



These resin parameters have been determined with a temperature of 25°C and a relative humidity of 75%. Test print were performed in a well-ventilated indoor space.

If your print breaks in the middle of the print, it can be due to an insufficient normal exposure time

If your print fails to stick onto the build plate, try to increase the bottom layer exposure time.

Sonic Mega 8K

FEPshop Resin Type	Basic Info		Bottom Layers			Transition Layers	Normal Layers			Waiting Mode During Printing		
	Layer Height (mm)	Retract Speed (mm/min)	Layer Count	Exposure Time (s)	Lifting Distance (mm)	Lifting Speed (mm/min)	Layer Count	Exposure Time (s)	Lifting Distance (mm)	Lifting Speed (mm/min)	Mode	Rest Time After Retract (s)
1 Basic Resin - Tough - Gray	0.05	150	8	34 - 42	10	45	6	2.2 - 3.0	10	45		4
2 Basic Tough Resin White	0.05	150	8	34 - 42	10	45	6	2.2 - 3.0	10	45		4
3 Basic Tough Resin Black	0.05	150	8	34 - 42	10	45	6	2.2 - 3.0	10	45		4
4 Basic Tough Resin Clear	0.05	150	8	34 - 42	10	45	6	2.2 - 3.0	10	45		4
5 Basic Resin ABS Like Gray	0.05	150	8	34 - 42	10	45	6	2.6 - 3.2	10	45		4
6 Basic Resin ABS Like White	0.05	150	8	34 - 42	10	45	6	2.6 - 3.2	10	45		4
7 Functional Resin High Tenacity	0.05	150	8	34 - 42	10	45	6	2.7 - 3.2	10	45		8
8 Functional Resin Flexible Black	0.05	150	8	34 - 42	10	45	6	2.9 - 3.3	10	45		4
9 Functional Resin Elastic Clear	0.05	150	6	38 - 46	12	30	6	5.8 - 6.6	12	30		8
10 Functional Resin Rubber Mold	0.05	150	8	36 - 42	10	45	6	3.0 - 3.6	10	45		4
11 Functional Resin High Transparency	0.05	150	8	40 - 46	10	45	6	6.4 - 7.0	10	45		4
12 Functional Resin Silicone Mold	0.05	150	8	34 - 42	10	45	6	2.9 - 3.4	10	45		4
13	0.05	150	8		10	45	6		10	45		4
14	0.05	150	8		10	45	6		10	45		4
15	0.05	150	8		10	45	6		10	45		4
16	0.05	150	8		10	45	6		10	45		4
17	0.05	150	8		10	45	6		10	45		4
18	0.05	150	8		10	45	6		10	45		4
19	0.05	150	8		10	45	6		10	45		4
20	0.05	150	8		10	45	6		10	45	Resting time	4



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Sonic Mighty 8K

FEPshop Resin Type	Basic Info		Bottom Layers			Transition Layers	Normal Layers			Waiting Mode During Printing		
	Layer Height (mm)	Retract Speed (mm/min)	Layer Count	Exposure Time (s)	Lifting Distance (mm)	Lifting Speed (mm/min)	Layer Count	Exposure Time (s)	Lifting Distance (mm)	Lifting Speed (mm/min)	Mode	Rest Time After Retract (s)
1 Basic Resin - Tough - Gray	0.05	150	6	24 - 30	6	60	6	1.8 - 2.6	6	60		4
2 Basic Tough Resin White	0.05	150	6	24 - 30	6	60	6	1.8 - 2.6	6	60		4
3 Basic Tough Resin Black	0.05	150	6	24 - 30	6	60	6	1.8 - 2.6	6	60		4
4 Basic Tough Resin Clear	0.05	150	6	24 - 30	6	60	6	1.8 - 2.6	6	60		4
5 Basic Resin ABS Like Gray	0.05	150	6	24 - 30	6	60	6	2.5 - 2.8	6	60		4
6 Basic Resin ABS Like White	0.05	150	6	24 - 30	6	60	6	2.5 - 2.8	6	60		4
7 Functional Resin High Tenacity	0.05	150	6	24 - 30	6	60	6	2.3 - 2.7	6	60		8
8 Functional Resin Flexible Black	0.05	150	6	22 - 28	6	60	6	2.0 - 2.5	6	60		4
9 Functional Resin Elastic Clear	0.05	150	6	30 - 38	10	45	6	5.2 - 6.0	10	45		8
10 Functional Resin Rubber Mold	0.05	150	6	26 - 32	6	60	6	2.6 - 3.2	6	60		4
11 Functional Resin High Transparency	0.05	150	6	30 - 36	6	60	6	6.0 - 6.6	6	60		4
12 Functional Resin Silicone Mold	0.05	150	6	24 - 32	6	60	6	2.5 - 3.0	6	60		4
13	0.05	150	6		6	60	6		6	60		4
14	0.05	150	6		6	60	6		6	60		4
15	0.05	150	6		6	60	6		6	60		4
16	0.05	150	6		6	60	6		6	60		4
17	0.05	150	6		6	60	6		6	60		4
18	0.05	150	6		6	60	6		6	60		4
19	0.05	150	6		6	60	6		6	60		4
20	0.05	150	6		6	60	6		6	60	Resting time	4



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Sonic Mini 8K

FEPshop Resin Type	Basic Info		Bottom Layers			Transition Layers	Normal Layers			Waiting Mode During Printing		
	Layer Height (mm)	Retract Speed (mm/min)	Layer Count	Exposure Time (s)	Lifting Distance (mm)	Lifting Speed (mm/min)	Layer Count	Exposure Time (s)	Lifting Distance (mm)	Lifting Speed (mm/min)	Mode	Rest Time After Retract (s)
1 Basic Tough Resin Gray	0.05	150	6	24 - 30	6	60	6	2.2 - 2.7	6	60		4
2 Basic Tough Resin White	0.05	150	6	24 - 30	6	60	6	2.2 - 2.7	6	60		4
3 Basic Tough Resin Black	0.05	150	6	24 - 30	6	60	6	2.2 - 2.7	6	60		4
4 Basic Tough Resin Clear	0.05	150	6	24 - 30	6	60	6	2.2 - 2.7	6	60		4
5 Basic Resin ABS Like Gray	0.05	150	6	24 - 30	6	60	6	2.3 - 2.8	6	60		4
6 Basic Resin ABS Like White	0.05	150	6	24 - 30	6	60	6	2.3 - 2.8	6	60		4
7 Functional Resin High Tenacity	0.05	150	6	24 - 30	6	60	6	2.5 - 2.9	6	60		8
8 Functional Resin Flexible Black	0.05	150	6	22 - 30	6	60	6	2.4 - 2.8	6	60		4
9 Functional Resin Elastic Clear	0.05	150	6	32 - 40	10	45	6	5.4 - 6.2	10	45		8
10 Functional Resin Rubber Mold	0.05	150	6	26 - 32	6	60	6	2.6 - 3.2	6	60		4
11 Functional Resin High Transparency	0.05	150	6	30 - 36	6	60	6	6.0 - 6.6	6	60		4
12 Functional Resin Silicone Mold	0.05	150	6	24 - 32	6	60	6	2.5 - 3.0	6	60		4
13	0.05	150	6		6	60	6		6	60		4
14	0.05	150	6		6	60	6		6	60		4
15	0.05	150	6		6	60	6		6	60		4
16	0.05	150	6		6	60	6		6	60		4
17	0.05	150	6		6	60	6		6	60		4
18	0.05	150	6		6	60	6		6	60		4
19	0.05	150	6		6	60	6		6	60		4
20	0.05	150	6		6	60	6		6	60	Resting time	4