



3D ACCUPRINT™

Authorised Distributor



3D PRINTER SETTINGS

Asiga Max UV 385

Ackuretta Sol

Shining 3D L4K

Phrozen Sonic Mini 4K

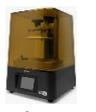
Phrozen Sonic Mini 8K

Phrozen Sonic Mighty 4K

Anycubic Photon Mono 4K

Elegoo Saturn 2 8K

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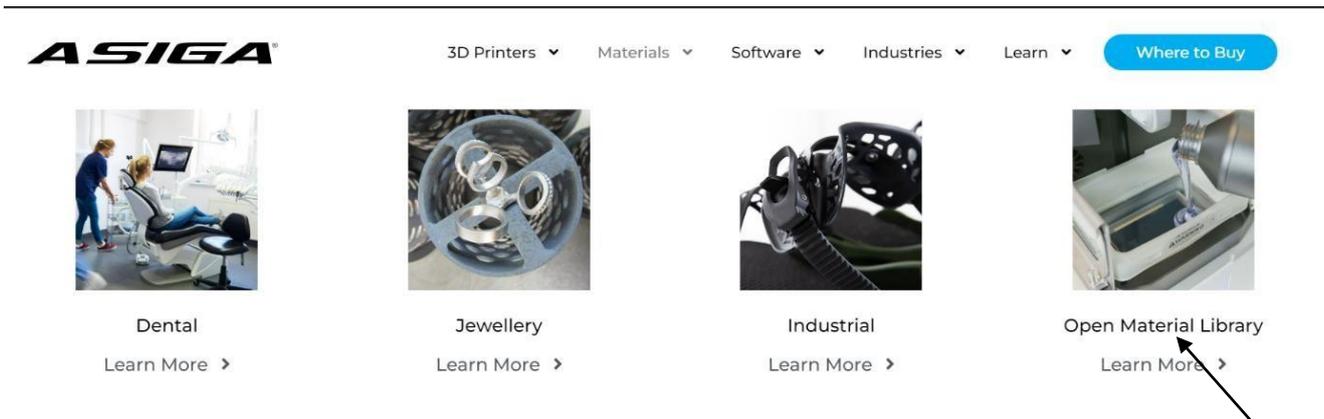
Sr. No	Printer Models	Model Pro 	Model Std 	Model Basic 	Model Hard 	Dental Cast 	Cast-L 	C&B/C&B Pro 	Surgical Guide 
1	 Asiga Max UV 385	✓	✓	✓	X	✓	X	✓	✓
		50 to 150	50 to 150	50 to 150	NA	50 to 150	NA	50 to 150	50 to 150
2	 Ackuretta SOL	X	✓	✓	X	✓	X	✓	✓
		NA	50 to 150	50 to 150	NA	50 to 150	NA	70 to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

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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.



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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

- Download the ini file to your computer
- Import them in Asiga composer software (check for latest version of software)

	Printer settings Ackuretta SOL		Origin Date	22 Jan 2024
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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"/> C&B	Fine
<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"/> SOL Large L BP	<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"/> d-tech		

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	Fine
<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"/> Model Standard	Fast
<input checked="" type="radio"/> SOL Large L BP	<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"/> d-tech		

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	Fine
<input type="radio"/> FreeShape 120 - May 2019	<input type="radio"/> VOCO	<input checked="" type="radio"/> Model Basic	Standard
<input type="radio"/> DENTIQ	<input type="radio"/> WhipMix	<input type="radio"/> Model Standard	Fast
<input checked="" type="radio"/> SOL Large L BP	<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"/> d-tech		

Name ⊕ ⊖ 📄 Import Export

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"/>			

Apply

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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"/> Dental Cast	Fine
<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"/> SOL Large L BP	<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"/> d-tech		

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	Fine
<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"/> SOL Large L BP	<input type="radio"/> YAMAHACHI	<input checked="" 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"/> d-tech		

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.

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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 Series
AccuFab-L4K

Printer Serial No.
L4K1AP310-gjBB048F21

Material Brand
Shining3D

Material Name
[Shining3D]DM03-0.05

Support Name
die support

Reset Current

Save Current

Reset All

Save All

Printer
Material
Support

Layer Counts:	5	27	0
Exposure Level:	High Power Mode	High Power Mode	Mid Power Mode
Fill Exposure Time (s):	11.00	5.00	4.00
Boundary Exposure Time (s):	5.00	3.00	4.00
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

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**

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Shining 3D L4K



+

Model Pro



Model Std



Model Basic



+

Layer height
**100µm/
0.1 mm**

Material Manager

Printer Series

AccuFab-L4K

Printer Serial No.

L4K1AP310-GjBB048F21

Material Brand

Shining3D

Material Name

[Shining3D]DM03-0.1

Support Name

die support

Reset Current

Save Current

Reset All

Save All

Printer
Material
Support

	Enhanced Layer	Medium Layer	General Layer
Layer Counts:	5	27	0
Exposure Level:	High Power Mode	High Power Mode	High Power Mode
Fill Exposure Time (s):	18.40	9.20	5.10
Boundary Exposure Time (s):	4.60	4.60	5.10
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

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

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

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Shining
3D L4K



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Surgical Guide



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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.

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Shining 3D L4K + Crown & Bridge + Layer height 50µm/ 0.05 mm

Material Manager

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

Printer | **Material** | Support

	Limboless 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.

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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
✕

D-Tech Model Pro, Model Std.

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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Phrozen Sonic Mini 4K



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Model Hard



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Layer height
**50µm/
0.05 mm**

Settings
✕

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D-Tech Model Hard

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🗑️
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📄
📄

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					

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Phrozen Sonic Mini 4K



+

Dental Cast Purple



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Dental Cast-L



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Layer height
**50µm/
0.05 mm**

Settings
✕

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🗑️

D-Tech Dental Cast Purple, Cast -L

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🗑️
↻
📄
🔗

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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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					

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

Mini 4K



+

Crown & Bridge



+

Layer height

**50µm/
0.05 mm**

Settings ✕

+

D-Tech Crown & Bridge

+

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:	6.000	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:	4.860	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					

	Printer settings Phrozen Sonic Mini 8K		Origin Date	22 Jan 2024
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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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	Printer settings Phrozen Sonic Mini 8K		Origin Date	22 Jan 2024
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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 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="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		

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Phrozen Sonic Mini 8K



+

Surgical Guide



+

Layer height
**50µm/
0.05 mm**

Settings ✕

+

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 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					

	Printer settings Phrozen Sonic Mini 8K		Origin Date	22 Jan 2024
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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					

	Printer settings Phrozen Sonic Mighty 4K		Origin Date	22 Jan 2024
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QMS/PS/Phrozen/MT04	Revision No:02	No. of Pages	Page 1 of 4	

**Phrozen Sonic
Mighty 4K**



+

Model Basic



+

Layer height
**50µm/
0.05 mm**

Slicing Software - Chitobox V1.9.6

Settings ✕

+

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"/> & <input type="text" value="0.000"/> mm/min</p> <p>Lifting Speed: <input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min</p> <p>Bottom Retract Speed: <input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min</p> <p>Retract Speed: <input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min</p>
---	---

	Printer settings Phrozen Sonic Mighty 4K		Origin Date	22 Jan 2024
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QMS/PS/Phrozen/MT04	Revision No:02	No. of Pages	Page 2 of 4	

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"/> & <input type="text" value="0.000"/> mm/min</p> <p>Lifting Speed: <input type="text" value="60.000"/> & <input type="text" value="0.000"/> mm/min</p> <p>Bottom Retract Speed: <input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min</p> <p>Retract Speed: <input type="text" value="120.000"/> & <input type="text" value="0.000"/> mm/min</p>
---	---

	Printer settings Phrozen Sonic Mighty 4K		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
+
✎
🗑️
↻
📧
📄

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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	Printer settings Phrozen Sonic Mighty 4K		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

+

✎

-

↻

✉

📄

📄

Default

AnyCubic Photon

Phrozen Sonic Mini 8K

Phrozen Sonic Mighty 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

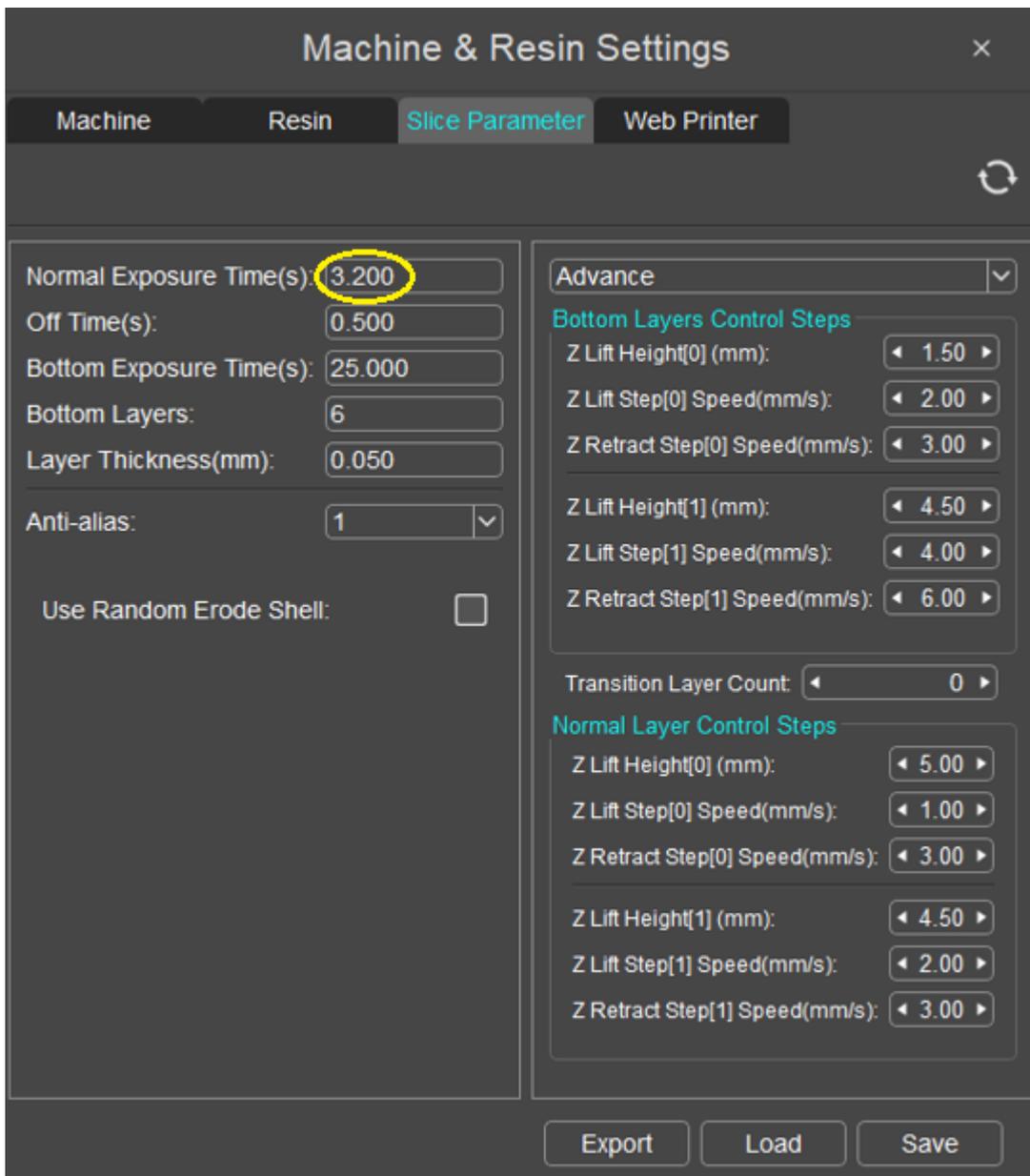
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	Printer settings Anycubic Photon Mono 4K		Origin Date	22 Jan 2024
			Revision Date	06 Feb 2024
	QMS/PS/Anycubic/Mono4K	Revision No:01	No. of Pages	Page 1 of 5

Anycubic Photon Mono 4K

 +
 
 Model Pro
 
 Model Std
 
 Model Basic
 +
 Layer height
50µm/ 0.05 mm

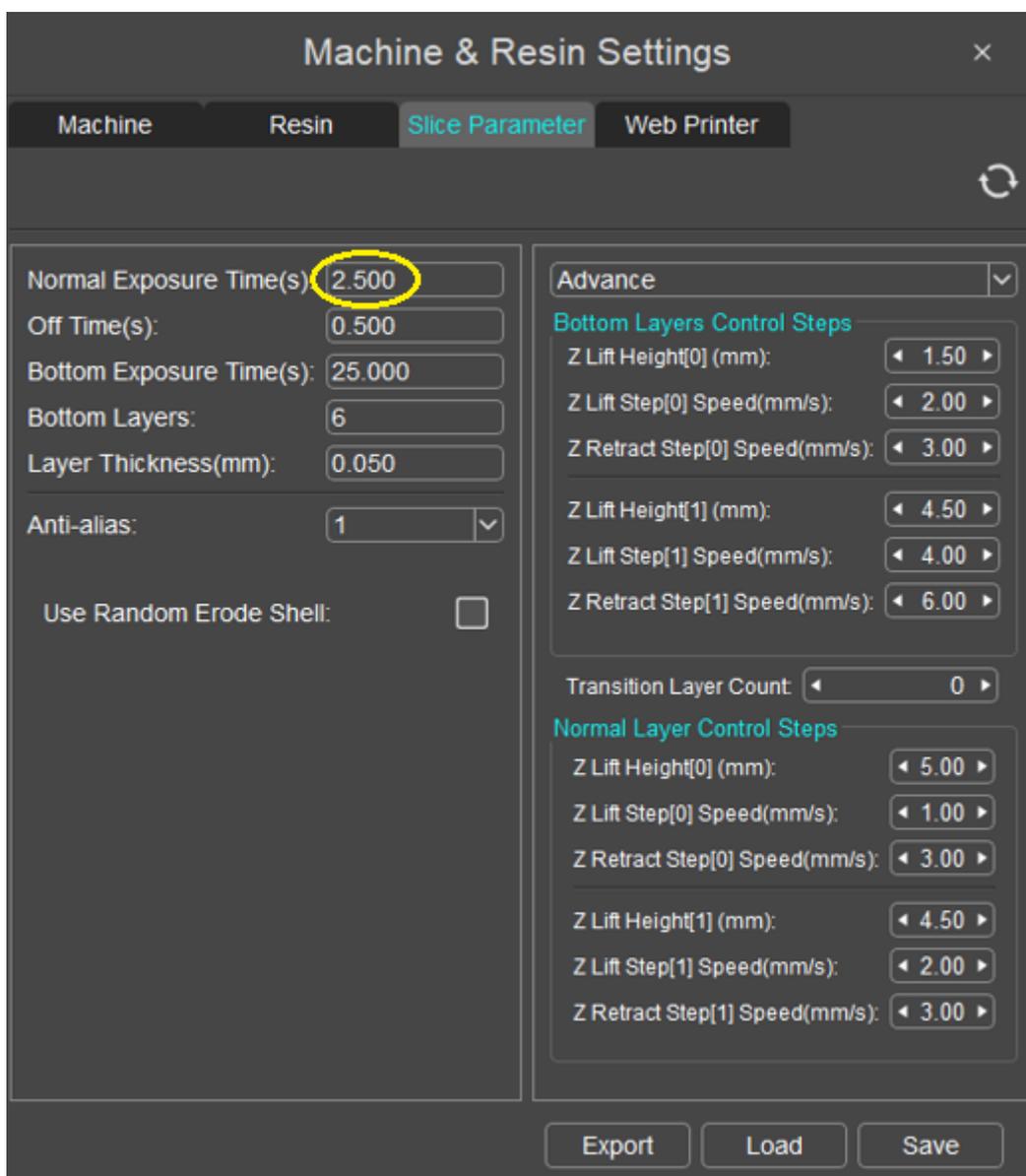
Slicing Software – Anycubic photon workshop V2.2.16



	Printer settings Anycubic Photon Mono 4K		Origin Date	22 Jan 2024
			Revision Date	06 Feb 2024
	QMS/PS/Anycubic/Mono4K	Revision No:01	No. of Pages	Page 2 of 5

Anycubic Photon Mono 4K

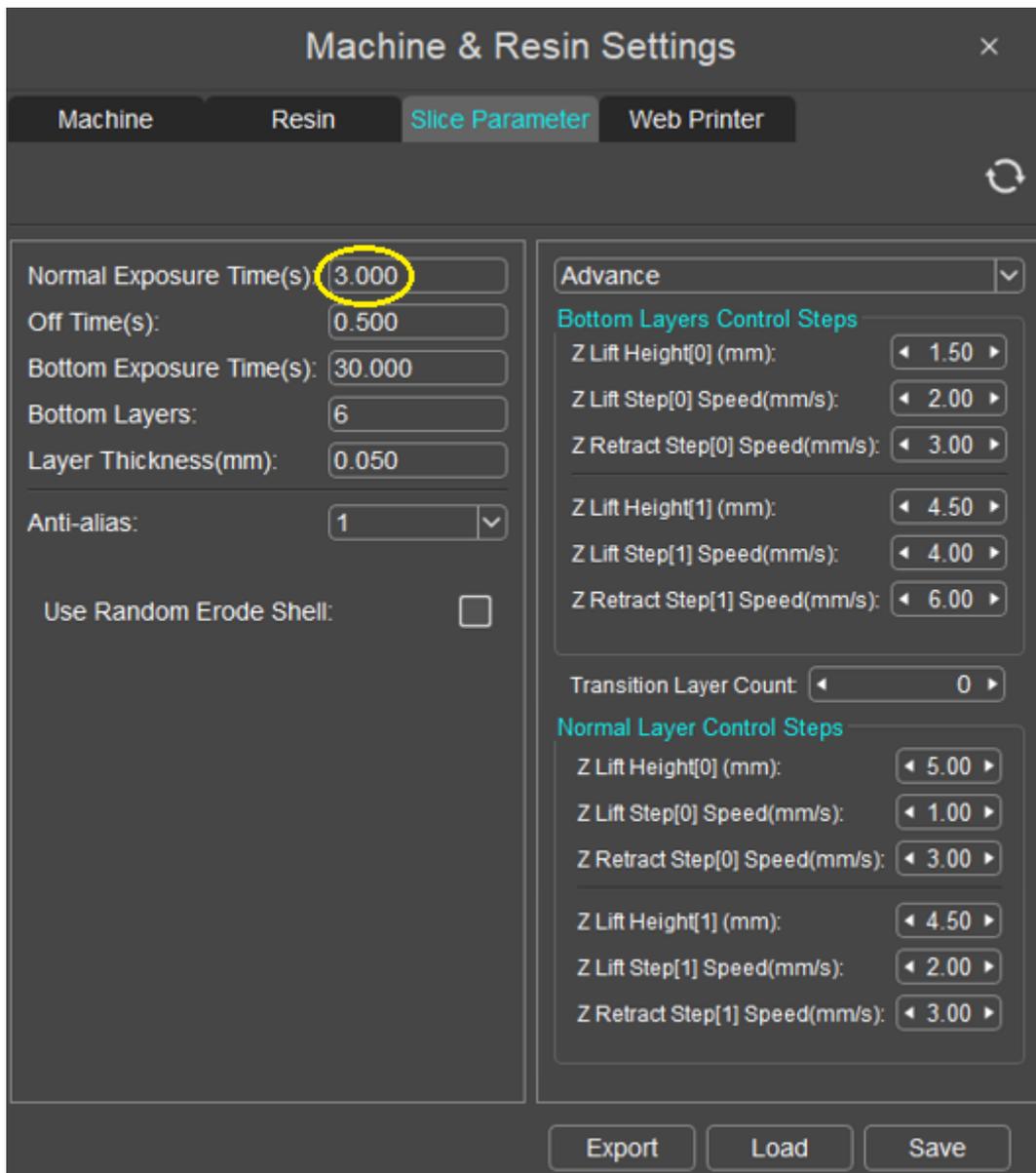
 +
 
 +
 Layer height
50µm/ 0.05 mm



	Printer settings Anycubic Photon Mono 4K		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



	Printer settings Anycubic Photon Mono 4K		Origin Date	22 Jan 2024
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Anycubic
Photon Mono
4K



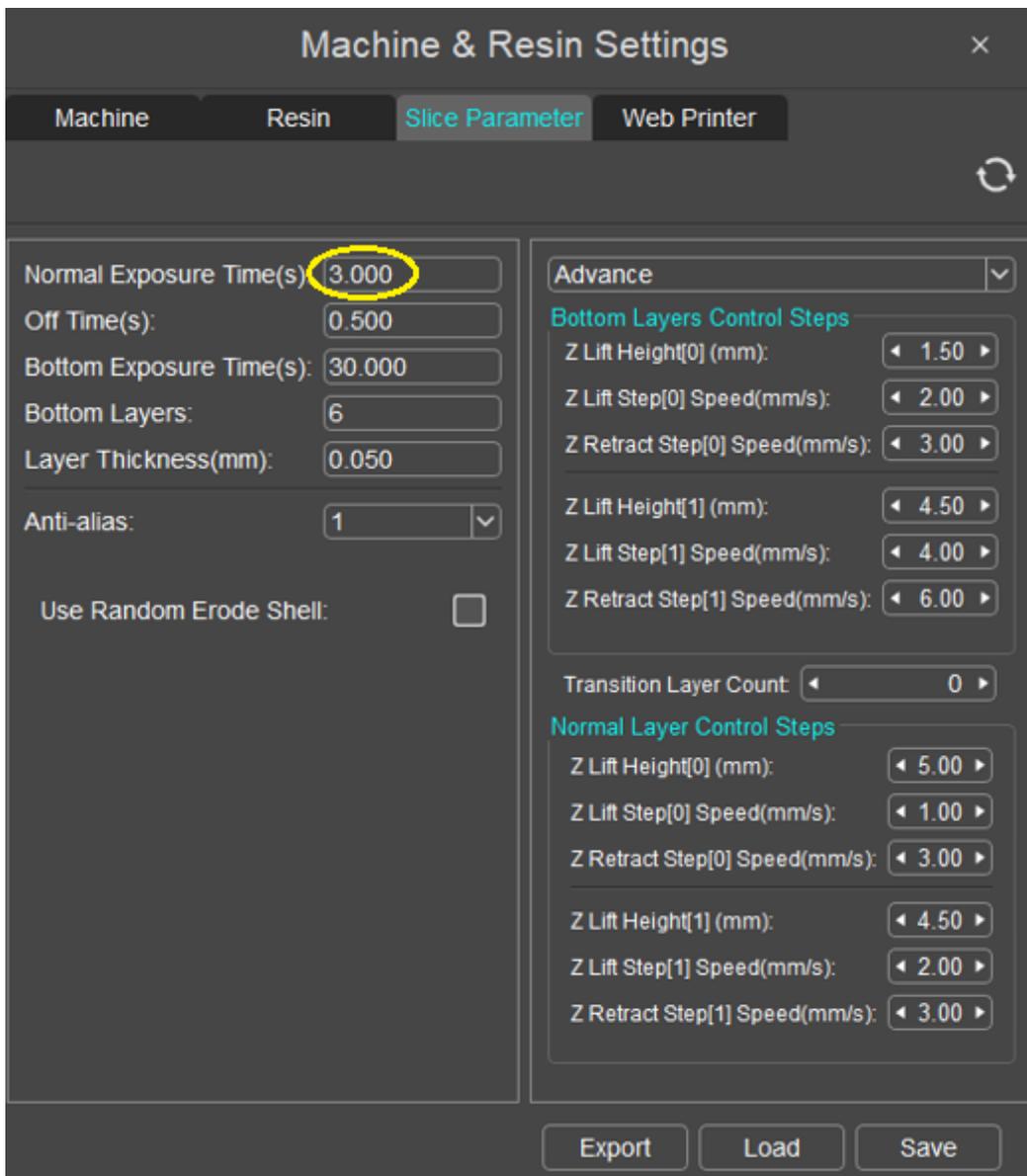
+

Surgical Guide



+

Layer height
50µm/
0.05 mm



	Printer settings Anycubic Photon Mono 4K		Origin Date	22 Jan 2024
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Anycubic Photon Mono 4K


+

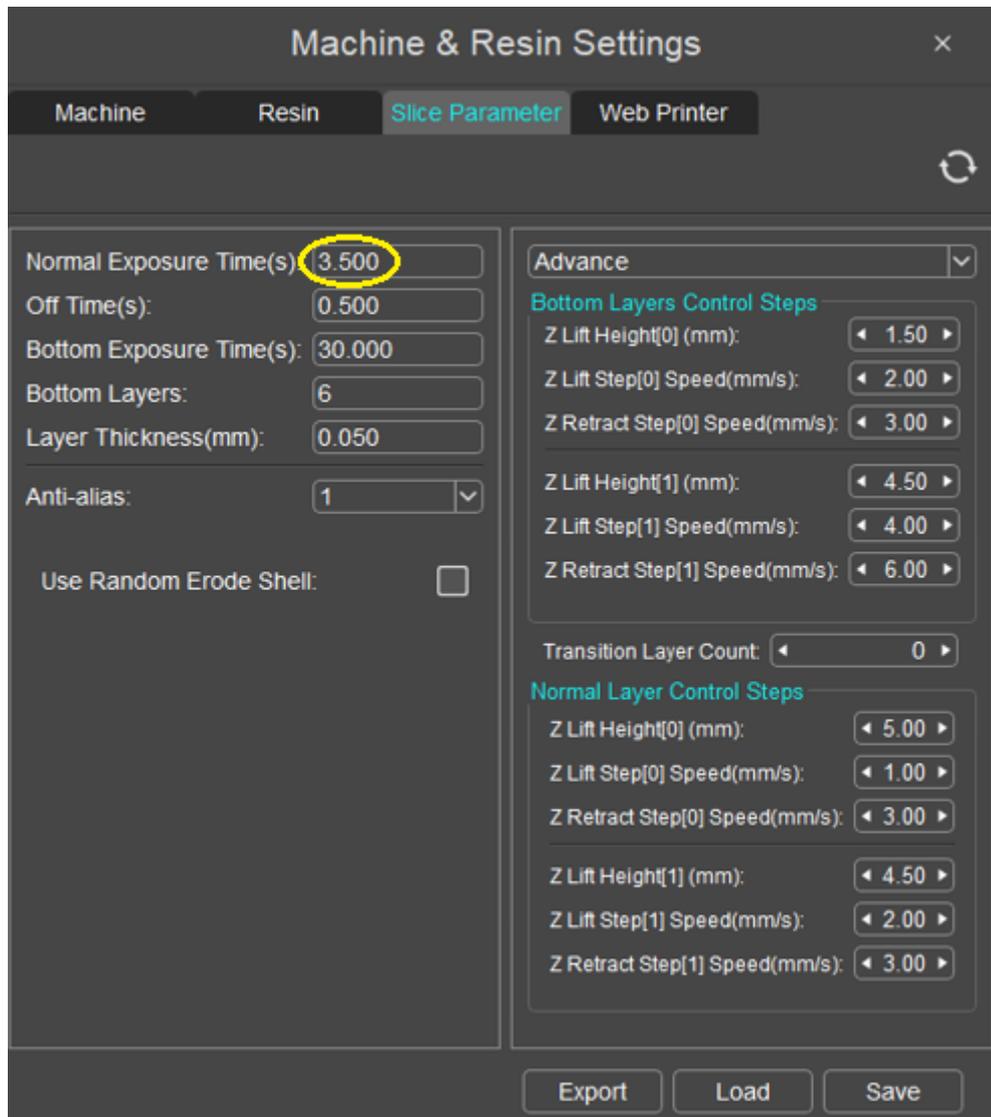
Crown & Bridge



+

Layer height

50µm/
0.05 mm



	Printer settings Elegoo Saturn 2 8K		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			

	Printer settings Elegoo Saturn 2 8K		Origin Date	22 Jan 2024
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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			



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