



DSI 3D RESIN

3D PRINTING MATERIALS



SETTINGS FOR FLASHFORGE

Printing Profiles for *FlashForge Hunter*

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	3-3.5s (30s)	4.4-5.2s (50s)	100 mm/min 1.7 mm/s	1s
Crown & Bridge A3	3.1-3.6s (30s)	4.5-5.2s (50s)	100 mm/min 1.7 mm/s	1s
Guide	2.2-2.5s (20s)	3.3-3.8s (40s)	100 mm/min 1.7 mm/s	1s
Tray	3.3-3.8s (40s)	4.7-5.4s (50s)	100 mm/min 1.7 mm/s	1s
Master	2.7-3.1s (30s)	3.9-4.5s (40s)	100 mm/min 1.7 mm/s	1s
Gingiva	2.6-3s (30s)	3.7-4.3s (40s)	100 mm/min 1.7 mm/s	1s
Basic	2.8-3.2s (30s)	4.2-4.9s (50s)	100 mm/min 1.7 mm/s	1s
Cast	6.8-7.9s (70s)	–	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	3.3-3.8s (40s)	–	200 mm/min 3.3 mm/s	1s
Model Blue	2.4-2.8s (30s)	3.5-4.1s (40s)	200 mm/min 3.3 mm/s	1s
Model Cherry	3.5-4.1s (40s)	–	200 mm/min 3.3 mm/s	1s
Models Clear	3.1-3.7s (30s)	4.4-5.2s (50s)	200 mm/min 3.3 mm/s	1s
Model Grey	3.5-4.1s (40s)	5.1-6s (60s)	200 mm/min 3.3 mm/s	1s
Model Natural	2.3-2.7s (30s)	3.5-4.1s (40s)	200 mm/min 3.3 mm/s	1s
Model White	2.9-3.3s (30s)	5.2-6.1s (60s)	200 mm/min 3.3 mm/s	1s
Art Glow	2.5-3s (30s)	3.7-4.3s (40s)	100 mm/min 1.7 mm/s	1s