



SHINING 3D AccuFab-L4D Printer Instructions



M-PRINT Model sand

REF 1084020

MODELLHERSTELLUNG



PRINTER SETTINGS

Layer Counts	5	20	0
Exposure Level	HPM	HPM	HPM
Fill Exposure Time	16,9 sec.	7,5 sec.	3,8 sec.
Boundary Exposure Time	16,9 sec.	7,5 sec.	3,8 sec.
Support Exposure Time	16,9 sec.	8,5 sec.	3,8 sec.
Wait Time on Top	2,0 sec.	1,0 sec.	0 sec.
Wait Time before Exposure	5,0 sec.	3,5 sec.	1,5 sec.
Wait Time after Exposure	0 sec.	0 sec.	0,2 sec.
Slow Lift Length on z-axis	1,5 mm	1,5 mm	1,5 mm
Slow Lift Speed on z-axis	45 mm/min.	65 mm/min.	40 mm/min.
Quick Lift Length on z-axis	8,0 mm	8,0 mm	8,0 mm
Quick Lift Speed on z-axis	180 mm/min.	220 mm/min.	300 mm/min.
Slow Return Length on z-axis	1,5 mm	1,5 mm	1,5 mm
Slow Return Speed on z-axis	72 mm/min.	72 mm/min.	72 mm/min.
Quick Return Length on z-axis	8,0 mm	8,0 mm	8,0 mm
Quick Return Speed on z-axis	180 mm/min.	220 mm/min.	330 mm/min.
Print Base Time	24,0 sec.	10,0 sec.	5,0 sec.

