



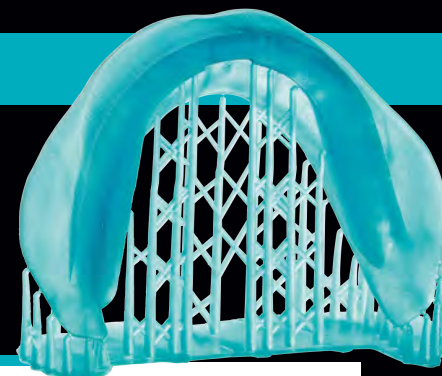
SHINING 3D AccuFab-L4D Printer Instructions



M-PRINT Tray aqua

REF 1084035

INDIVIDUAL IMPRESSION TRAYS



PRINTER SETTINGS HIGH POWER MODE

Layer Counts	4	26	0
Exposure Level	HPM	HPM	HPM
Fill Exposure Time	15.0 sec.	5.0 sec.	5.0 sec.
Boundary Exposure Time	15.0 sec.	5.0 sec.	5.0 sec.
Support Exposure Time	15.0 sec.	5.0 sec.	5.0 sec.
Wait Time on Top	1.0 sec.	2.0 sec.	0 sec.
Wait Time before Exposure	3.5 sec.	3.5 sec.	2.5 sec.
Wait Time after Exposure	0 sec.	0 sec.	0 sec.
Slow Lift Length on z-axis	2.0 mm	2.0 mm	1.0 mm
Slow Lift Speed on z-axis	50 mm/min.	72 mm/min.	72 mm/min.
Quick Lift Length on z-axis	8.0 mm	8.0 mm	6.5 mm
Quick Lift Speed on z-axis	180 mm/min.	220 mm/min.	330 mm/min.
Slow Return Length on z-axis	3.0 mm	2.0 mm	1.0 mm
Slow Return Speed on z-axis	80 mm/min.	90 mm/min.	72 mm/min.
Quick Return Length on z-axis	7.0 mm	8.0 mm	6.5mm
Quick Return Speed on z-axis	180 mm/min.	220 mm/min.	330 mm/min.
Print Base Time	21 sec.	14 sec.	12 sec.

