



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



# SETTINGS FOR PHROZEN

## Printing Profiles for *Phrozen Transform*

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	7.7-9s (80s)	11.3-13.2s (120s)	100 mm/min 1.7 mm/s	1s
Crown & Bridge A3	7.8-9.1s (90s)	11.4-13.3s (120s)	100 mm/min 1.7 mm/s	1s
Guide	5.5-6.5s (60s)	8.3-9.7s (90s)	100 mm/min 1.7 mm/s	1s
Tray	8.3-9.7s (90s)	11.9-13.9s (130s)	100 mm/min 1.7 mm/s	1s
Master	6.8-8s (70s)	9.9-11.6s (110s)	100 mm/min 1.7 mm/s	1s
Gingiva	6.6-7.7s (70s)	9.5-11.1s (100s)	100 mm/min 1.7 mm/s	1s
Basic	7.1-8.3s (80s)	10.7-12.5s (120s)	100 mm/min 1.7 mm/s	1s
Cast	17.3-20.2s (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	8.3-9.7s (90s)	–	200 mm/min 3.3 mm/s	1s
Model Blue	6.1-7.1s (70s)	8.9-10.4s (100s)	200 mm/min 3.3 mm/s	1s
Model Cherry	8.9-10.4s (100s)	–	200 mm/min 3.3 mm/s	1s
Models Clear	8-9.4s (90s)	11.3-13.2s (120s)	200 mm/min 3.3 mm/s	1s
Model Grey	8.9-10.4s (100s)	13.1-15.3s (140s)	200 mm/min 3.3 mm/s	1s
Model Natural	5.9-6.9s (60s)	8.9-10.4s (100s)	200 mm/min 3.3 mm/s	1s
Model White	7.3-8.5s (80s)	13.3-15.5s (140s)	200 mm/min 3.3 mm/s	1s
Art Glow	6.5-7.6s (70s)	9.5-11.1s (100s)	100 mm/min 1.7 mm/s	1s