

SAMPLE PRINT REFERENCE - CURE TIME SETTING



G3D\_MAX\_BUILD\_SIZE\_XY175umZ120um.g3d  
Cure Time: 70-3-14



G3D\_ROOK\_XY175umZ120um.g3d  
Cure Time: 70-3-10



G3D\_BOY\_XY175umZ120um.g3d  
Cure Time: 70-3-10



G3D\_MODEL\_HOUSE\_XY175umZ120um.g3d  
Cure Time: 70-3-10

# STD CLEAR 101V5



## RESIN TIME SETTING

PROJECTOR SET		LAYER THICKNESS (µm)	INITIAL LAYER CURE TIME (seconds)	NUMBER OF INITIAL LAYER	LAYERS CURE TIME (seconds)
175	Lowest Resolution	120 - 97.5	60 - 70	3	8 - 12
		90 - 67.5	60 - 70	3	8 - 12
		60 - 37.5	60 - 70	3	7 - 10
		30 - 7.5 Highest resolution	60 - 70	3	7 - 8
150	Lowest Resolution	120 - 97.5	50 - 60	3	6 - 9
		90 - 67.5	50 - 60	3	6 - 9
		60 - 37.5	50 - 60	3	6 - 8
		30 - 7.5 Highest resolution	50 - 60	3	6 - 7
125	Lowest Resolution	120 - 97.5	40 - 50	3	5 - 8
		90 - 67.5	40 - 50	3	5 - 8
		60 - 37.5	40 - 50	3	5 - 6
		30 - 7.5 Highest resolution	40 - 50	3	5 - 6
100	Lowest Resolution	120 - 97.5	35 - 40	3	4 - 8
		90 - 67.5	35 - 40	3	4 - 8
		60 - 37.5	35 - 40	3	4 - 7
		30 - 7.5 Highest resolution	35 - 40	3	4 - 7

## RESIN TIME SETTING

PROJECTOR SET		LAYER THICKNESS (µm)	INITIAL LAYER CURE TIME (seconds)	NUMBER OF INITIAL LAYER	LAYERS CURE TIME (seconds)
175	Lowest Resolution	120 - 97.5	60 - 70	3	7 - 12
		90 - 67.5	60 - 70	3	7 - 12
		60 - 37.5	60 - 70	3	7 - 10
		30 - 7.5 Highest resolution	60 - 70	3	7 - 10
150	Lowest Resolution	120 - 97.5	55 - 65	3	7 - 10
		90 - 67.5	55 - 65	3	7 - 10
		60 - 37.5	55 - 65	3	7 - 8
		30 - 7.5 Highest resolution	55 - 65	3	7 - 8
125	Lowest Resolution	120 - 97.5	40 - 50	3	6 - 8
		90 - 67.5	40 - 50	3	6 - 8
		60 - 37.5	40 - 50	3	6 - 7
		30 - 7.5 Highest resolution	40 - 50	3	6 - 7
100	Lowest Resolution	120 - 97.5	35 - 40	3	3 - 7
		90 - 67.5	35 - 40	3	3 - 7
		60 - 37.5	35 - 40	3	3 - 6
		30 - 7.5 Highest resolution	35 - 40	3	3 - 6

Optimal Settings for T-1000 3D Printer (resin label)

# STD YELLOW T 102V1



## RESIN TIME SETTING

PROJECTOR SET		LAYER THICKNESS (µm)	INITIAL LAYER CURE TIME (seconds)	NUMBER OF INITIAL LAYER	LAYERS CURE TIME (seconds)
175	Lowest Resolution	120 - 97.5	60 - 70	3	7 - 12
		90 - 67.5	60 - 70	3	7 - 12
	60 - 37.5	60 - 70	3	7 - 10	
	30 - 7.5 Highest resolution	60 - 70	3	7 - 10	
150	Lowest Resolution	120 - 97.5	55 - 65	3	7 - 10
		90 - 67.5	55 - 65	3	7 - 10
	60 - 37.5	55 - 65	3	7 - 8	
	30 - 7.5 Highest resolution	55 - 65	3	7 - 8	
125	Lowest Resolution	120 - 97.5	40 - 50	3	6 - 8
		90 - 67.5	40 - 50	3	6 - 8
	60 - 37.5	40 - 50	3	6 - 7	
	30 - 7.5 Highest resolution	40 - 50	3	6 - 7	
100	Lowest Resolution	120 - 97.5	35 - 40	3	3 - 7
		90 - 67.5	35 - 40	3	3 - 7
	60 - 37.5	35 - 40	3	3 - 6	
	30 - 7.5 Highest resolution	35 - 40	3	3 - 6	

Optimal Settings for T-1000 3D Printer (resin label)

# STD BLUE T 104V1



## RESIN TIME SETTING

PROJECTOR SET		LAYER THICKNESS (µm)	INITIAL LAYER CURE TIME (seconds)	NUMBER OF INITIAL LAYER	LAYERS CURE TIME (seconds)
175	Lowest Resolution	120 - 97.5	60 - 70	3	7 - 12
		90 - 67.5	60 - 70	3	7 - 12
		60 - 37.5	60 - 70	3	7 - 10
		30 - 7.5 Highest resolution	60 - 70	3	7 - 10
150	Lowest Resolution	120 - 97.5	55 - 65	3	7 - 10
		90 - 67.5	55 - 65	3	7 - 10
		60 - 37.5	55 - 65	3	7 - 8
		30 - 7.5 Highest resolution	55 - 65	3	7 - 8
125	Lowest Resolution	120 - 97.5	40 - 50	3	6 - 8
		90 - 67.5	40 - 50	3	6 - 8
		60 - 37.5	40 - 50	3	6 - 7
		30 - 7.5 Highest resolution	40 - 50	3	6 - 7
100	Lowest Resolution	120 - 97.5	35 - 40	3	3 - 7
		90 - 67.5	35 - 40	3	3 - 7
		60 - 37.5	35 - 40	3	3 - 6
		30 - 7.5 Highest resolution	35 - 40	3	3 - 6

# STD GRAY T 107V1

## RESIN TIME SETTING

PROJECTOR SET		LAYER THICKNESS (µm)	INITIAL LAYER CURE TIME (seconds)	NUMBER OF INITIAL LAYER	LAYERS CURE TIME (seconds)
175	Lowest Resolution	120 - 97.5	70 - 80	3	10 - 14
		90 - 67.5	70 - 80	3	10 - 14
		60 - 37.5	60 - 70	3	8 - 12
		30 - 7.5 Highest resolution	60 - 70	3	8 - 12
150	Lowest Resolution	120 - 97.5	60 - 70	3	9 - 12
		90 - 67.5	60 - 70	3	9 - 12
		60 - 37.5	55 - 65	3	8 - 10
		30 - 7.5 Highest resolution	55 - 65	3	8 - 10
125	Lowest Resolution	120 - 97.5	55 - 65	3	8 - 10
		90 - 67.5	55 - 65	3	8 - 10
		60 - 37.5	45 - 55	3	7 - 8
		30 - 7.5 Highest resolution	45 - 55	3	7 - 8
100	Lowest Resolution	120 - 97.5	45 - 55	3	4 - 7
		90 - 67.5	45 - 55	3	4 - 7
		60 - 37.5	35 - 40	3	4 - 6
		30 - 7.5 Highest resolution	35 - 40	3	4 - 6