



**DSI 3D RESIN**  
3D PRINTING MATERIALS

**EPAX 3D**

## SETTINGS FOR EPAX

### Printing Profiles for *EPAX X1*

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	7.8-9.1s (90s)	11.5-13.3s (120s)	100 mm/min 1.7 mm/s	1s
Crown & Bridge A3	7.9-9.2s (90s)	11.6-13.4s (130s)	100 mm/min 1.7 mm/s	1s
Guide	5.6-6.5s (60s)	8.4-9.8s (90s)	100 mm/min 1.7 mm/s	1s
Tray	8.4-9.8s (90s)	12.1-14s (130s)	100 mm/min 1.7 mm/s	1s
Master	6.9-8s (80s)	10-11.7s (110s)	100 mm/min 1.7 mm/s	1s
Gingiva	6.7-7.8s (70s)	9.6-11.2s (100s)	100 mm/min 1.7 mm/s	1s
Basic	7.2-8.4s (80s)	10.8-12.6s (120s)	100 mm/min 1.7 mm/s	1s
Cast	17.5-20.4s (190s)	–	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	8.4-9.8s (90s)	–	200 mm/min 3.3 mm/s	1s
Model Blue	6.2-7.2s (70s)	9-10.5s (100s)	200 mm/min 3.3 mm/s	1s
Model Cherry	9-10.5s (100s)	–	200 mm/min 3.3 mm/s	1s
Models Clear	8.1-9.4s (90s)	11.5-13.3s (120s)	200 mm/min 3.3 mm/s	1s
Model Grey	9-10.5s (100s)	13.3-15.4s (140s)	200 mm/min 3.3 mm/s	1s
Model Natural	6-7s (70s)	9-10.5s (100s)	200 mm/min 3.3 mm/s	1s
Model White	7.4-8.6s (80s)	13.5-15.7s (150s)	200 mm/min 3.3 mm/s	1s
Art Glow	6.6-7.7s (70s)	9.6-11.2s (100s)	100 mm/min 1.7 mm/s	1s