

3DR Settings Guidance on Phrozen Sonic Mini 4K

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Phrozen Mini 4K



Phrozen cure V2

Resin	Settings	50 Micron	100 Micron	Guidance
 Model Pro	INI	Manual Setting	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (chitubox 1.9.0) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	5.5	5.5	
	Base Exposure (s)	40	40	
 Model Standard	INI	Manual Setting	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (chitubox 1.9.0) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	5.5	5.5	
	Base Exposure (s)	40	40	
 Model Hard	INI	Manual Setting	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (chitubox 1.9.0) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	4.5	6.75	
	Base Exposure (s)	35	40	
 Dental Cast	INI	Manual Setting	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (chitubox 1.9.0) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	6	9	
	Base Exposure (s)	40	50	
 Surgical Guide	INI	Manual Setting	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (chitubox 1.9.0) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	5.5	9	
	Base Exposure (s)	40	50	
 Crown & Bridge	INI	Manual Setting	Manual Setting	Step 1 - Enter manual settings in Slicing Software i.e (chitubox 1.9.0) Step 2 - Post Cure in Phrozen Cure V2 UV Post Curing Lamp for 30 mins.
	Layer Exposure (s)	6	9	
	Base Exposure (s)	40	50	