



SHINING 3D AccuFab-L40 Printer Instructions



M-PRINT Model taupe-gray

REF 1084018

MODELLHERSTELLUNG



PRINTER SETTINGS

Layer Counts	5	16	0
Exposure Level	HPM	HPM	HPM
Fill Exposure Time	15,5 sec.	5,0 sec.	3,8 sec.
Boundary Exposure Time	15,5 sec.	5,0 sec.	3,8 sec.
Support Exposure Time	15,5 sec.	5,5 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 sec.
Slow Lift Length on z-axis	1,5 mm	1,5 mm	1,0 mm
Slow Lift Speed on z-axis	45 mm/min.	65 mm/min.	40 mm/min.
Quick Lift Length on z-axis	7,0 mm	7,0 mm	7,0 mm
Quick Lift Speed on z-axis	220 mm/min.	220 mm/min.	330 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	7 mm	7 mm	7 mm
Quick Return Speed on z-axis	220 mm/min	220 mm/min	330 mm/min
Print Base Time	22 sec.	13 sec.	13 sec.

