

Resin Printing Settings

Print parameter item	Resin type	M58/M68	K	K+	G217	D01	D01S	M70	HT-Enduse	F39/F39T	F69	F80 Black/gum color	ANTI	TH72	W90B Transpar ent/grey/ white/blu e	W90BORA NGE	C01	FX60	EC51	TH50	EZprint8K Gray/white/ light skin
Layer Height(mm)		0.05mm	0.05mm	0.05mm	0.075mm	0.05mm	0.05mm	0.05mm	0.05mm	0.09mm	0.09mm	0.1mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.75mm	0.15mm	0.05mm	0.05mm
Exposure Time(s)		2-3s	3.3-5s	3.3-5s	3-4.5s	2.8-4.2s	2.8-4.2s	3-4.5s	2.5-3.8s	3.2-4.8s	5-7.5s	5-7.5s	2.2-3.3s	2.8-4.2s	1.5-2.3s	2.5-3.8s	3.5-5.3s	4.5-6.8s	3.2-4.8s	1.7-2.6s	2-3s
The ratio to the default exposure time		1	1.65	1.5	1.5	1.4	1.4	1.5	1.25	1.6	2.5	2.5	1.1	1.4	0.75	1.25	1.75	2.25	1.6	0.85	1
Layer Height(mm)					0.05mm			0.025mm			0.05mm	0.05mm						0.05mm	0.05mm		
Exposure Time(s)					2.2-3.3s (1.1)			1.8-2.7s (0.9)			3.25-4.9s (1.625)	3.3-5s (1.65)						3-4.5s (1.5)	1.5-2.3s (0.75)		
Bottom Exposure Time(s)		40-70s	50-70s	50-70s	25-45s	60-80s	60-80s	70-110s	30-50s	40-60s	40-80s	40-80s	40-60s	45-65s	25-40s	40-60s	50-80s	50-70s	40-70s	25-45s	45-65s
Lifting Height(LCD Screen Size less than 8.9 inches)		6mm	6mm	6mm	7mm	6mm	7mm	7mm	7mm	7mm	7mm	8mm	7mm	6mm	5mm	5mm	5mm	6mm	6mm	6mm	5mm
Lifting Height(LCD Screen Size ≥8.9 inches)		≥9mm	≥9mm	≥9mm	≥10mm	≥9mm	≥11mm	≥11mm	≥10mm	≥12mm	≥12mm	≥13mm	≥10mm	≥10mm	≥7mm	≥7mm	≥7mm	≥10mm	≥9mm	≥10mm	≥8mm
Rest Time After Retract/Off times /Light-off Delay(s)		≥2	≥2	≥2	≥3	≥2	≥3	≥4	≥3	≥4	≥4	≥5	≥4	≥3	≥1	≥1	≥1	≥3	≥2	≥2	≥2
Lifting speed/Retract speed (mm/min)										90	90	60									

【Must read before printing】

"Anti-aliasing"/"Grayscale" remains off !