





3DR Settings Guidance on Anycubic Photon Mono 4K



Anycubic Photon Mono 4k Phrozen Cure V2

Resin	Settings	50 Micron	Guidance
 Model Pro	INI	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (Photon Workshop V 2.1.3) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	3.2	
	Base Exposure (s)	25	
 Model Standard	INI	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (Photon Workshop V 2.1.30) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	3.2	
	Base Exposure (s)	25	
 Model Hard	INI	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (Photon Workshop V 2.1.3) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	3	
	Base Exposure (s)	30	
 Dental Cast	INI	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (Photon Workshop V 2.1.3) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	3	
	Base Exposure (s)	30	
 Surgical Guide	INI	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (Photon Workshop V 2.1.3) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	3.2	
	Base Exposure (s)	25	
 Crown & Bridge	INI	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (Photon Workshop V 2.1.3) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	3.5	
	Base Exposure (s)	30	