	Printer settings Shining 3D L4K		Issue Date	06 Dec 2019
			Revision Date	10 Oct 2023
	QMS/PS/SHINING/L4K	Revision No:01	No. of Pages	4

Shining 3D L4K



Model Pro, Model standard & Model basic – All three resins work with the inbuilt profile (Shining 3D) DM03 -3.05

Material Manager


Printer Series: AccuFab-L4K
 Printer Serial No.: L4K1AP310-GjBB048F21
 Material Brand: Shining3D
 Material Name: [Shining3D]DM03-0.05
 Support Name: die support

Printer | **Material** | Support

	Enhanced Layer	Medium Layer	General Layer
Layer Counts:	5	27	0
Exposure Level:	High Power Mode	High Power Mode	Mid Power Mode
Fill Exposure Time (s):	11.00	5.00	3.60
Boundary Exposure Time (s):	5.00	3.00	3.60
Support Exposure Time (s):	11.00	5.00	4.20
Wait Time on Top (s):	0.50	0.50	0.00
Wait Time before Exposure (s):	4.50	4.00	3.00
Wait Time after Exposure (s):	0.00	0.00	0.00
Slow Lift Length on z-axis (mm):	1.5	1.5	1.0
Slow Lift Speed on z-axis (mm/min):	30	60	80
Quick Lift Length on z-axis (mm):	7.0	7.0	7.0
Quick Lift Speed on z-axis (mm/min):	220	220	330
Slow Return Length on z-axis (mm):	1.5	1.5	1.0
Slow Return Speed on z-axis (mm/min):	72	72	90
Quick Return Length on z-axis (mm):	7.0	7.0	7.0
Quick Return Speed on z-axis (mm/min):	220	220	330
Print Base Time (s):	20.00	15.00	11.60

Buttons: Add Support, Delete, Change Name/Layer Thickness



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Shining 3D L4K



❖ Dental Cast Purple + Dental Cast –L



Material Manager

Printer Series AccuFab-L4K Printer Serial No. L4K1AP310-GJB048F21 Material Brand Shining3D Material Name [Shining3D]DC12-0.05 Support Name wax crown & frame support	Printer Material Support	Wait Time Arguments:	Enhanced Layer 4	Medium Layer 25	General Layer 0
	Layer Counts: Exposure Level: Fill Exposure Time (s): Boundary Exposure Time (s): Support Exposure Time (s): Wait Time on Top (s): Wait Time before Exposure (s): Wait Time after Exposure (s): Slow Lift Length on z-axis (mm): Slow Lift Speed on z-axis (mm/min): Quick Lift Length on z-axis (mm): Quick Lift Speed on z-axis (mm/min): Slow Return Length on z-axis (mm): Slow Return Speed on z-axis (mm/min): Quick Return Length on z-axis (mm): Quick Return Speed on z-axis (mm/min):	High Power Mode 14.00 0.50 14.00 1.00 3.50 0.00 1.5 45 6.5 160 1.5 60 6.5 200	High Power Mode 4.70 4.70 5.50 1.50 3.00 0.00 1.5 45 6.5 180 1.5 60 6.5 240	High Power Mode 4.70 4.70 5.50 1.00 2.00 0.00 1.0 60 6.0 240 1.0 90 6.0 280	Add Support Delete Change Name/Layer Thickness



❖ Surgical Guide



Material Manager

Printer Series AccuFab-L4K Printer Serial No. L4K1AP310-GJB048F21 Material Brand Shining3D Material Name [Shining3D]DC12-0.05 Support Name wax crown & frame support	Printer Material Support	Wait Time Arguments:	Enhanced Layer 4	Medium Layer 25	General Layer 0
	Layer Counts: Exposure Level: Fill Exposure Time (s): Boundary Exposure Time (s): Support Exposure Time (s): Wait Time on Top (s): Wait Time before Exposure (s): Wait Time after Exposure (s): Slow Lift Length on z-axis (mm): Slow Lift Speed on z-axis (mm/min): Quick Lift Length on z-axis (mm): Quick Lift Speed on z-axis (mm/min): Slow Return Length on z-axis (mm): Slow Return Speed on z-axis (mm/min): Quick Return Length on z-axis (mm): Quick Return Speed on z-axis (mm/min):	High Power Mode 14.00 0.50 14.00 1.00 3.50 0.00 1.5 45 6.5 160 1.5 60 6.5 200	High Power Mode 4.70 4.70 5.50 1.50 3.00 0.00 1.5 45 6.5 180 1.5 60 6.5 240	High Power Mode 4.70 4.70 5.50 1.00 2.00 0.00 1.0 60 6.0 240 1.0 90 6.0 280	Add Support Delete Change Name/Layer Thickness

