



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



# SETTINGS FOR PHROZEN

## Printing Profiles for *Phrozen Shuffle Light*

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	7.2-8.4s (80s)	10.6-12.3s (120s)	100 mm/min 1.7 mm/s	1s
Crown & Bridge A3	7.3-8.5s (80s)	10.7-12.4s (120s)	100 mm/min 1.7 mm/s	1s
Guide	5.2-6s (60s)	7.8-9.1s (80s)	100 mm/min 1.7 mm/s	1s
Tray	7.8-9.1s (80s)	11.2-13s (120s)	100 mm/min 1.7 mm/s	1s
Master	6.4-7.4s (70s)	9.3-10.8s (100s)	100 mm/min 1.7 mm/s	1s
Gingiva	6.2-7.2s (70s)	8.9-10.4s (100s)	100 mm/min 1.7 mm/s	1s
Basic	6.7-7.8s (70s)	10-11.7s (110s)	100 mm/min 1.7 mm/s	1s
Cast	16.2-18.8s (180s)	–	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	7.8-9.1s (80s)	–	200 mm/min 3.3 mm/s	1s
Model Blue	5.7-6.7s (60s)	8.4-9.7s (90s)	200 mm/min 3.3 mm/s	1s
Model Cherry	8.4-9.7s (90s)	–	200 mm/min 3.3 mm/s	1s
Models Clear	7.5-8.7s (80s)	10.6-12.3s (120s)	200 mm/min 3.3 mm/s	1s
Model Grey	8.4-9.7s (90s)	12.3-14.3s (130s)	200 mm/min 3.3 mm/s	1s
Model Natural	5.6-6.5s (60s)	8.4-9.7s (90s)	200 mm/min 3.3 mm/s	1s
Model White	6.9-8s (70s)	12.5-14.5s (140s)	200 mm/min 3.3 mm/s	1s
Art Glow	6.1-7.1s (70s)	8.9-10.4s (100s)	100 mm/min 1.7 mm/s	1s