

EVOCURE

3D Printer Settings

Printer	Resin	Layer thickness	Exposure time (seconds)	Base layer count	Base layer exposure	Lift Height (mm)	Lift speed / retract speed (mm/min)	Rest Time after retract
Phrozen Sonic Mini 8KS	MODEL PRO	50 µm	3,50	3	35,0	6	60/320	1,50
	MODEL PRO	100 µm	4,80	3	35,0	6	60/320	1,50
	MODEL	50 µm	3,45	3	35,0	6	60/320	1,50
	MODEL	100 µm	4,50	3	35,0	6	60/320	1,50
	CAST PRO	30 µm	3,35	3	40,0	6	60/320	1,50
Phrozen Sonic XL 4K / PLUS	MODEL PRO	50 µm	2,30	3	30,0	6	60/200	2,00
	MODEL	50 µm	2,30	3	30,0	7	60/200	2,50
Phrozen Sonic Mighty 4K	MODEL PRO	50 µm	3,25	6	40,0	6	80/400	2,00
	MODEL	50 µm	3,75	6	40,0	6	80/400	2,00
Phrozen Sonic Mini 4K	MODEL PRO	50 µm	3,00	5	35,0	5	60/150	2,50
	MODEL PRO	100 µm	3,75	5	35,0	5	60/150	2,00
	MODEL	50 µm	3,35	5	35,0	5	60/150	2,50
	MODEL	100 µm	4,00	5	35,0	5	60/150	2,00

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Elegoo Saturn 3 Ultra	MODEL PRO	50 µm	3,40	3	35,0	7	60/420	2,00
	MODEL PRO	100 µm	4,40	3	35,0	8	100/400	2,00
	MODEL	50 µm	3,30	4	35,0	8	80/400	2,50
	MODEL	100 µm	4,35	4	35,0	8	100/400	2,00
	CAST PRO	30 µm	3,20	4	40,0	8	100/400	2,00
Elegoo Saturn 3	MODEL PRO	50 µm	3,40	3	35,0	7	60/420	2,00
	MODEL PRO	100 µm	4,40	3	35,0	8	100/400	2,00
	MODEL	50 µm	3,30	4	35,0	8	80/400	2,50
	MODEL	100 µm	4,35	4	35,0	8	100/400	2,00
	CAST PRO	30 µm	3,20	4	40,0	8	100/400	2,00
Elegoo Mars 4 Ultra	MODEL PRO	50 µm	2,50	6	35,0	7	120/230	2,00
	MODEL PRO	100 µm	3,00	6	35,0	7	120/230	2,00
	MODEL	50 µm	2,75	6	35,0	7	120/230	2,50
	MODEL	100 µm	3,30	6	35,0	7	120/230	2,50
Elegoo Mars 4	MODEL PRO	50 µm	2,50	6	35,0	7	120/230	2,50
	MODEL PRO	100 µm	3,00	6	35,0	7	120/230	2,50
	MODEL	50 µm	2,75	6	35,0	7	120/230	2,50
	MODEL	100 µm	3,30	6	35,0	7	120/230	2,50

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Anycubic Mono 2	MODEL PRO	50 µm	4,30	5	25,0	5	60/300	2,50
	MODEL PRO	100 µm	5,55	5	25,0	5	60/300	2,00
	MODEL	50 µm	3,95	5	25,0	5	40/300	2,00
	MODEL	100 µm	5,25	5	25,0	5	40/300	2,00
	CAST PRO	30 µm	3,50	6	50,0	4	60/400	2,00
Anycubic Mono M5	MODEL PRO	50 µm	3,50	5	30,0	8	90/360	2,50
	MODEL PRO	100 µm	4,25	5	30,0	8	90/360	2,50
	MODEL	50 µm	3,50	5	30,0	8	90/360	2,50
	MODEL	100 µm	4,25	5	30,0	8	90/360	2,50
Anycubic Mono M5s	MODEL PRO	50 µm	3,50	5	30,0	8	90/360	2,50
	MODEL PRO	100 µm	4,25	5	30,0	8	90/360	2,50
	MODEL	50 µm	3,50	5	30,0	8	90/360	2,50
	MODEL	100 µm	4,25	5	30,0	8	90/360	2,50
Zortrax Inkspire	MODEL PRO	50 µm	11,50	5	90,0	5	60/150	2,00
	MODEL PRO	100 µm	12,50	5	90,0	5	60/150	2,00
	MODEL	50 µm	11,50	5	90,0	5	60/150	2,00
	MODEL	100 µm	12,50	5	90,0	5	60/150	2,00