time after Exposure (s):	1.00	1.00	1.00
	Slow Lift Length on z-axis (mm):	3.0	2.0	2.0
own support	Slow Lift Speed on z-axis (mm/min):	30 🜲	30 🜲	40 🜲
	Quick Lift Length on z-axis (mm):	4.5	2.0	3.0
	Quick Lift Speed on z-axis (mm/min):	700	700	700
	Slow Return Length on z-axis (mm):	3.0	2.0	1.0
	Slow Return Speed on z-axis (mm/min):	120	150	120
	Quick Return Length on z-axis (mm):	4.5	2.0	3.0 🜲
	Quick Return Speed on z-axis (mm/min):	700	700	700
	Print Base Time (s):	8.50	8.50	15.95

Note- Please select [NextDent]C&BMFH N2-0.05µm material name.

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Slicing Software - Chitubox V1.9.6

Settings								×
	D-Tech Model Pro, Model Std.			•) 🕒 🥖			909
Default	Machine	Resin		Print	Gcode			Advanced
AnyCubic Photon								
Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Lift Distance:	5.000	+	0.000	mm
	Bottom Layer Count:	6)	Lifting Distance:	5.000	+	0.000	mm
Phrozen Sonic Mighty 4K	Exposure Time:	5.500	s	Bottom Retract Distance:	5.000	+	0.000	mm
Phrozen Sonic Mini 4K	Bottom Exposure Time:	40.000	s	Retract Distance:	5.000	+	0.000	mm
	Transition Layer Count:	6)	Bottom Lift Speed:	60.000	8	0.000	mm/min
	Transition Type:	Linear 🔻		Lifting Speed:	60.000	8	0.000	mm/min
	Transition Time Decrement:	4.930	s	Bottom Retract Speed:	120.000	8	0.000) mm/min
	Waiting Mode During Printing:	Light 🔻)	Retract Speed:	120.000	&	0.000	mm/min
	Light-off Delay:	9.000	s					
	Bottom Light-off Delay:	9.000	s					

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Phrozen Sonic Mini 4K + ber and the sonic Mini 50µm/ 0.05 mm



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Phrozen Sonic Mini 4K + drug cast burg of the solution of the



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£	D-Tech Surgical Guide			•) 🗈 🥖	• [1		
Default	Machine	Resin		Print	Gcode			Advanced
AnyCubic Photon								
Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Lift Distance:	5.000) + (0.000	mm
Throzen Some Will OK	Bottom Layer Count:	6		Lifting Distance:	5.000) + (0.000	mm
Phrozen Sonic Mighty 4K	Exposure Time:	5.500	s	Bottom Retract Distance:	5.000	+	0.000	mm
Phrozen Sonic Mini 4K	Bottom Exposure Time:	40.000	s	Retract Distance:	5.000) + (0.000	mm
	Transition Layer Count:	6		Bottom Lift Speed:	60.000	8	0.000	mm/min
	Transition Type:	Linear 🔻		Lifting Speed:	60.000	8	0.000	mm/min
	Transition Time Decrement:	4.930	s	Bottom Retract Speed:	120.000	8	0.000	mm/min
	Waiting Mode During Printing:	Light 🔻		Retract Speed:	120.000	8	0.000	mm/min
	Light-off Delay:	9.000	s					
	Bottom Light-off Delay:	9.000	s					

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Slicing Software - Chitubox V1.9.6

Settings C C C 靣 Ð 靣 D-Tech Model Pro. Model Std, Model Basic, Model Hard ▼ 🔁 🛛 💉 Default Machine Resin Advanced AnyCubic Photon Layer Height: Bottom Lift Distance: 0.050 mm 5.000 0.000 mm Bottom Layer Count: 6 Lifting Distance: 5.000 0.000 mm + Phrozen Sonic Mighty 4K 4.500 **Exposure Time:** Bottom Retract Distance: S 5.000 0.000 mm Phrozen Sonic Mini 4K Bottom Exposure Time: 40.000 **Retract Distance:** S 5.000 0.000 mm + Bottom Lift Speed: mm/min Transition Layer Count: 6 60.000 & 0.000 Transition Type: Linear 🔻 Lifting Speed: 0.000 mm/min 60.000 & Transition Time Decrement: Bottom Retract Speed: 120.000 5.070 S & 0.000 mm/min Light ... 🔻 0.000 Waiting Mode During Printing: **Retract Speed:** 120.000 & mm/min Light-off Delay: 9.000 S Bottom Light-off Delay: 9.000 s

Od-tech Phrozen Sonic Mini 8K Revision Date 24 Jan 2024 QMS/PS/Phrozen/Mini8K Revision No:01 No. of Pages Page 2 of 4		Printer se	ttings	Origin Date	22 Jan 2024
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	D-Tech Dental Cast Purple, Cast-L				1			000
Default	Machine	R	esin	Print			Ad	vanced
AnyCubic Photon								
Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Lift Distance:	5.000) +	0.000	mm
	Bottom Layer Count:	6)	Lifting Distance:	5.000) +	0.000	mm
hrozen Sonic Mighty 4K	Exposure Time:	5.000	s	Bottom Retract Distance:	5.000) +	0.000	mm
Phrozen Sonic Mini 4K	Bottom Exposure Time:	40.000	s	Retract Distance:	5.000) +	0.000	mm
	Transition Layer Count:	6)	Bottom Lift Speed:	60.000	8	0.000	mm/min
	Transition Type:	Linear 🔻		Lifting Speed:	60.000	8	0.000	mm/min
	Transition Time Decrement:	5.000	s	Bottom Retract Speed:	120.000	8	0.000	mm/min
	Waiting Mode During Printing:	Light 🔻)	Retract Speed:	120.000	8	0.000	mm/min
	Light-off Delay:	9.000	s					
	Bottom Light-off Delay:	9.000	s					

	Printer set	ttings	Origin Date	22 Jan 2024
◆d-tech 3 D	Phrozen Soni	Revision Date	24 Jan 2024	
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	Phrozen Soni	ic Mini 8K	Revision Date	24 Jan 2024
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Phrozen Sonio	c Mighty 4K	Revision Date	06 Feb 2024
QMS/PS/Phrozen/MT04 Revision No:02		No. of Pages	Page 1 of 4



Slicing Software - Chitubox V1.9.6

Settings								×
	D-Tech Model Basic				3		Ce	
Default	Machine	Resin		Print	Scode		Ad	vanced
AnyCubic Photon Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Lift Distance:	5.000) +	0.000	mm
Phrozen Sonic Mighty 4K	Bottom Layer Count:	6	J	Lifting Distance:	5.000	+	0.000	mm
	Exposure Time:	4.500	s	Bottom Retract Distance:	5.000	+	0.000	mm
	Bottom Exposure Time:	40.000	s	Retract Distance:	5.000	+	0.000	mm
	Transition Layer Count:	6)	Bottom Lift Speed:	60.000	8	0.000	mm/min
	Transition Type:	Linear 🔻		Lifting Speed:	60.000	8	0.000	mm/min
	Transition Time Decrement:	5.070	s	Bottom Retract Speed:	120.000	8	0.000] mm/min
	Waiting Mode During Printing:	Light 🔻)	Retract Speed:	120.000	8	0.000] mm/min
	Light-off Delay:	12.000	s					
	Bottom Light-off Delay:	12.000	s					

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◆d-tech 吕 D	Phrozen Sonio	Phrozen Sonic Mighty 4K		06 Feb 2024
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◆d-tech	Phrozen Sonio	c Mighty 4K	Revision Date	06 Feb 2024
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	Printer se	ettings	Origin Date	22 Jan 2024
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	D-Tech Dental Cast-L 50 µm			•				900
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AnyCubic Photon								
Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Lift Distance:	5.000	+	0.000	mm
Throzen Some min ok	Bottom Layer Count:	6		Lifting Distance:	5.000) +	0.000	mm
Phrozen Sonic Mighty 4K	Exposure Time:	5.000	s	Bottom Retract Distance:	5.000	+	0.000	mm
	Bottom Exposure Time:	30.000	s	Retract Distance:	5.000) +	0.000	mm
	Transition Layer Count:	6		Bottom Lift Speed:	60.000	&	0.000	mm/min
	Transition Type:	Linear 🔻		Lifting Speed:	60.000	&	0.000	mm/min
	Transition Time Decrement:	3.570	s	Bottom Retract Speed:	120.000	8	0.000	mm/min
	Waiting Mode During Printing:	Light 🔻		Retract Speed:	120.000	8	0.000	mm/min
	Light-off Delay:	12.000	s					
	Bottom Light-off Delay:	12.000	s					

	Printer sett	ings	Origin Date	22 Jan 2024
•d-tech 3D	Anycubic Photon Mono 4K			06 Feb 2024
	QMS/PS/Anycubic/Mono4K	Revision No:01	No. of Pages	Page 1 of 5

Anycubic Photon Mono 4K + Q and a set and a se

Slicing Software – Anycubic photon workshop V2.2.16

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Normal Exposure	Time(s):		Advance				•
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Use Random Er	ode Shell:		Z Retract	Step(1) Speed	ا(mm/s): [۹	6.00 ► 0 ►	
			Normal La Z Lift Hei Z Lift Stej Z Retract Z Lift Hei Z Lift Stej Z Retract	yer Control S ght[0] (mm): p[0] Speed(mi Step[0] Spee ght[1] (mm): p[1] Speed(mi Step[1] Spee	teps m/s): (- d(mm/s): (- m/s): (- d(mm/s): (-	 < 5.00 > < 1.00 > < 3.00 > < 4.50 > < 2.00 > < 3.00 > 	
			Export	Loa	d (Save	

	Printer sett	ings	Origin Date	22 Jan 2024
•d-tech BD	3D Anycubic Photon Mono 4K			06 Feb 2024
	No. of Pages	Page 2 of 5		

Anycu Photor 4K	bic 1 Mono		+	Model Hard	+	Layer ^{height} 50µm/ 0.05 mm
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	Printer sett	ings	Origin Date	22 Jan 2024
•d-tech BD	Anycubic Photon Mono 4K			06 Feb 2024
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	Printer sett	Origin Date	22 Jan 2024	
•d-tech BD	Anycubic P Mono 4	Revision Date	06 Feb 2024	
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	Printer sett	Origin Date	22 Jan 2024	
•d-tech BD	Anycubic P Mono 4	Anycubic Photon Mono 4K		
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•d-tech 3D	Printer s Elegoo Sa	ettings turn 2 8K	Origin Date Revision Date	22 Jan 2024 07 Feb 2024
QMS/PS/Elegoo /8K Revision No:00			No. of Pages	Page 1 of 2
Elegoo Saturn 2 8K		+ Iodel Std	Addel Basic +	Layer height 50µm/

2 8K





Slicing Software - Chitubox V1.9.6

Settings

	D-Tech Model Std, Model Basic			•) 🗄 🥖			
Default	Machine	Resin		Print	Gcode			Advanced
AnyCubic Photon						_		
Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Lift Distance:	5.000) +	4.000	mm
Throzen Some Mini ok	Bottom Layer Count:	6)	Lifting Distance:	5.000) +	4.000	mm
Phrozen Sonic Mighty 4K	Exposure Time:	5.500) s	Bottom Retract Distance:	7.500) +	1.500	mm
Phrozen Sonic Mini 4K	Bottom Exposure Time:	40.000	s	Retract Distance:	7.500) +	1.500	mm
ELEGOO SATURN 2	Transition Layer Count:	6)	Bottom Lift Speed:	60.000	8	180.000	mm/min
	Transition Type:	Linear v		Lifting Speed:	60.000	8	180.000	mm/min
	Transition Time Decrement:	4.930	s	Bottom Retract Speed:	120.000	8	65.000	mm/min
	Waiting Mode During Printing:	Light 🔻)	Retract Speed:	120.000	8	65.000	mm/min
	Light-off Delay:	9.000	s					
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	D-Tech Dental Cast Purple, Cast-L							
Default	Machine	Resin		Print	Gcode			Advanced
AnyCubic Photon								_
Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Lift Distance:	5.000) +	4.000	mm
	Bottom Layer Count:	6)	Lifting Distance:	5.000) +	4.000	mm
Phrozen Sonic Mighty 4K	Exposure Time:	4.500	s	Bottom Retract Distance:	7.500) +	1.500	mm
Phrozen Sonic Mini 4K	Bottom Exposure Time:	40.000	s	Retract Distance:	7.500) +	1.500	mm
ELEGOO SATURN 2	Transition Layer Count:	6)	Bottom Lift Speed:	60.000	8	180.000] mm/min
	Transition Type:	Linear 🔻		Lifting Speed:	60.000	8	180.000] mm/min
	Transition Time Decrement:	5.070	s	Bottom Retract Speed:	120.000	8	65.000] mm/min
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