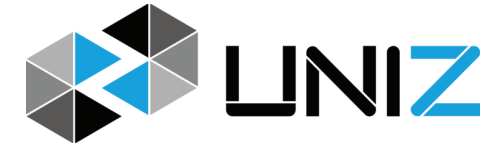




# DSI 3D RESIN

## 3D PRINTING MATERIALS



## SETTINGS FOR UNIZ

### Printing Profiles for *Uniz Slash +*

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	3.9-4.5s (40s)	5.7-6.6s (60s)	100 mm/min 1.7 mm/s	1s
Crown & Bridge A3	3.9-4.6s (40s)	5.7-6.7s (60s)	100 mm/min 1.7 mm/s	1s
Guide	2.8-3.2s (30s)	4.2-4.9s (50s)	100 mm/min 1.7 mm/s	1s
Tray	4.2-4.9s (50s)	6-7s (70s)	100 mm/min 1.7 mm/s	1s
Master	3.4-4s (40s)	5-5.8s (50s)	100 mm/min 1.7 mm/s	1s
Gingiva	3.3-3.9s (40s)	4.8-5.6s (50s)	100 mm/min 1.7 mm/s	1s
Basic	3.6-4.2s (40s)	5.4-6.3s (60s)	100 mm/min 1.7 mm/s	1s
Cast	8.7-10.1s (90s)	-	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	4.2-4.9s (50s)	-	200 mm/min 3.3 mm/s	1s
Model Blue	3.1-3.6s (30s)	4.5-5.2s (50s)	200 mm/min 3.3 mm/s	1s
Model Cherry	4.5-5.2s (50s)	-	200 mm/min 3.3 mm/s	1s
Models Clear	4-4.7s (40s)	5.7-6.6s (60s)	200 mm/min 3.3 mm/s	1s
Model Grey	4.5-5.2s (50s)	6.6-7.7s (70s)	200 mm/min 3.3 mm/s	1s
Model Natural	3-3.5s (30s)	4.5-5.2s (50s)	200 mm/min 3.3 mm/s	1s
Model White	3.7-4.3s (40s)	6.7-7.8s (70s)	200 mm/min 3.3 mm/s	1s
Art Glow	3.3-3.8s (40s)	4.8-5.6s (50s)	100 mm/min 1.7 mm/s	1s