



**3D** ACCUPRINT™



# 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**

	<h2>Printer Settings Index</h2>		Origin Date	22 Jan 2024
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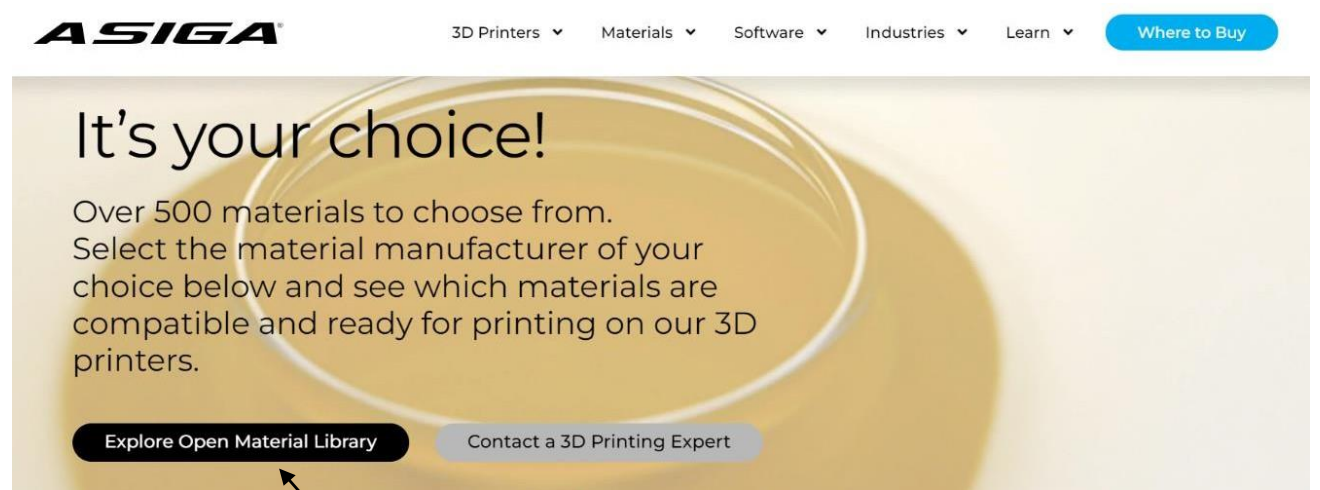
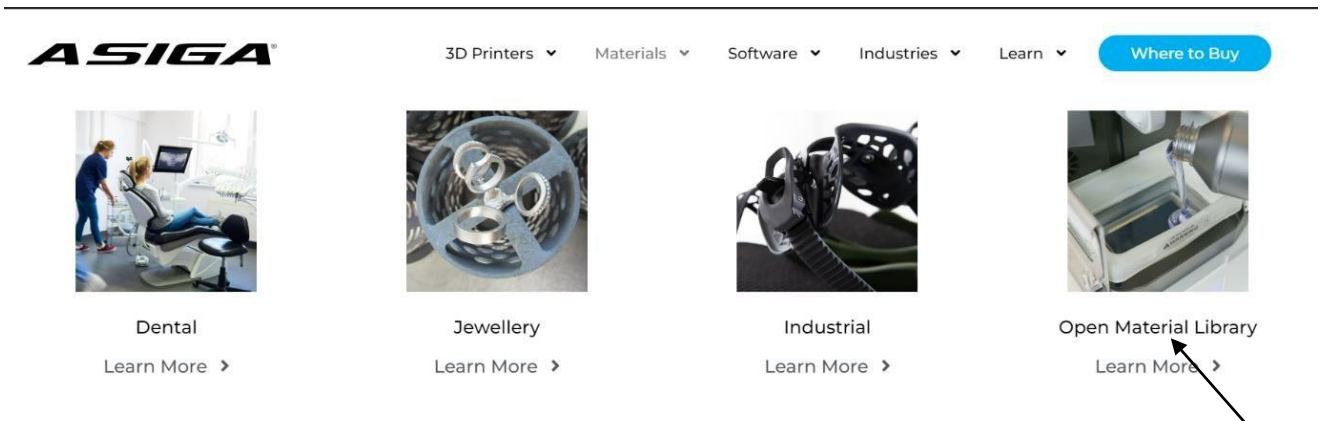
Sr. No	Printer Models	Model Pro 	Model Std 	Model Basic 	Model Hard 	Dental Cast 	Cast-L 	C&B/C&B Pro 	Surgical Guide 
1	 <b>Asiga Max UV 385</b>	✓	✓	✓	X	✓	X	✓	✓
		50 to 150	50 to 150	50 to 150	NA	50 to 150	NA	50 to 150	50 to 150
2	 <b>Ackuretta SOL</b>	X	✓	✓	X	✓	X	✓	✓
		NA	50 to 150	50 to 150	NA	50 to 150	NA	70 to 150 C&B	50 to 150
3	 <b>Shining 3D L4K</b>	✓	✓	✓	X	✓	✓	✓	✓
		50 to 100	50 to 100	50 to 100	NA	50	50	50 C&B	50
4	 <b>Phrozen Sonic Mini 4K</b>	✓	✓	X	✓	✓	✓	✓	✓
		50	50	NA	50	50	50	50 C&B	50
5	 <b>Phrozen Sonic Mini 8K</b>	✓	✓	✓	✓	✓	✓	✓	✓
		50	50	50	50	50	50	50 C&B	50
6	 <b>Phrozen Sonic Mighty 4K</b>	X	X	✓	X	X	✓	X	✓
		NA	NA	50 to 100	NA	NA	50 to 100	NA	50
7	 <b>Anycubic Photon Mono 4K</b>	✓	✓	✓	✓	✓	✓	✓	✓
		50	50	50	50	50	50	50 C&B	50
8	 <b>Elegoo Saturn2 8K</b>	X	✓	✓	X	X	✓	X	X
		NA	50	50	NA	NA	50	NA	NA


	<b>Printer settings</b> <b>Asiga Max UV 385</b>		Origin Date	22 Jan 2024
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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.



	<b>Printer settings</b> <b>Asiga Max UV 385</b>		Origin Date	22 Jan 2024
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← → ↻ asiga.com/open-material-library/ 🔗 ☆ ⚙️ 🗄️ 🌐



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List of available material profiles:

- D-Tech 3DAccuprint C&B
- D-Tech 3DAccuprint Dental Cast
- D-Tech 3DAccuprint Model Pro
- D-Tech 3DAccuprint Model Standard
- D-Tech 3DAccuprint Surgical Guide

Download Material Profiles

visit – [dtechasia.com](https://dtechasia.com)

- 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 AI V5.1.1*

- D Tech resins are already validated in Ackuretta Software (Alpha AI 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**

Printer	Brand	Resin	Layer
<input type="radio"/> FreeShape 120 - Nov 2018	<input type="radio"/> Straumann	<input checked="" type="radio"/> <b>C&amp;B</b>	<b>Fine</b>
<input type="radio"/> FreeShape 120 - Feb 2019	<input type="radio"/> Trusana	<input type="radio"/> Dental Cast	Standard
<input type="radio"/> FreeShape 120 - May 2019	<input type="radio"/> VOCO	<input type="radio"/> Model Basic	Fast
<input type="radio"/> DENTIQ	<input type="radio"/> WhipMix	<input type="radio"/> Model Standard	
<input checked="" type="radio"/> <b>SOL   Large L BP</b>	<input type="radio"/> YAMAHACHI	<input type="radio"/> Surgical guide	
<input type="radio"/> SOL   Medium M BP	<input type="radio"/> YLLER_digital		
<input type="radio"/> SOL   Small S BP	<input checked="" type="radio"/> <b>d-tech</b>		

Name

Layer Thickness	<input type="text" value="0.07 mm"/>	Scaling Ratio	X	<input type="text" value="1.00965"/>
Illumination	<input type="text" value="1.70 s"/>		Y	<input type="text" value="1.00842"/>
Adjustment	<input type="text" value="0.0 s"/>		Z	<input type="text" value="1.00670"/>
Base Adjustment	<input type="text" value="0.0 s"/>			

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## ❖ Model Standard-

### Parameter Editor ✕

Printer	Brand	Resin	Layer
<input type="radio"/> FreeShape 120 - Nov 2018	<input type="radio"/> Straumann	<input type="radio"/> C&B	Finest
<input type="radio"/> FreeShape 120 - Feb 2019	<input type="radio"/> Trusana	<input type="radio"/> Dental Cast	<b>Fine</b>
<input type="radio"/> FreeShape 120 - May 2019	<input type="radio"/> VOCO	<input type="radio"/> Model Basic	Standard
<input type="radio"/> DENTIQ	<input type="radio"/> WhipMix	<input checked="" type="radio"/> <b>Model Standard</b>	Fast
<input checked="" type="radio"/> <b>SOL   Large L BP</b>	<input type="radio"/> YAMAHACHI	<input type="radio"/> Surgical guide	
<input type="radio"/> SOL   Medium M BP	<input type="radio"/> YLLER_digital		
<input type="radio"/> SOL   Small S BP	<input checked="" type="radio"/> <b>d-tech</b>		

Name

Layer Thickness	<input type="text" value="0.07 mm"/>	Scaling Ratio	X	<input type="text" value="1.00692"/>
Illumination	<input type="text" value="2.60 s"/>		Y	<input type="text" value="1.00503"/>
Adjustment	<input type="text" value="0.0 s"/>		Z	<input type="text" value="1.01762"/>
Base Adjustment	<input type="text" value="0.0 s"/>			

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## ❖ Model Basic-


### Parameter Editor

Printer	Brand	Resin	Layer
<input type="radio"/> FreeShape 120 - Nov 2018	<input type="radio"/> Straumann	<input type="radio"/> C&B	Finest
<input type="radio"/> FreeShape 120 - Feb 2019	<input type="radio"/> Trusana	<input type="radio"/> Dental Cast	<b>Fine</b>
<input type="radio"/> FreeShape 120 - May 2019	<input type="radio"/> VOCO	<input checked="" type="radio"/> <b>Model Basic</b>	Standard
<input type="radio"/> DENTIQ	<input type="radio"/> WhipMix	<input type="radio"/> Model Standard	Fast
<input checked="" type="radio"/> <b>SOL   Large L BP</b>	<input type="radio"/> YAMAHACHI	<input type="radio"/> Surgical guide	
<input type="radio"/> SOL   Medium M BP	<input type="radio"/> YLLER_digital		
<input type="radio"/> SOL   Small S BP	<input checked="" type="radio"/> <b>d-tech</b>		

Name



Layer Thickness	<input type="text" value="0.07 mm"/>	Scaling Ratio	X	<input type="text" value="1.00442"/>
Illumination	<input type="text" value="2.10 s"/>		Y	<input type="text" value="1.00533"/>
Adjustment	<input type="text" value="0.0 s"/>		Z	<input type="text" value="1.01391"/>
Base Adjustment	<input type="text" value="0.0 s"/>			

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## ❖ Dental Cast-


### Parameter Editor

Printer	Brand	Resin	Layer
<input type="radio"/> FreeShape 120 - Nov 2018	<input type="radio"/> Straumann	<input type="radio"/> C&B	Finest
<input type="radio"/> FreeShape 120 - Feb 2019	<input type="radio"/> Trusana	<input checked="" type="radio"/> <b>Dental Cast</b>	<b>Fine</b>
<input type="radio"/> FreeShape 120 - May 2019	<input type="radio"/> VOCO	<input type="radio"/> Model Basic	Standard
<input type="radio"/> DENTIQ	<input type="radio"/> WhipMix	<input type="radio"/> Model Standard	Fast
<input checked="" type="radio"/> <b>SOL   Large L BP</b>	<input type="radio"/> YAMAHACHI	<input type="radio"/> Surgical guide	
<input type="radio"/> SOL   Medium M BP	<input type="radio"/> YLLER_digital		
<input type="radio"/> SOL   Small S BP	<input checked="" type="radio"/> <b>d-tech</b>		

Name

Layer Thickness	<input type="text" value="0.07 mm"/>	Scaling Ratio	X	<input type="text" value="1.01294"/>
Illumination	<input type="text" value="1.80 s"/>		Y	<input type="text" value="1.01421"/>
Adjustment	<input type="text" value="0.0 s"/>		Z	<input type="text" value="1.00182"/>
Base Adjustment	<input type="text" value="0.0 s"/>			



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## ❖ Surgical Guide-

### Parameter Editor

Printer	Brand	Resin	Layer
<input type="radio"/> FreeShape 120 - Nov 2018	<input type="radio"/> Straumann	<input type="radio"/> C&B	Finest
<input type="radio"/> FreeShape 120 - Feb 2019	<input type="radio"/> Trusana	<input type="radio"/> Dental Cast	<b>Fine</b>
<input type="radio"/> FreeShape 120 - May 2019	<input type="radio"/> VOCO	<input type="radio"/> Model Basic	Standard
<input type="radio"/> DENTIQ	<input type="radio"/> WhipMix	<input type="radio"/> Model Standard	Fast
<input checked="" type="radio"/> <b>SOL   Large L BP</b>	<input type="radio"/> YAMAHACHI	<input checked="" type="radio"/> <b>Surgical guide</b>	
<input type="radio"/> SOL   Medium M BP	<input type="radio"/> YLLER_digital		
<input type="radio"/> SOL   Small S BP	<input checked="" type="radio"/> <b>d-tech</b>		

Name  + - 📄 Import Export

Layer Thickness	<input type="text" value="0.07 mm"/>	Scaling Ratio	X	<input type="text" value="1.00634"/>
Illumination	<input type="text" value="1.90 s"/>		Y	<input type="text" value="1.00618"/>
Adjustment	<input type="text" value="0.0 s"/>		Z	<input type="text" value="1.01496"/>
Base Adjustment	<input type="text" value="0.0 s"/>			

**Apply**

***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.*

	<b>Printer settings</b> <b>Shining 3D L4K</b>		Origin Date	22 Jan 2024
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Shining 3D L4K + Model Pro + Model Std + Model Basic + Layer height 50µm/ 0.05 mm

### Slicing Software - Accuware V 3.1.8.35

Material Manager

Printer | **Material** | Support

Printer Series	AccuFab-L4K	Layer Counts:	5	27	0
Printer Serial No.	L4K1AP310-gjBB048F21	Exposure Level:	High Power Mode	High Power Mode	Mid Power Mode
Material Brand	Shining3D	Fill Exposure Time (s):	11.00	5.00	4.00
Material Name	[Shining3D]DM03-0.05	Boundary Exposure Time (s):	5.00	3.00	4.00
Support Name	die support	Support Exposure Time (s):	11.00	5.00	4.20
		Wait Time on Top (s):	0.50	0.50	0.00
		Wait Time before Exposure (s):	4.50	4.00	3.00
		Wait Time after Exposure (s):	0.00	0.00	0.00
		Slow Lift Length on z-axis (mm):	1.5	1.5	1.0
		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

Buttons: Add Support, Delete, Change Name/Layer Thickness

Activate Windows: Go to Settings to activate V

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**

	Printer settings <b>Shining 3D L4K</b>		Origin Date	22 Jan 2024
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Shining 3D L4K + Model Pro + Model Std + Model Basic + Layer height 100µm/ 0.1 mm

Material Manager


	Printer	Material	Support
Printer Series	AccuFab-L4K		
Printer Serial No.	L4K1AP310-GjBB048F21		
Material Brand	Shining3D		
Material Name	[Shining3D]DM03-0.1		
Support Name	die support		
		Enhanced Layer	Medium Layer
Layer Counts:		5	27
Exposure Level:		High Power Mode	High Power Mode
Fill Exposure Time (s):		18.40	9.20
Boundary Exposure Time (s):		4.60	4.60
Support Exposure Time (s):		11.00	5.00
Wait Time on Top (s):		0.50	0.50
Wait Time before Exposure (s):		4.50	4.00
Wait Time after Exposure (s):		0.00	0.00
Slow Lift Length on z-axis (mm):		1.5	1.5
Slow Lift Speed on z-axis (mm/min):		30	60
Quick Lift Length on z-axis (mm):		7.0	7.0
Quick Lift Speed on z-axis (mm/min):		220	220
Slow Return Length on z-axis (mm):		1.5	1.5
Slow Return Speed on z-axis (mm/min):		72	72
Quick Return Length on z-axis (mm):		7.0	7.0
Quick Return Speed on z-axis (mm/min):		220	220
Print Base Time (s):		20.00	15.00
		General Layer	
		0	
		High Power Mode	
		5.10	
		5.10	
		4.20	
		0.00	
		3.00	
		0.00	
		1.0	
		80	
		7.0	
		330	
		1.0	
		72	
		7.0	
		330	
		11.60	

Buttons: Add Support, Delete, Change Name/Layer Thickness

Activate Windows: Go to Settings to activate

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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**Material Manager**

Printer Series: AccuFab-L4K

Printer Serial No.: L4K1AP310-GJBB048F21

Material Brand: Shining3D

Material Name: [Shining3D]DC12-0.05

Support Name: wax crown & frame support

Reset Current

Save Current

Reset All

Save All

Printer   **Material**   Support

Layer Counts:	4	25	0
Exposure Level:	High Power Mode	High Power Mode	High Power Mode
Fill Exposure Time (s):	14.00	4.70	4.70
Boundary Exposure Time (s):	0.50	4.70	4.70
Support Exposure Time (s):	14.00	5.50	5.50
Wait Time on Top (s):	1.00	1.50	1.00
Wait Time before Exposure (s):	3.50	3.00	2.00
Wait Time after Exposure (s):	0.00	0.00	0.00
Slow Lift Length on z-axis (mm):	1.5	1.5	1.0
Slow Lift Speed on z-axis (mm/min):	45	45	60
Quick Lift Length on z-axis (mm):	6.5	6.5	6.0
Quick Lift Speed on z-axis (mm/min):	160	180	240
Slow Return Length on z-axis (mm):	1.5	1.5	1.0
Slow Return Speed on z-axis (mm/min):	60	60	90
Quick Return Length on z-axis (mm):	6.5	6.5	6.0
Quick Return Speed on z-axis (mm/min):	200	240	280
Print Base Time (s):	15.00	15.00	15.59

Add Support   Delete   Change Name/Layer Thickness

Activate Windows  
Go to Settings to activate 1

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

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Shining  
**3D L4K**



+

Surgical Guide



+

Layer height  
**50µm/  
0.05 mm**

**Material Manager**

Printer Series  
AccuFab-L4K

Printer Serial No.  
L4K1AP310-GjBB048F21

Material Brand  
Shining3D

Material Name  
[Shining3D]SG01-0.05

Support Name  
guide support

Reset Current

Save Current

Reset All

Save All


Printer
Material
Support

Layer Counts:	4	25	0
Exposure Level:	High Power Mode	High Power Mode	High Power Mode
Fill Exposure Time (s):	8.00	2.50	2.50
Boundary Exposure Time (s):	1.00	2.50	2.50
Support Exposure Time (s):	8.00	4.00	3.30
Wait Time on Top (s):	1.00	1.50	1.50
Wait Time before Exposure (s):	4.00	3.50	1.50
Wait Time after Exposure (s):	0.00	0.00	0.00
Slow Lift Length on z-axis (mm):	2.0	2.0	2.0
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

Add Support
Delete
Change Name/Layer Thickness

Activate Windows  
Go to Settings to activate W

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


	<b>Printer settings</b> <b>Shining 3D L4K</b>		Origin Date	22 Jan 2024
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# Shining 3D L4K



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Crown & Bridge



+

Layer height  
**50µm/  
0.05 mm**

**Material Manager**

Printer
Material
Support

Printer Series  
AccuFab-L4K

Printer Serial No.  
L4K1AP310-GjBB048F21

Material Brand  
NextDent

Material Name  
[NextDent]C&B MFH N2-0.05

Support Name  
crown support

Reset Current

Save Current

Reset All

Save All

	LIMITED Layer	MEDIUM Layer	GENERAL Layer
Layer Counts:	4	8	0
Exposure Level:	Mid Power Mode	Mid Power Mode	Mid Power Mode
Fill Exposure Time (s):	10.00	5.00	3.80
Boundary Exposure Time (s):	2.00	2.00	2.00
Support Exposure Time (s):	10.00	5.00	5.00
Wait Time on Top (s):	2.00	2.00	2.00
Wait Time before Exposure (s):	2.00	2.00	2.00
Wait Time after Exposure (s):	1.00	1.00	1.00
Slow Lift Length on z-axis (mm):	3.0	2.0	2.0
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

Add Support
Delete
Change Name/Layer Thickness

Activate Windows  
Go to Settings to activate Windows

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


	<b>Printer settings</b> <b>Phrozen Sonic Mini 4K</b>		Origin Date	22 Jan 2024
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## Phrozen Sonic Mini 4K



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Model Pro



Model Std



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Layer height  
**50µm/  
0.05 mm**

### Slicing Software - *Chitobox V1.9.6*

Settings
✕

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🗑️

D-Tech Model Pro, Model Std.

📄
✎
🗑️
🔄
📧
📄

Machine

Resin

Print


Gcode

Advanced

Layer Height:	<input type="text" value="0.050"/>	mm	Bottom Lift Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Bottom Layer Count:	<input type="text" value="6"/>		Lifting Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Exposure Time:	<input style="border: 2px solid black;" type="text" value="5.500"/>	s	Bottom Retract Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Bottom Exposure Time:	<input type="text" value="40.000"/>	s	Retract Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Transition Layer Count:	<input type="text" value="6"/>		Bottom Lift Speed:	<input type="text" value="60.000"/>	&	<input type="text" value="0.000"/>	mm/min
Transition Type:	<input type="text" value="Linear"/>	▼	Lifting Speed:	<input type="text" value="60.000"/>	&	<input type="text" value="0.000"/>	mm/min
Transition Time Decrement:	<input type="text" value="4.930"/>	s	Bottom Retract Speed:	<input type="text" value="120.000"/>	&	<input type="text" value="0.000"/>	mm/min
Waiting Mode During Printing:	<input type="text" value="Light ..."/>	▼	Retract Speed:	<input type="text" value="120.000"/>	&	<input type="text" value="0.000"/>	mm/min
Light-off Delay:	<input type="text" value="9.000"/>	s					
Bottom Light-off Delay:	<input type="text" value="9.000"/>	s					


	<b>Printer settings</b> <b>Phrozen Sonic Mini 4K</b>		Origin Date	22 Jan 2024
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# Phrozen Sonic Mini 4K



+

Model Hard



+

Layer height  
**50µm/  
0.05 mm**

Settings
✕

+
🗑️

D-Tech Model Hard

+
🖋️
🗑️
🔄
📄
🔗
🔗

Default

AnyCubic Photon

Phrozen Sonic Mini 8K

Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 4K

Machine

Resin

Print

Gcode

Advanced

Layer Height:	0.050	mm	Bottom Lift Distance:	5.000	+	0.000	mm
Bottom Layer Count:	6		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	&	0.000	mm/min
Transition Type:	Linear	▼	Lifting Speed:	60.000	&	0.000	mm/min
Transition Time Decrement:	5.070	s	Bottom Retract Speed:	120.000	&	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					



	<b>Printer settings</b> <b>Phrozen Sonic Mini 4K</b>		Origin Date	22 Jan 2024
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## Phrozen Sonic Mini 4K



+

Dental Cast Purple



+

Dental Cast-L



+

Layer height  
**50µm/  
0.05 mm**

Settings ✕

+
🗑️

D-Tech Dental Cast Purple, Cast -L

+
🗑️
↻
📄
🔗
🔗

Default

AnyCubic Photon

Phrozen Sonic Mini 8K


Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 4K

	Machine	Resin	Print	Gcode	Advanced
Layer Height:		<input type="text" value="0.050"/>	mm	Bottom Lift Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Bottom Layer Count:		<input type="text" value="6"/>		Lifting Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Exposure Time:		<input style="border: 2px solid black;" type="text" value="6.000"/>	s	Bottom Retract Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Bottom Exposure Time:		<input type="text" value="40.000"/>	s	Retract Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Transition Layer Count:		<input type="text" value="6"/>		Bottom Lift Speed:	<input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min
Transition Type:		<input type="text" value="Linear"/>	▼	Lifting Speed:	<input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min
Transition Time Decrement:		<input type="text" value="4.860"/>	s	Bottom Retract Speed:	<input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min
Waiting Mode During Printing:		<input type="text" value="Light ..."/>	▼	Retract Speed:	<input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min
Light-off Delay:		<input type="text" value="9.000"/>	s		
Bottom Light-off Delay:		<input type="text" value="9.000"/>	s		

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## Phrozen Sonic Mini 4K



+

Surgical Guide



+

Layer height  
**50µm/  
0.05 mm**

Settings ✕

+

D-Tech Surgical Guide

+

Machine


Resin

Print

Gcode


Advanced

Layer Height:	<input type="text" value="0.050"/>	mm	Bottom Lift Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Bottom Layer Count:	<input type="text" value="6"/>		Lifting Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Exposure Time:	<input type="text" value="5.500"/>	s	Bottom Retract Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Bottom Exposure Time:	<input type="text" value="40.000"/>	s	Retract Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Transition Layer Count:	<input type="text" value="6"/>		Bottom Lift Speed:	<input type="text" value="60.000"/>	&	<input type="text" value="0.000"/>	mm/min
Transition Type:	<input type="text" value="Linear"/>	▼	Lifting Speed:	<input type="text" value="60.000"/>	&	<input type="text" value="0.000"/>	mm/min
Transition Time Decrement:	<input type="text" value="4.930"/>	s	Bottom Retract Speed:	<input type="text" value="120.000"/>	&	<input type="text" value="0.000"/>	mm/min
Waiting Mode During Printing:	<input type="text" value="Light ..."/>	▼	Retract Speed:	<input type="text" value="120.000"/>	&	<input type="text" value="0.000"/>	mm/min
Light-off Delay:	<input type="text" value="9.000"/>	s					
Bottom Light-off Delay:	<input type="text" value="9.000"/>	s					

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Phrozen Sonic

**Mini 4K**



+

Crown & Bridge



+

Layer height

**50µm/  
0.05 mm**

Settings ✕

+

D-Tech Crown & Bridge

+

Default

AnyCubic Photon

Phrozen Sonic Mini 8K

Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 4K

Machine

Resin

Print

Gcode

Advanced

Layer Height:  mm

Bottom Layer Count:

Exposure Time:  s

Bottom Exposure Time:  s

Transition Layer Count:

Transition Type:  ▼

Transition Time Decrement:  s

Waiting Mode During Printing:  ▼

Light-off Delay:  s

Bottom Light-off Delay:  s

Bottom Lift Distance:  +  mm

Lifting Distance:  +  mm

Bottom Retract Distance:  +  mm

Retract Distance:  +  mm

Bottom Lift Speed:  &  mm/min

Lifting Speed:  &  mm/min

Bottom Retract Speed:  &  mm/min

Retract Speed:  &  mm/min

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Printer Settings Phrozen

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# Phrozen Sonic Mini 8K



+

Model Pro


Model Std


Model Basic


Model Hard


Layer height  
**50µm/  
0.05 mm**

### Slicing Software - Chitubox V1.9.6

Settings ✕

+ 🗑️

Default

AnyCubic Photon

Phrozen Sonic Mini 8K

Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 4K

D-Tech Model Pro. Model Std, Model Basic, Model Hard
+ 🗑️ ↻ 🔄 📄

Machine	Resin	Print	Advanced
Layer Height:	<input type="text" value="0.050"/> mm	Bottom Lift Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Bottom Layer Count:	<input type="text" value="6"/>	Lifting Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Exposure Time:	<input style="border: 2px solid black;" type="text" value="4.500"/> s	Bottom Retract Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Bottom Exposure Time:	<input type="text" value="40.000"/> s	Retract Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Transition Layer Count:	<input type="text" value="6"/>	Bottom Lift Speed:	<input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min
Transition Type:	<input type="text" value="Linear"/> ▼	Lifting Speed:	<input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min
Transition Time Decrement:	<input type="text" value="5.070"/> s	Bottom Retract Speed:	<input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min
Waiting Mode During Printing:	<input type="text" value="Light ..."/> ▼	Retract Speed:	<input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min
Light-off Delay:	<input type="text" value="9.000"/> s		
Bottom Light-off Delay:	<input type="text" value="9.000"/> s		

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Printer Settings Phrozen

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Phrozen Sonic  
**Mini 8K**



+

Dental Cast Purple



+

Dental Cast-L



+

Layer height  
**50µm/  
0.05 mm**

Settings ✕

+
🗑️

D-Tech Dental Cast Purple, Cast-L

+
🖋️
🗑️
🔄
📧
📄
📄

	Machine	Resin	Print	Advanced
Layer Height:		<input type="text" value="0.050"/> mm		Bottom Lift Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Bottom Layer Count:		<input type="text" value="6"/>		Lifting Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Exposure Time:		<input type="text" value="5.000"/> s		Bottom Retract Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Bottom Exposure Time:		<input type="text" value="40.000"/> s		Retract Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Transition Layer Count:		<input type="text" value="6"/>		Bottom Lift Speed: <input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min
Transition Type:		<input type="text" value="Linear"/> ▼		Lifting Speed: <input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min
Transition Time Decrement:		<input type="text" value="5.000"/> s		Bottom Retract Speed: <input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min
Waiting Mode During Printing:		<input type="text" value="Light ..."/> ▼		Retract Speed: <input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min
Light-off Delay:		<input type="text" value="9.000"/> s		
Bottom Light-off Delay:		<input type="text" value="9.000"/> s		

	Printer settings <b>Phrozen Sonic Mini 8K</b>		Origin Date	22 Jan 2024
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Phrozen Sonic Mini 8K + Surgical Guide + Layer height 50µm/ 0.05 mm




Settings ✕

+

Default

AnyCubic Photon

**Phrozen Sonic Mini 8K**

Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 4K

D-Tech Surgical Guide +

Machine	Resin	Print	Advanced
Layer Height:	<input type="text" value="0.050"/> mm	Bottom Lift Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Bottom Layer Count:	<input type="text" value="6"/>	Lifting Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Exposure Time:	<input type="text" value="4.500"/> s	Bottom Retract Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Bottom Exposure Time:	<input type="text" value="40.000"/> s	Retract Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm
Transition Layer Count:	<input type="text" value="6"/>	Bottom Lift Speed:	<input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min
Transition Type:	Linear ▼	Lifting Speed:	<input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min
Transition Time Decrement:	<input type="text" value="5.070"/> s	Bottom Retract Speed:	<input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min
Waiting Mode During Printing:	Light ... ▼	Retract Speed:	<input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min
Light-off Delay:	<input type="text" value="9.000"/> s		
Bottom Light-off Delay:	<input type="text" value="9.000"/> s		

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Phrozen Sonic

**Mini 8K**



+

Crown & Bridge



+

Layer height

**50µm/  
0.05 mm**

Settings ✕

+
🗑️

D-Tech Crown & Bridge

+
🖋️
🗑️
🔄
📄
📄
📄

Machine

Resin

Print

Advanced

Default


AnyCubic Photon

Phrozen Sonic Mini 8K

Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 4K

Layer Height:	0.050	mm	Bottom Lift Distance:	5.000	+	0.000	mm
Bottom Layer Count:	6		Lifting Distance:	5.000	+	0.000	mm
Exposure Time:	5.000	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	&	0.000	mm/min
Transition Type:	Linear	▼	Lifting Speed:	60.000	&	0.000	mm/min
Transition Time Decrement:	5.000	s	Bottom Retract Speed:	120.000	&	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					

	<b>Printer settings</b> <b>Phrozen Sonic Mighty 4K</b>		Origin Date	22 Jan 2024
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**Phrozen Sonic  
Mighty 4K**



+

Model Basic




+

Layer height  
**50µm/  
0.05 mm**

*Slicing Software - Chitubox V1.9.6*

Settings ✕

+ 

Default

AnyCubic Photon








Phrozen Sonic Mini 8K

Phrozen Sonic Mighty 4K


D-Tech Model Basic

Machine
Resin
Print
Gcode
Advanced

<p>Layer Height: <input type="text" value="0.050"/> mm</p> <p>Bottom Layer Count: <input type="text" value="6"/></p> <p>Exposure Time: <input style="border: 2px solid black;" type="text" value="4.500"/> s</p> <p>Bottom Exposure Time: <input type="text" value="40.000"/> s</p> <p>Transition Layer Count: <input type="text" value="6"/></p> <p>Transition Type: <input type="text" value="Linear"/> ▼</p> <p>Transition Time Decrement: <input type="text" value="5.070"/> s</p> <p>Waiting Mode During Printing: <input type="text" value="Light ..."/> ▼</p> <p>Light-off Delay: <input type="text" value="12.000"/> s</p> <p>Bottom Light-off Delay: <input type="text" value="12.000"/> s</p>	<p>Bottom Lift Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm</p> <p>Lifting Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm</p> <p>Bottom Retract Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm</p> <p>Retract Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm</p> <p>Bottom Lift Speed: <input type="text" value="60.000"/> &amp; <input type="text" value="0.000"/> mm/min</p> <p>Lifting Speed: <input type="text" value="60.000"/> &amp; <input type="text" value="0.000"/> mm/min</p> <p>Bottom Retract Speed: <input type="text" value="120.000"/> &amp; <input type="text" value="0.000"/> mm/min</p> <p>Retract Speed: <input type="text" value="120.000"/> &amp; <input type="text" value="0.000"/> mm/min</p>
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Phrozen Sonic  
**Mighty 4K**



+

Model Basic



+


Layer height  
**100µm/  
0.1 mm**

Settings ✕

D-Tech Model Basic 100 micron

Machine    Resin    **Print**    Gcode    Advanced

<p>Layer Height: <input type="text" value="0.100"/> mm</p> <p>Bottom Layer Count: <input type="text" value="6"/></p> <p>Exposure Time: <input style="border: 2px solid black;" type="text" value="6.700"/> s</p> <p>Bottom Exposure Time: <input type="text" value="40.000"/> s</p> <p>Transition Layer Count: <input type="text" value="6"/></p> <p>Transition Type: <input type="text" value="Linear"/> ▼</p> <p>Transition Time Decrement: <input type="text" value="4.760"/> s</p> <p>Waiting Mode During Printing: <input type="text" value="Light ..."/> ▼</p> <p>Light-off Delay: <input type="text" value="12.000"/> s</p> <p>Bottom Light-off Delay: <input type="text" value="12.000"/> s</p>	<p>Bottom Lift Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm</p> <p>Lifting Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm</p> <p>Bottom Retract Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm</p> <p>Retract Distance: <input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm</p> <p>Bottom Lift Speed: <input type="text" value="60.000"/> &amp; <input type="text" value="0.000"/> mm/min</p> <p>Lifting Speed: <input type="text" value="60.000"/> &amp; <input type="text" value="0.000"/> mm/min</p> <p>Bottom Retract Speed: <input type="text" value="120.000"/> &amp; <input type="text" value="0.000"/> mm/min</p> <p>Retract Speed: <input type="text" value="120.000"/> &amp; <input type="text" value="0.000"/> mm/min</p>
---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

	Printer settings		Origin Date	22 Jan 2024
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Phrozen Sonic  
Mighty 4K



+

Surgical Guide



+

Layer height  
50µm/  
**0.05 mm**

Settings ✕

+
🗑️

D-Tech Surgical Guide

+
🖋️
🗑️
🔄
📄
📁
🔗


Default

AnyCubic Photon

Phrozen Sonic Mini 8K

Phrozen Sonic Mighty 4K

Machine	Resin	Print	Gcode	Advanced
Layer Height:	<input type="text" value="0.050"/> mm	Bottom Lift Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm	
Bottom Layer Count:	<input type="text" value="6"/>	Lifting Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm	
Exposure Time:	<input style="border: 2px solid black;" type="text" value="4.500"/> s	Bottom Retract Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm	
Bottom Exposure Time:	<input type="text" value="40.000"/> s	Retract Distance:	<input type="text" value="5.000"/> + <input type="text" value="0.000"/> mm	
Transition Layer Count:	<input type="text" value="6"/>	Bottom Lift Speed:	<input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min	
Transition Type:	<input type="text" value="Linear"/> ▼	Lifting Speed:	<input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min	
Transition Time Decrement:	<input type="text" value="5.070"/> s	Bottom Retract Speed:	<input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min	
Waiting Mode During Printing:	<input type="text" value="Light ..."/> ▼	Retract Speed:	<input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min	
Light-off Delay:	<input type="text" value="12.000"/> s			
Bottom Light-off Delay:	<input type="text" value="12.000"/> s			

	<b>Printer settings</b> <b>Phrozen Sonic Mighty 4K</b>		Origin Date	22 Jan 2024
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Phrozen Sonic  
**Mighty 4K**



+

Dental Cast-L



+

Layer height  
**50µm/  
0.05 mm**

Settings ✕

+

-

D-Tech Dental Cast-L 50 µm

+

✎

-

↻

✉

📄

📄

Machine

Resin

Print

Gcode


Advanced

Layer Height:	<input type="text" value="0.050"/>	mm	Bottom Lift Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Bottom Layer Count:	<input type="text" value="6"/>		Lifting Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Exposure Time:	<input style="border: 2px solid black;" type="text" value="5.000"/>	s	Bottom Retract Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Bottom Exposure Time:	<input type="text" value="30.000"/>	s	Retract Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="0.000"/>	mm
Transition Layer Count:	<input type="text" value="6"/>		Bottom Lift Speed:	<input type="text" value="60.000"/>	&	<input type="text" value="0.000"/>	mm/min
Transition Type:	<input type="text" value="Linear"/>	▼	Lifting Speed:	<input type="text" value="60.000"/>	&	<input type="text" value="0.000"/>	mm/min
Transition Time Decrement:	<input type="text" value="3.570"/>	s	Bottom Retract Speed:	<input type="text" value="120.000"/>	&	<input type="text" value="0.000"/>	mm/min
Waiting Mode During Printing:	<input type="text" value="Light ..."/>	▼	Retract Speed:	<input type="text" value="120.000"/>	&	<input type="text" value="0.000"/>	mm/min
Light-off Delay:	<input type="text" value="12.000"/>	s					
Bottom Light-off Delay:	<input type="text" value="12.000"/>	s					

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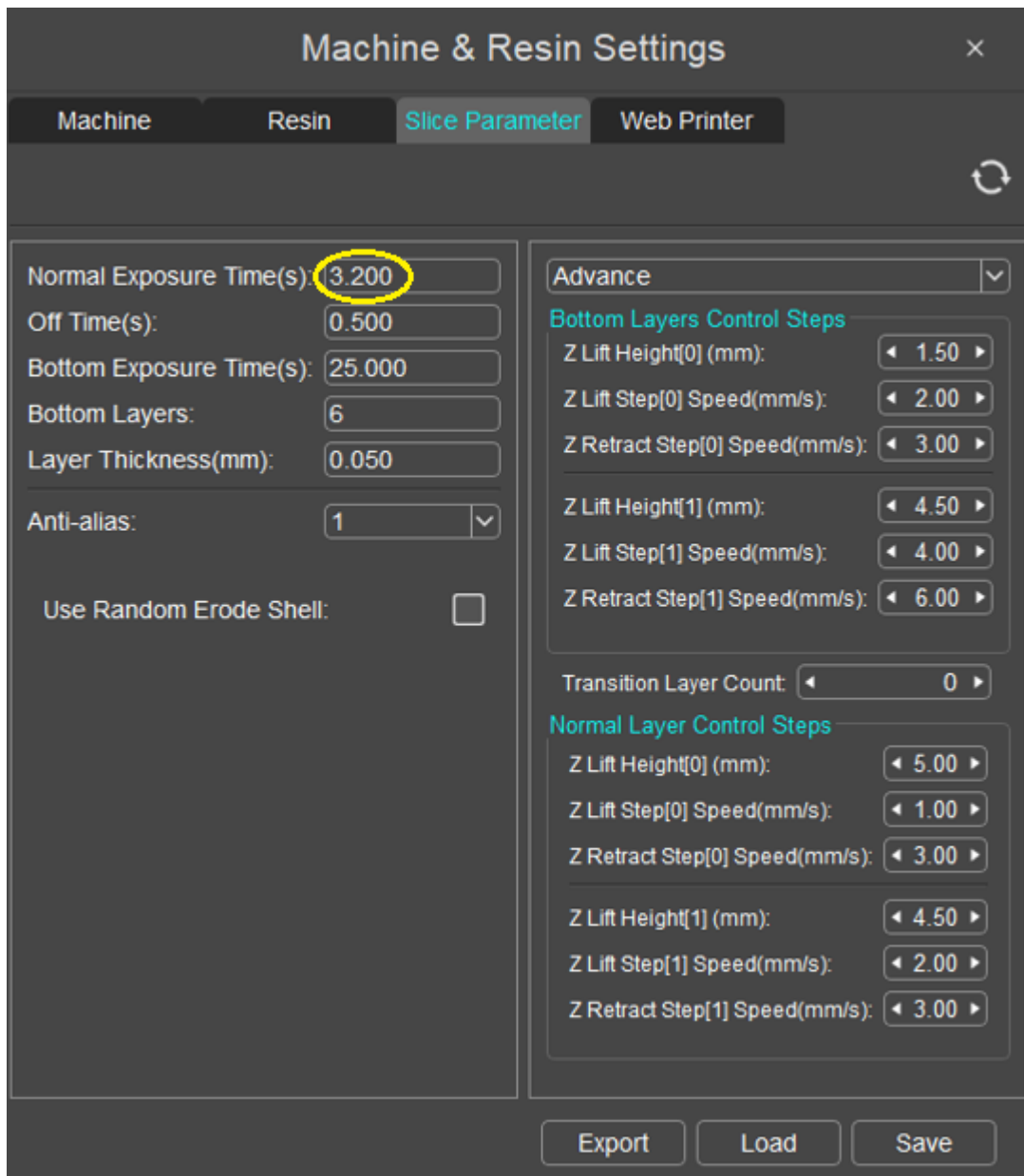
Printer Settings Phrozen


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Anycubic Photon Mono 4K
 
 +
 
 Model Pro
 
 Model Std
 
 Model Basic
 +
 Layer height  
 50µm/  
**0.05 mm**

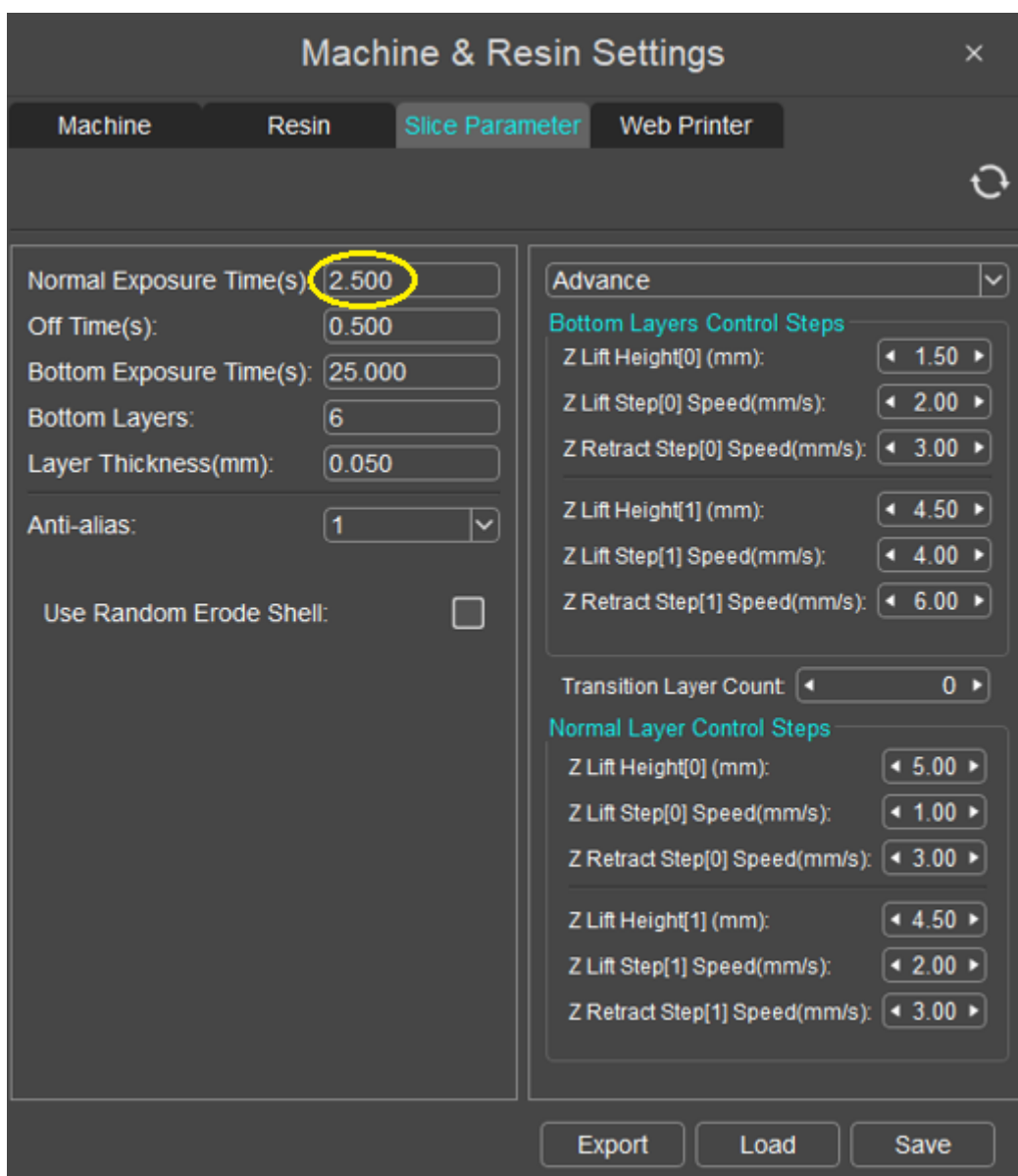
*Slicing Software – Anycubic photon workshop V2.2.16*



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**Anycubic Photon Mono 4K**

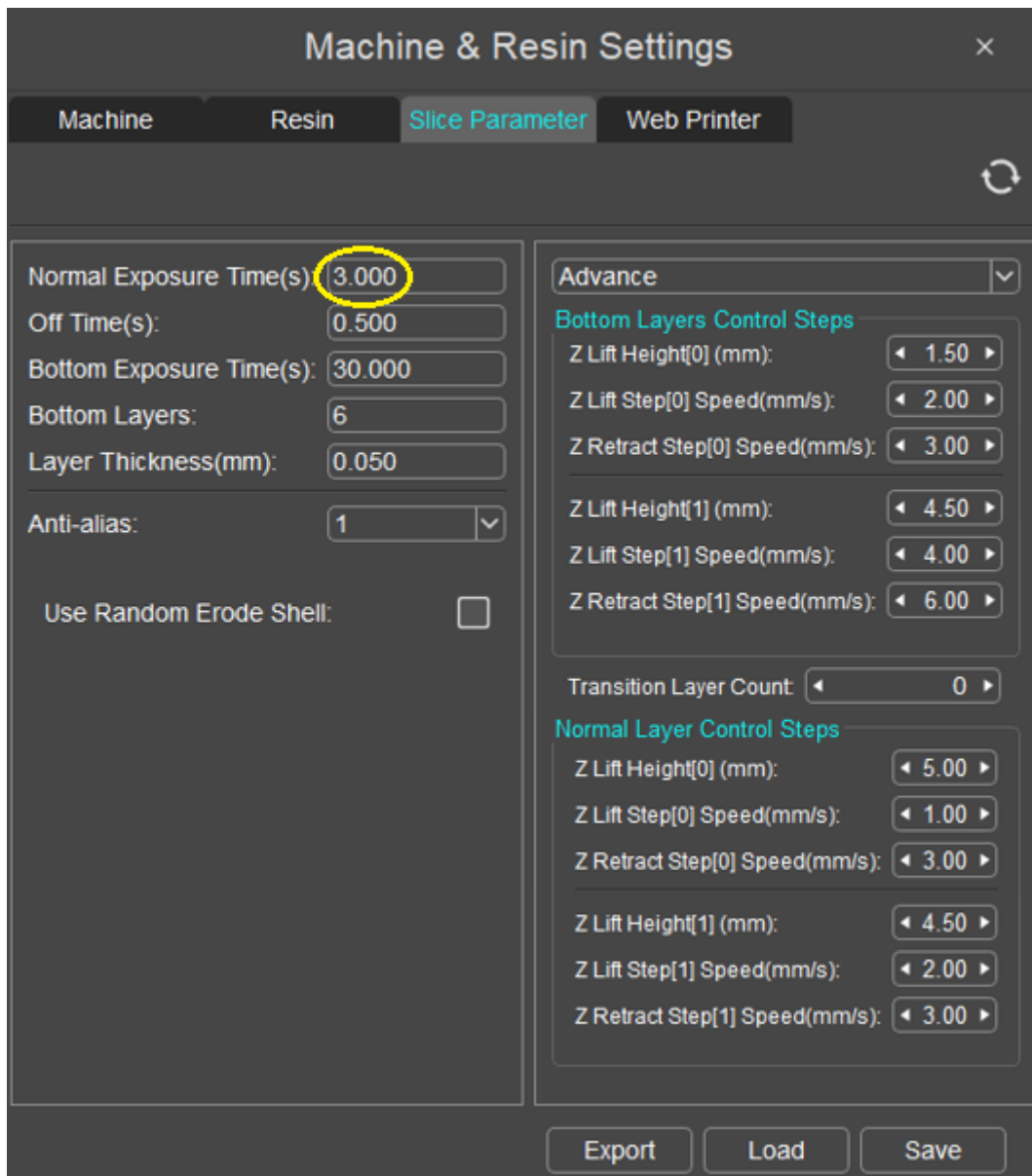
 +
 
 +
 Layer height  
**50µm/ 0.05 mm**




	<b>Printer settings</b> <b>Anycubic Photon Mono 4K</b>		Origin Date	22 Jan 2024
			Revision Date	06 Feb 2024
	QMS/PS/Anycubic/Mono4K	Revision No:01	No. of Pages	Page 3 of 5

**Anycubic Photon Mono 4K**

 +
 
 Dental Cast Purple
 +
 
 Dental Cast-L
 +
 Layer height  
**50µm/ 0.05 mm**



	<b>Printer settings</b> <b>Anycubic Photon</b> <b>Mono 4K</b>		Origin Date	22 Jan 2024
			Revision Date	06 Feb 2024
	QMS/PS/Anycubic/Mono4K	Revision No:01	No. of Pages	Page 4 of 5

**Anycubic**  
**Photon Mono**  
**4K**



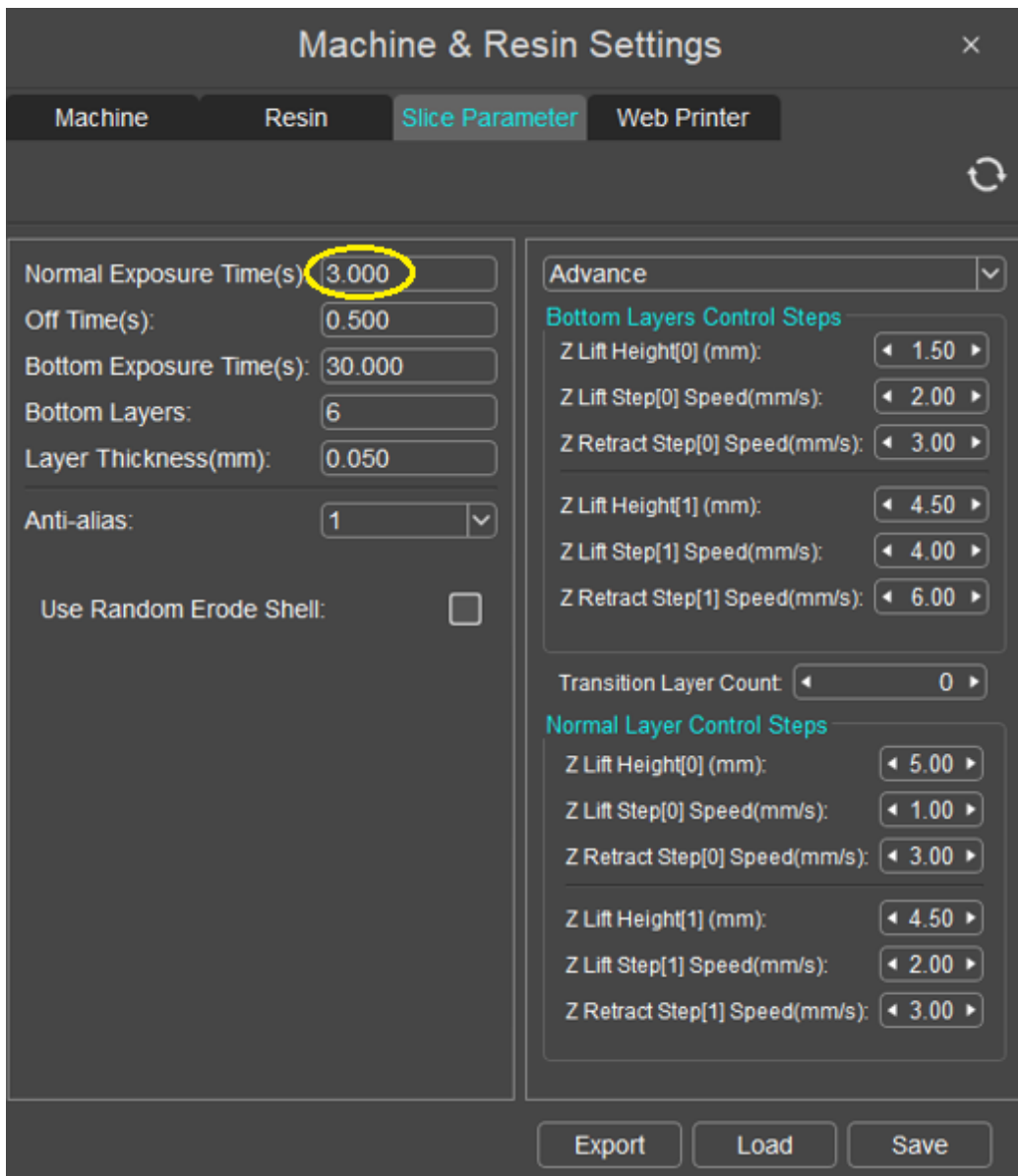
+


Surgical Guide




+

Layer height  
**50µm/**  
**0.05 mm**




	<b>Printer settings</b> <b>Anycubic Photon Mono 4K</b>		Origin Date	22 Jan 2024
			Revision Date	06 Feb 2024
	QMS/PS/Anycubic/Mono4K	Revision No:01	No. of Pages	Page <b>5</b> of <b>5</b>

Anycubic Photon Mono 4K


+

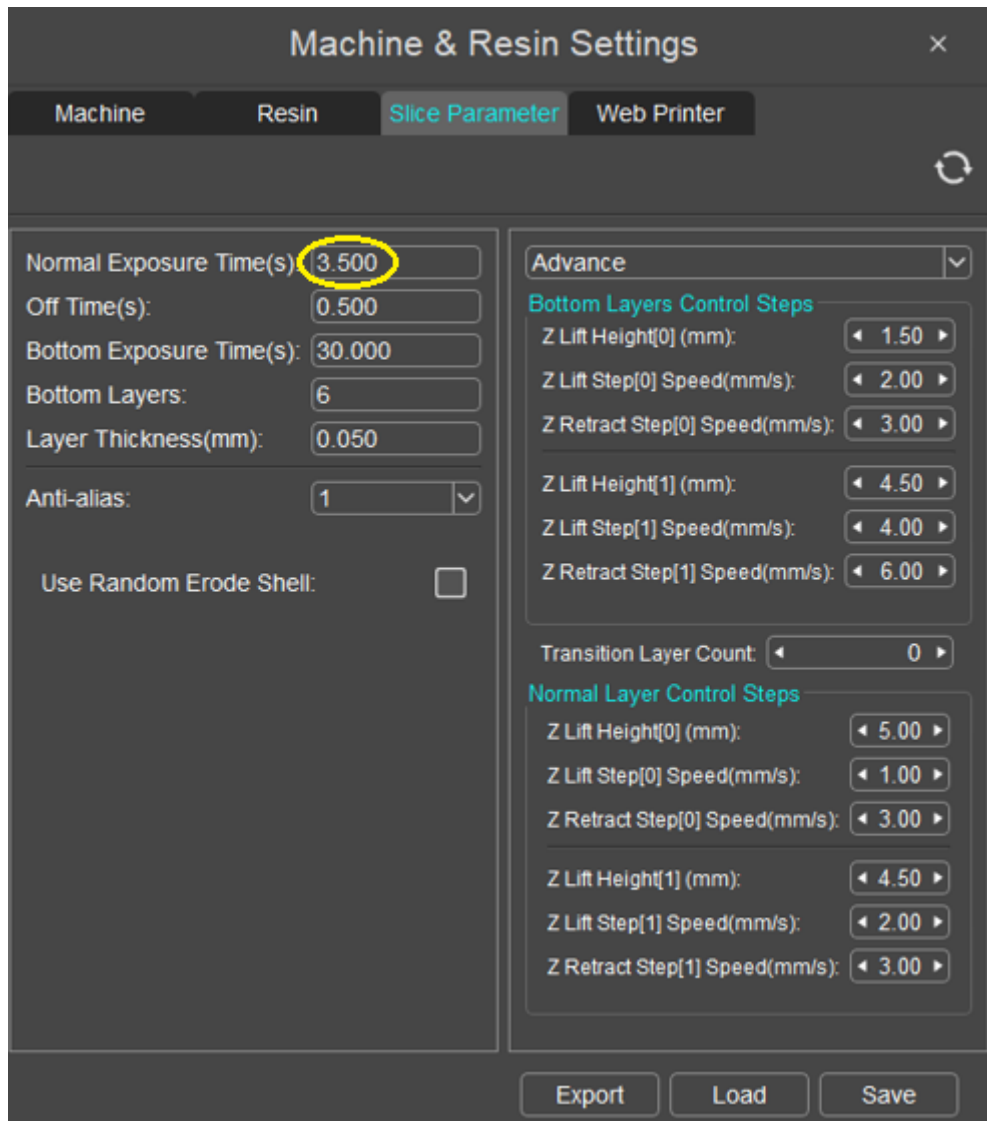
Crown & Bridge




+

Layer height

50µm/  
0.05 mm





	<b>Printer settings</b> <b>Elegoo Saturn 2 8K</b>		Origin Date	22 Jan 2024
			Revision Date	07 Feb 2024
	QMS/PS/Elegoo /8K	Revision No:00	No. of Pages	Page 1 of 2

Elegoo Saturn  
**2 8K**



+

Model Std



+

Model Basic



+

Layer height  
**50µm/  
0.05 mm**

*Slicing Software - Chitobox V1.9.6*

Settings ✕

+
🗑️

D-Tech Model Std, Model Basic

+
✎
🗑️
🔄
📄
🔗
🔗

Machine


Resin

Print

Gcode

Advanced

Layer Height:	<input type="text" value="0.050"/>	mm	Bottom Lift Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="4.000"/>	mm
Bottom Layer Count:	<input type="text" value="6"/>		Lifting Distance:	<input type="text" value="5.000"/>	+	<input type="text" value="4.000"/>	mm
Exposure Time:	<input style="border: 2px solid black;" type="text" value="5.500"/>	s	Bottom Retract Distance:	<input type="text" value="7.500"/>	+	<input type="text" value="1.500"/>	mm
Bottom Exposure Time:	<input type="text" value="40.000"/>	s	Retract Distance:	<input type="text" value="7.500"/>	+	<input type="text" value="1.500"/>	mm
Transition Layer Count:	<input type="text" value="6"/>		Bottom Lift Speed:	<input type="text" value="60.000"/>	&	<input type="text" value="180.000"/>	mm/min
Transition Type:	<input type="text" value="Linear"/>	▼	Lifting Speed:	<input type="text" value="60.000"/>	&	<input type="text" value="180.000"/>	mm/min
Transition Time Decrement:	<input type="text" value="4.930"/>	s	Bottom Retract Speed:	<input type="text" value="120.000"/>	&	<input type="text" value="65.000"/>	mm/min
Waiting Mode During Printing:	<input type="text" value="Light ..."/>	▼	Retract Speed:	<input type="text" value="120.000"/>	&	<input type="text" value="65.000"/>	mm/min
Light-off Delay:	<input type="text" value="9.000"/>	s					
Bottom Light-off Delay:	<input type="text" value="9.000"/>	s					

	<b>Printer settings</b> <b>Elegoo Saturn 2 8K</b>		Origin Date	22 Jan 2024
			Revision Date	07 Feb 2024
	QMS/PS/Elegoo /8K	Revision No:00	No. of Pages	Page 2 of 2

## Elegoo Saturn 2 8K



+

Dental Cast Purple



+

Dental Cast-L



+

Layer height  
50µm/  
**0.05 mm**

Settings ✕

+
🗑️

D-Tech Dental Cast Purple, Cast-L

+
✍️
🗑️
🔄
📧
📄
📄

Default

AnyCubic Photon

Phrozen Sonic Mini 8K

Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 4K

ELEGOO SATURN 2

	Machine	Resin	Print	Gcode	Advanced
Layer Height:		<input type="text" value="0.050"/> mm		Bottom Lift Distance:	<input type="text" value="5.000"/> + <input type="text" value="4.000"/> mm
Bottom Layer Count:		<input type="text" value="6"/>		Lifting Distance:	<input type="text" value="5.000"/> + <input type="text" value="4.000"/> mm
Exposure Time:		<input style="border: 2px solid black;" type="text" value="4.500"/> s		Bottom Retract Distance:	<input type="text" value="7.500"/> + <input type="text" value="1.500"/> mm
Bottom Exposure Time:		<input type="text" value="40.000"/> s		Retract Distance:	<input type="text" value="7.500"/> + <input type="text" value="1.500"/> mm
Transition Layer Count:		<input type="text" value="6"/>		Bottom Lift Speed:	<input type="text" value="60.000"/> & <input type="text" value="180.000"/> mm/min
Transition Type:		<input type="text" value="Linear"/> ▼		Lifting Speed:	<input type="text" value="60.000"/> & <input type="text" value="180.000"/> mm/min
Transition Time Decrement:		<input type="text" value="5.070"/> s		Bottom Retract Speed:	<input type="text" value="120.000"/> & <input type="text" value="65.000"/> mm/min
Waiting Mode During Printing:		<input type="text" value="Light ..."/> ▼		Retract Speed:	<input type="text" value="120.000"/> & <input type="text" value="65.000"/> mm/min
Light-off Delay:		<input type="text" value="9.000"/> s			
Bottom Light-off Delay:		<input type="text" value="9.000"/> s			