



DSI 3D RESIN

3D PRINTING MATERIALS



SETTINGS FOR ANYCUBIC

Printing Profiles for *Anycubic Photon S*

Resin	Exposure 50 µm (Base exposure)	Exposure 100 µm (Base exposure)	Lift (mm/min) / retract speed (mm/s)	Wait before print
Crown & Bridge A1-A2	6-6.9s (60s)	8.7-10.2s (90s)	100 mm/min 1.7 mm/s	1s
Crown & Bridge A3	6-7s (70s)	8.8-10.2s (100s)	100 mm/min 1.7 mm/s	1s
Guide	4.3-5s (50s)	6.4-7.5s (70s)	100 mm/min 1.7 mm/s	1s
Tray	6.4-7.5s (70s)	9.2-10.7s (100s)	100 mm/min 1.7 mm/s	1s
Master	5.3-6.1s (60s)	7.7-8.9s (80s)	100 mm/min 1.7 mm/s	1s
Gingiva	5.1-5.9s (60s)	7.3-8.5s (80s)	100 mm/min 1.7 mm/s	1s
Basic	5.5-6.4s (60s)	8.3-9.6s (90s)	100 mm/min 1.7 mm/s	1s
Cast	13.4-15.5s (140s)	–	50 mm/min 0.8 mm/s	1s

Resin	Exposure 50 µm (Base exposure)	Exposure 100 µm (Base exposure)	Lift (mm/min) retract speed (mm/s)	Wait before print
Model Black	6.4-7.5s (70s)	–	200 mm/min 3.3 mm/s	1s
Model Blue	4.7-5.5s (50s)	6.9-8s (70s)	200 mm/min 3.3 mm/s	1s
Model Cherry	6.9-8s (70s)	–	200 mm/min 3.3 mm/s	1s
Models Clear	6.2-7.2s (70s)	8.7-10.2s (90s)	200 mm/min 3.3 mm/s	1s
Model Grey	6.9-8s (70s)	10.1-11.8s (110s)	200 mm/min 3.3 mm/s	1s
Model Natural	4.6-5.3s (50s)	6.9-8s (70s)	200 mm/min 3.3 mm/s	1s
Model White	5.7-6.6s (60s)	10.3-11.9s (110s)	200 mm/min 3.3 mm/s	1s
Art Glow	5-5.9s (50s)	7.3-8.5s (80s)	100 mm/min 1.7 mm/s	1s