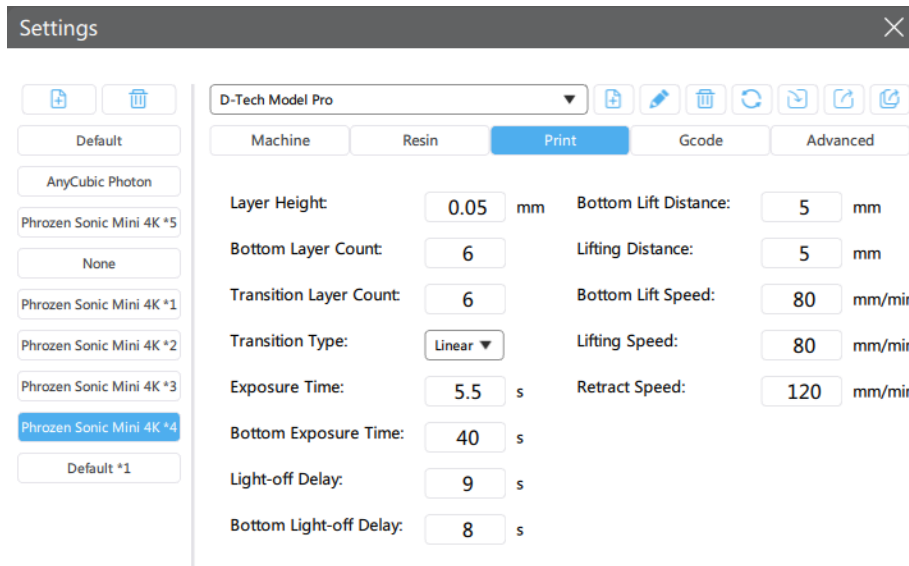

	<b>Printer settings</b> <b>Phrozen Sonic Mini 4K</b>		Issue Date	06 Dec 2019
			Revision Date	10 Oct 2023
	QMS/PS/PHROZEN/4K	Revision No:01	No. of Pages	4



- ❖ Model Pro
- ❖ Model Standard
- ❖ Model Basic



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### ❖ Model Hard

Settings
✕

D-Tech 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 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		




### ❖ Dental Cast Purple

Settings
✕

D-Tech Dental Cast Purple

Machine	Resin	Print	Gcode	Advanced
Layer Height:	<input type="text" value="0.05"/> mm	Bottom Lift Distance:	<input type="text" value="5"/> mm	
Bottom Layer Count:	<input type="text" value="6"/>	Lifting Distance:	<input type="text" value="5"/> mm	
Transition Layer Count:	<input type="text" value="6"/>	Bottom Lift Speed:	<input type="text" value="80"/> mm/min	
Transition Type:	<input type="text" value="Linear"/> ▼	Lifting Speed:	<input type="text" value="80"/> mm/min	
Exposure Time:	<input type="text" value="6"/> s	Retract Speed:	<input type="text" value="120"/> mm/min	
Bottom Exposure Time:	<input type="text" value="40"/> s			
Light-off Delay:	<input type="text" value="9"/> s			
Bottom Light-off Delay:	<input type="text" value="8"/> s			





	<b>Printer settings</b> <b>Phrozen Sonic Mini 4K</b>		Issue Date	06 Dec 2019
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### ❖ Surgical Guide

Settings
✕

Default

AnyCubic Photon

Phrozen Sonic Mini 4K \*5

None







Phrozen Sonic Mini 4K \*1

Phrozen Sonic Mini 4K \*2

Phrozen Sonic Mini 4K \*3

Phrozen Sonic Mini 4K \*4

Default \*1



D-Tech Surgical Guide







Machine
Resin
Print
Gcode
Advanced

Layer Height:	0.05	mm	Bottom Lift Distance:	5	mm
Bottom Layer Count:	6		Lifting Distance:	5	mm
Transition Layer Count:	6		Bottom Lift Speed:	80	mm/min
Transition Type:	Linear	▼	Lifting Speed:	80	mm/min
Exposure Time:	5.5	s	Retract Speed:	120	mm/min
Bottom Exposure Time:	40	s			
Light-off Delay:	9	s			
Bottom Light-off Delay:	8	s			

### ❖ Crown & Bridge

Settings
✕

Default

AnyCubic Photon

Phrozen Sonic Mini 4K \*5

None







Phrozen Sonic Mini 4K \*1

Phrozen Sonic Mini 4K \*2

Phrozen Sonic Mini 4K \*3

Phrozen Sonic Mini 4K \*4

Default \*1

D-Tech C&B







Machine
Resin
Print
Gcode
Advanced

Layer Height:	0.05	mm	Bottom Lift Distance:	5	mm
Bottom Layer Count:	6		Lifting Distance:	5	mm
Transition Layer Count:	6		Bottom Lift Speed:	80	mm/min
Transition Type:	Linear	▼	Lifting Speed:	80	mm/min
Exposure Time:	6	s	Retract Speed:	120	mm/min
Bottom Exposure Time:	40	s			
Light-off Delay:	9	s			
Bottom Light-off Delay:	8	s			