



Printing area	Solid	Closed	Wall Thickness	Design Requirements	Support Settings			Slice Settings					Print Mode		
				HOLE OPENING	SUPPORT DIAMETER (mm)	HEAD LENGTH (mm)	POINT SIZE	RISE HEIGHT	MOTOR SPEED	COOL DOWN TIME	EXPOSURE TIME	UDP MODE			
5%	Y			N	0.6~1	1~2	0.19~0.3	3	HIGH	0~2	AUTO	Y	FAST		
	N	Y		Y								N		N	
	N	N	>3mm	N								N		N	
	N	N	≥3mm	N								N		N	
10%	Y			N	0.9~1.3	1~2.5	0.25~0.3	3	HIGH	1~4	AUTO	Y			
	N	Y		Y								N		N	
	N	N	>3mm	N								N		N	
	N	N	≥3mm	N								N		N	
20%	Y			N	1.2~1.5	1~2.5	0.26~0.35	3	HIGH	1~4	AUTO	Y			
	N	Y		Y								N		N	
	N	N	>3mm	N								N		N	
	N	N	≥3mm	N								N		N	
30%	Y			N	1.3~1.6	1~3	0.33~0.4	3	HIGH	2~5	AUTO	Y			
	N	Y		Y								N	N		
	N	N	>3mm	N								N	N		
	N	N	≥3mm	N								N	N		
40%	Y			N	1.4~1.7	1~3	0.43~0.52	8	MEDIUM	5~10	AUTO	Y	MEDIUM		
	N	Y		Y								N		N	
	N	N	>3mm	N								N		N	
	N	N	≥3mm	N								N		N	
50%	Y			N	1.6~2	1~3.5	0.45~0.66	8	MEDIUM	10~15	AUTO*2	N			
	N	Y		Y							N			N	
	N	N	>3mm	N							N			N	
	N	N	≥3mm	N							N			N	
80%	Y			N	2.2~2.6	1~3.5	0.7~1.24	15	LOW	15~20	AUTO*2.5			SLOW	
	N	Y		Y							N				N
	N	N	>3mm	N							N				N
	N	N	≥3mm	N							N				N
100%	Y			N	2.5~3	1~3.5	1.04~1.72	15	LOW	15~20	AUTO*3				
	N	Y		Y							N		N		
	N	N	>3mm	N							N		N		
	N	N	≥3mm	N							N		N		

PARAMETERS DESCRIPTION:

1. Printing area: the proportion of exposed screen area in the platform area
2. Wall thickness: the thickness of a non-solid part
3. Hole opening: in order to avoid broken walls in closed models, it is recommended that users use model editing software to insert holes.
4. Support diameter: users can adjust the support diameter according to the size and weight of the model;
5. Point size: refers to the point of direct contact between the support head and the model. Users need to adjust the support diameter according to the size and weight of the printed model. The upper limit of point size is directly related to the support diameter
6. Head length: users can adjust the distance between the support and the model by adjusting the head length
7. Motor speed: the motor speed is inversely proportional to the motor torque. Users can adjust the motor speed of the printer according to the printing area of each layer of the model.
8. Rise height: the lifting height of the tray after each layer is printed. The larger the area, the higher the lifting height is required to ensure the reflux replenishment of the resin.
9. Cool down time: the curing reaction is exothermic. The larger the slice area, the greater the heat. In order to avoid heat accumulation during the printing process, users need to choose different cool down times depending on the printing area in order to avoid damaging the resin tank.
10. Estimated printing time: estimated printing time is directly related to exposure time, cool down time, motor speed and rise height.
11. Print mode: By understanding the previous series of conditions, users can set the proper print parameters to optimize their print.