

# MODEL

3D Print High-Contrast Dental Models

Printer Parameter	
Layer Height (mm)	0.05 / 0.1
Bottom Layer Count	6
Exposure Time (s)	10
Bottom Exposure Time (s)	40
Transition layer Count	6
Transition Type	Linear
Transition Time Decrement	4.29
Waiting mode during printing	Light
Light off delay (s)	13
Bottom Light off delay (s)	13
Bottom lift distance (mm)	8
Lifting distance (mm)	8
Bottom Retract Distance	8
Retract Distance	8
Bottom lift speed (mm/min)	60
Lifting speed (mm/min)	60
Bottom Retract speed (mm/min)	150
Retract speed (mm/min)	150
Tolerance Compensation Beta	a: -0.200
	b: -0.1



Support Setting					
Z-Lift Height (mm)	10.5				
Support Setting	Light				
Top		Middle		Bottom	
Contact Shape	None	Shape	Cylinder	Platform Touch Shape	Skate
Contact Diameter (mm)	0.3	Diameter (mm)	0.8	Touch Diameter (mm)	10
Contact Depth (mm)	0.2	Angle	70	Thickness	0.8
Contact Shape	Cone	Small Pillar Shape	Cone	Model Contact Shape	None
Upper Diameter (mm)	0.3	Diameter (mm)	0.4	Contact Diameter (mm)	0.4
Lower Diameter (mm)	0.8	Upper Depth (mm)	0.25	Contact Depth (mm)	0.2
Connection Length (mm)	2	Lower Depth (mm)	0.25	Contact Point	1

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