



DSI 3D RESIN
3D PRINTING MATERIALS

EPAX 3D

SETTINGS FOR EPAX

Printing Profiles for *EPAX X156*

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	8.8-10.2s (100s)	12.9-15s (140s)	100 mm/min 1.7 mm/s	1s
Crown & Bridge A3	8.9-10.4s (100s)	13-15.1s (140s)	100 mm/min 1.7 mm/s	1s
Guide	6.3-7.3s (70s)	9.5-11s (100s)	100 mm/min 1.7 mm/s	1s
Tray	9.5-11s (100s)	13.6-15.8s (150s)	100 mm/min 1.7 mm/s	1s
Master	7.8-9.1s (80s)	11.3-13.1s (120s)	100 mm/min 1.7 mm/s	1s
Gingiva	7.6-8.8s (80s)	10.8-12.6s (120s)	100 mm/min 1.7 mm/s	1s
Basic	8.1-9.4s (90s)	12.2-14.2s (130s)	100 mm/min 1.7 mm/s	1s
Cast	19.7-22.9s (210s)	–	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	9.5-11s (100s)	–	200 mm/min 3.3 mm/s	1s
Model Blue	7-8.1s (80s)	10.2-11.8s (110s)	200 mm/min 3.3 mm/s	1s
Model Cherry	10.2-11.8s (110s)	–	200 mm/min 3.3 mm/s	1s
Models Clear	9.1-10.6s (100s)	12.9-15s (140s)	200 mm/min 3.3 mm/s	1s
Model Grey	10.2-11.8s (110s)	14.9-17.4s (160s)	200 mm/min 3.3 mm/s	1s
Model Natural	6.8-7.9s (70s)	10.2-11.8s (110s)	200 mm/min 3.3 mm/s	1s
Model White	8.4-9.7s (90s)	15.2-17.6s (160s)	200 mm/min 3.3 mm/s	1s
Art Glow	7.4-8.7s (80s)	10.8-12.6s (120s)	100 mm/min 1.7 mm/s	1s