



DSI 3D RESIN

3D PRINTING MATERIALS



SETTINGS FOR ZORTRAX

Printing Profiles for *Zortrax Inkspire*

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	7.9-9.2s (90s)	11.5-13.4s (130s)	100 mm/min 1.7 mm/s	1s
Crown & Bridge A3	8-9.3s (90s)	11.7-13.5s (130s)	100 mm/min 1.7 mm/s	1s
Guide	5.6-6.6s (60s)	8.5-9.9s (90s)	100 mm/min 1.7 mm/s	1s
Tray	8.5-9.9s (90s)	12.2-14.1s (130s)	100 mm/min 1.7 mm/s	1s
Master	7-8.1s (80s)	10.1-11.8s (110s)	100 mm/min 1.7 mm/s	1s
Gingiva	6.8-7.9s (70s)	9.7-11.3s (110s)	100 mm/min 1.7 mm/s	1s
Basic	7.3-8.5s (80s)	10.9-12.7s (120s)	100 mm/min 1.7 mm/s	1s
Cast	17.7-20.5s (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	8.5-9.9s (90s)	–	200 mm/min 3.3 mm/s	1s
Model Blue	6.3-7.3s (70s)	9.1-10.6s (100s)	200 mm/min 3.3 mm/s	1s
Model Cherry	9.1-10.6s (100s)	–	200 mm/min 3.3 mm/s	1s
Models Clear	8.2-9.5s (90s)	11.5-13.4s (130s)	200 mm/min 3.3 mm/s	1s
Model Grey	9.1-10.6s (100s)	13.4-15.6s (150s)	200 mm/min 3.3 mm/s	1s
Model Natural	6.1-7s (70s)	9.1-10.6s (100s)	200 mm/min 3.3 mm/s	1s
Model White	7.5-8.7s (80s)	13.6-15.8s (150s)	200 mm/min 3.3 mm/s	1s
Art Glow	6.7-7.8s (70s)	9.7-11.3s (110s)	100 mm/min 1.7 mm/s	1s