

	3D Printer Settings		Document No. F.3D.PS.01
			Issue No. 01
	PREVEST//3D		Revision No. 01
			Effective Date. 03/04/2024



	3D Printer Settings	Document No. F.3D.PS.01
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- Use Slicing Software Chitu Box.
- Copy the data saved from OMNI 9K USB to any computer drive.
- Install Chitubox Slicer and run the program.
- Import OMNI 9K Prevest Resin Chitu Box Settings profile .cfg file into the software.
- Finally use resin settings for 3D Printing.

Import .cfg



Prevest Resin Chitu Box Settings








Machine

Resin

Print

Gcode

Advanced

Name:

OMNI 9K PREVEST 3D

Machine Type:

default

Resolution:

X : 8520 px

Y : 4320 px

Mirror:

LCD_mirror

Lock Ratio:

☐

Size:

X : 153.360 mm

Y : 77.760 mm

Z : 150.000 mm

Build Area Offset:

☐

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PREVEST MODEL PRO

- Import the Prevest Model Pro settings Profile .cfg file into the software.
- Use resin settings for 3D Printing.



Prevest Model Pro

Machine
Resin
Print
Gcode
Advanced

Layer Height:	0.050	mm	Bottom Lift Distance:	4.000	+	2.000	mm
Bottom Layer Count:	5		Lifting Distance:	4.000	+	2.000	mm
Exposure Time:	5.000	s	Bottom Retract Distance:	4.000	+	2.000	mm
Bottom Exposure Time:	50.000	s	Retract Distance:	4.000	+	2.000	mm
Transition Layer Count:	5		Bottom Lift Speed:	60.000	&	150.000	mm/min
Transition Type:	Linear		Lifting Speed:	60.000	&	150.000	mm/min
Transition Time Decrement:	7.500	s	Bottom Retract Speed:	150.000	&	60.000	mm/min
Waiting Mode During Printing:	Restin...		Retract Speed:	150.000	&	60.000	mm/min
Rest Time Before Lift:	0.000	s					
Rest Time After Lift:	0.000	s					
Rest Time After Retract:	0.500	s					

Prevest Model Pro

Machine
Resin
Print
Gcode
Advanced

Bottom Light PWM:	255	/ ▼	Shrinkage Compensation:	☐
Light PWM:	255	/ ▼	Tolerance Compensation(Beta):	☒
Anti-aliasing:	☒			a: -0.200 mm
Anti-aliasing Level:	8			b: -0.100 mm
Grey Level	8			Bottom Tolerance Compensation: ☒
Image Blur:	☒			a: -0.200 mm
Image Blur Pixel:	4		b: -0.100 mm	Print Time Compensation: ☐

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Prevest Model

- Import the Prevest Model settings Profile .cfg file into the software.
- Use resin settings for 3D Printing.



Prevest Model

Machine

Resin

Print

Gcode

Advanced

Layer Height:	0.050	mm	Bottom Lift Distance:	4.000	+	2.000	mm
Bottom Layer Count:	5		Lifting Distance:	4.000	+	2.000	mm
Exposure Time:	5.000	s	Bottom Retract Distance:	4.000	+	2.000	mm
Bottom Exposure Time:	50.000	s	Retract Distance:	4.000	+	2.000	mm
Transition Layer Count:	5		Bottom Lift Speed:	60.000	&	150.000	mm/min
Transition Type:	Linear		Lifting Speed:	60.000	&	150.000	mm/min
Transition Time Decrement:	7.500	s	Bottom Retract Speed:	150.000	&	60.000	mm/min
Waiting Mode During Printing:	Restin...		Retract Speed:	150.000	&	60.000	mm/min
Rest Time Before Lift:	0.000	s					
Rest Time After Lift:	0.000	s					
Rest Time After Retract:	0.500	s					

Prevest Model

Machine

Resin

Print

Gcode

Advanced

Bottom Light PWM:	255	/	Shrinkage Compensation:	☐
Light PWM:	255	/	Tolerance Compensation(Beta):	☒
Anti-aliasing:	☒			a: -0.200 mm b: -0.100 mm
Anti-aliasing Level:	8			
Grey Level:	8		Bottom Tolerance Compensation:	☒
Image Blur:	☒			a: -0.200 mm b: -0.100 mm
Image Blur Pixel:	4		Print Time Compensation:	☐

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Prevest Burn Out

- Import the Prevest Burn Out settings Profile .cfg file into the software.
- Use resin settings for 3D Printing.

Prevest Burn Out

Machine

Resin

Print

Gcode

Advanced

Layer Height:	0.050	mm	Bottom Lift Distance:	4.000	+	2.000	mm
Bottom Layer Count:	5		Lifting Distance:	4.000	+	2.000	mm
Exposure Time:	5.000	s	Bottom Retract Distance:	4.000	+	2.000	mm
Bottom Exposure Time:	50.000	s	Retract Distance:	4.000	+	2.000	mm
Transition Layer Count:	5		Bottom Lift Speed:	60.000	&	150.000	mm/min
Transition Type:	Linear		Lifting Speed:	60.000	&	150.000	mm/min
Transition Time Decrement:	7.500	s	Bottom Retract Speed:	150.000	&	60.000	mm/min
Waiting Mode During Printing:	Restin...		Retract Speed:	150.000	&	60.000	mm/min
Rest Time Before Lift:	0.000	s					
Rest Time After Lift:	0.000	s					
Rest Time After Retract:	0.500	s					



Prevest Burn Out

Machine

Resin

Print

Gcode

Advanced

Bottom Light PWM:	255	/	Shrinkage Compensation:	☐
Light PWM:	255	/	Tolerance Compensation(Beta):	☒
Anti-aliasing:	☒		a b	a: -0.200 mm
Anti-aliasing Level:	8		b	b: -0.100 mm
Grey Level	8		Bottom Tolerance Compensation:	☒
Image Blur:	☒		a b	a: -0.200 mm
Image Blur Pixel:	4		b	b: -0.100 mm
			Print Time Compensation:	☐

Prevest Surgical Guide

- Import the Prevest Surgical Guide settings Profile .cfg file into the software.
- Use resin settings for 3D Printing.

Prevest Surgical Guide








Machine

Resin

Print

Gcode

Advanced

Layer Height:	0.050	mm	Bottom Lift Distance:	4.000	+	2.000	mm
Bottom Layer Count:	5		Lifting Distance:	4.000	+	2.000	mm
Exposure Time:	5.000	s	Bottom Retract Distance:	4.000	+	2.000	mm
Bottom Exposure Time:	50.000	s	Retract Distance:	4.000	+	2.000	mm
Transition Layer Count:	5		Bottom Lift Speed:	60.000	&	150.000	mm/min
Transition Type:	Linear		Lifting Speed:	60.000	&	150.000	mm/min
Transition Time Decrement:	7.500	s	Bottom Retract Speed:	150.000	&	60.000	mm/min
Waiting Mode During Printing:	Restin...		Retract Speed:	150.000	&	60.000	mm/min
Rest Time Before Lift:	0.000	s					
Rest Time After Lift:	0.000	s					
Rest Time After Retract:	0.500	s					



Prevest Surgical Guide








Machine

Resin

Print

Gcode

Advanced

Bottom Light PWM:	255	/	255	Shrinkage Compensation:	☐
Light PWM:	255	/	255	Tolerance Compensation(Beta):	☒
Anti-aliasing:	☒			 a: -0.200 mm b: -0.100 mm	
Anti-aliasing Level:	8				
Grey Level	8			Bottom Tolerance Compensation:	☒
Image Blur:	☒			 a: -0.200 mm b: -0.100 mm	
Image Blur Pixel:	4			Print Time Compensation:	☐

Prevest Denture

- Import the Prevest Denture settings Profile .cfg file into the software.
- Use resin settings for 3D Printing.

Prevest Denture








Machine

Resin

Print

Gcode

Advanced

Layer Height:	0.050 mm	Bottom Lift Distance:	4.000 + 2.000 mm
Bottom Layer Count:	5	Lifting Distance:	4.000 + 2.000 mm
Exposure Time:	5.000 s	Bottom Retract Distance:	4.000 + 2.000 mm
Bottom Exposure Time:	50.000 s	Retract Distance:	4.000 + 2.000 mm
Transition Layer Count:	5	Bottom Lift Speed:	60.000 & 150.000 mm/min
Transition Type:	Linear	Lifting Speed:	60.000 & 150.000 mm/min
Transition Time Decrement:	7.500 s	Bottom Retract Speed:	150.000 & 60.000 mm/min
Waiting Mode During Printing:	Restin...	Retract Speed:	150.000 & 60.000 mm/min
Rest Time Before Lift:	0.000 s		
Rest Time After Lift:	0.000 s		
Rest Time After Retract:	0.500 s		



Prevest Denture








Machine

Resin

Print

Gcode

Advanced

Bottom Light PWM:	255 / 255	Shrinkage Compensation:	☐
Light PWM:	255 / 255	Tolerance Compensation(Beta):	☒
Anti-aliasing:	☒		a: -0.200 mm b: -0.100 mm
Anti-aliasing Level:	8		
Grey Level	8	Bottom Tolerance Compensation:	☒
Image Blur:	☒		a: -0.200 mm b: -0.100 mm
Image Blur Pixel:	4		
		Print Time Compensation:	☐

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Prevest C&B Interim

- Import the Prevest C&B Interim settings Profile .cfg file into the software.
- Use resin settings for 3D Printing.

Prevest C&B Interim

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

Bottom Lift Distance:

4.000

+

2.000

mm

Lifting Distance:

4.000

+

2.000

mm

Bottom Retract Distance:

4.000

+

2.000

mm

Retract Distance:

4.000

+

2.000

mm

Bottom Lift Speed:

60.000

&

150.000

mm/min

Lifting Speed:

60.000

&

150.000

mm/min

Bottom Retract Speed:

150.000

&

60.000

mm/min

Retract Speed:

150.000

&

60.000

mm/min



Prevest C&B Interim

Machine

Resin

Print

Gcode

Advanced

Bottom Light PWM:

255

/

Light PWM:

255

/

Anti-aliasing:

☐

Anti-aliasing Level:

8

Grey Level

8

Image Blur:

☐

Image Blur Pixel:

4

Shrinkage Compensation:

☐

Tolerance Compensation(Beta):

☒

a:

-0.200

mm

b:

-0.100

mm

Bottom Tolerance Compensation:

☒

a:

-0.200

mm

b:

-0.100

mm

Print Time Compensation:

☐

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Prevest C&B Permanent

- Import the Prevest C&B Permanent settings Profile .cfg file into the software.
- Use resin settings for 3D Printing.

Prevest C&B Permanent

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

Bottom Lift Distance:

4.000

+

2.000

mm

Lifting Distance:

4.000

+

2.000

mm

Bottom Retract Distance:

4.000

+

2.000

mm

Retract Distance:

4.000

+

2.000

mm

Bottom Lift Speed:

60.000

&

150.000

mm/min

Lifting Speed:

60.000

&

150.000

mm/min

Bottom Retract Speed:

150.000

&

60.000

mm/min

Retract Speed:

150.000

&

60.000

mm/min



Prevest C&B Permanent

Machine

Resin

Print

Gcode

Advanced

Bottom Light PWM:

255

/

Light PWM:

255

/

Anti-aliasing:

Anti-aliasing Level:

8

Grey Level

8

Image Blur:

Image Blur Pixel:

4

Shrinkage Compensation:

Tolerance Compensation(Beta):

a:

-0.200

mm

b:

-0.100

mm

Bottom Tolerance Compensation:

a:

-0.200

mm

b:

-0.100

mm

Print Time Compensation:

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Prevest C&B Ceramic

- Import the Prevest C&B Ceramic settings Profile .cfg file into the software.
- Use resin settings for 3D Printing.

Prevest C&B Ceramic

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

4.000

+

2.000

mm

Bottom Layer Count:

5

Lifting Distance:

4.000

+

2.000

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

4.000

+

2.000

mm

Bottom Exposure Time:

50.000

s

Retract Distance:

4.000

+

2.000

mm

Transition Layer Count:

5

Bottom Lift Speed:

60.000

&

150.000

mm/min

Transition Type:

Linear

Lifting Speed:

60.000

&

150.000

mm/min

Transition Time Decrement:

7.500

s

Bottom Retract Speed:

150.000

&

60.000

mm/min

Waiting Mode During Printing:

Restin...

Retract Speed:

150.000

&

60.000

mm/min

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s



Prevest C&B Ceramic

Machine

Resin

Print

Gcode

Advanced

Bottom Light PWM:

255

/

Shrinkage Compensation:

☐

Light PWM:

255

/

Tolerance Compensation(Beta):

☒

Anti-aliasing:

☒

a:

-0.200

mm

Anti-aliasing Level:

8

b:

-0.100

mm

Grey Level

8

Bottom Tolerance Compensation:

☒

Image Blur:

☒

a:

-0.200

mm

Image Blur Pixel:

4

b:

-0.100

mm

Print Time Compensation:

☐

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Post Curing Unit

- Printed Materials are validated for Post Curing on the Omni Cure curing unit.



Prevest Model Pro
Post Curing Time: 5 min.



Prevest Model
Post Curing Time: 5 min.



Prevest Surgical Guide
Post Curing Time: 5 min.



Prevest Denture
Post Curing Time: 5 min.



Prevest Burn Out
Post Curing Time: 5 min.



Prevest C&B Interim
Post Curing Time: 30 min.



Prevest C&B Ceramic
Post Curing Time: 30 min.



Prevest C&B Permanent
Post Curing Time: 30 min.