MSLA-Modeling – Dental (MMD-R001DN)

Check
- Vat and LCD screen are clean
- Shake well before pouring, 60 sec
- Vat & platform are tighten properly
- Do Not overfill vat

Setting recommendation Chart

Printer	Layer Thickness	Normal Exposure Time (sec)	Bottom (Burn-In) Layers	Exposure Time (sec) for Bottom (Burn-In)
Photon	50 μm	10	8	45
Photon	100 μm	15	10	50
Photon S	50 μm	5	8	40
Photon S	100 μm	8	10	45
Mono X	50 μm	1.5	3	30
Mono X	100 μm	2.4	3	30
Shuffle	50 μm	10	8	40
Shuffle	100 μm	15	10	45
Shuffle XL	50 μm	8	8	40
Shuffle XL	100 μm	12	10	45
Sonic	50 μm	2.5	8	30
Sonic	100 μm	4	10	30
Sonic Mini	50 μm	4	6	30
Sonic Mini	100 μm	6	6	30
Sonic Mighty 4K	50 μm	3	10	30
Sonic Mighty 4K	100 μm	5	10	30
Sonic Mega 8K	50 μm	3.8	8	35
Sonic Mega 8K	100 μm	5.4	8	40
Transform Fast	50 μm	3.2	10	60
Transform Fast	100 μm	4.5	10	60
Elegoo Mars 2 Pro	50 μm	2.8	5	25
Elegoo Mars 2 Pro	100 mm	3.8	5	30
Elegoo Mars 3	50 μm	2.8	5	25
Elegoo Mars 3	100 μm	3.8	5	30

Detail setting of various printers, please refer to ALW LCD/LED Settings Worksheet. Each printer is unique, light intensity varies from printer to printer eventhough they are the same model and make. Please adjust normol exposure time from our recommended setting ±3 (±0.5 for monochrome LCD) second for your printer and print geometry.

For size calibration, please download XYZ caalibration cube stl file.

Washing
Submerge print in clean IPA for up to **5 minutes**, gently shake-off / blow-off excess IPA, set print in a shaded airy place to dry before curing. **(extended period in IPA causes deformation).** Dried print might be a little tacky to touch

Curing
Post-curing required for optimal material performance: Light wavelength: 405 nm Total light energy per unit area required on the print: **162,000 mJ/cm^2**

Example:
Light power on the print = 40mW/cm^2, (higher power per unit area shortens curing time) 162,000 mJ / 30 mW / 60 sec = 90 minutes of curing time.

Form commond curing chambers, the recommended setting is following:

Post Curing Chamber	Temperature (°C)	Time (min)
FormCure (FormLabs)	60	30
ProCure (Sprintray)	30	15
Phrozen cure XL (Phrozen)	--	45
Mercury x Cure (Elegoo)	--	30

Storage
Don't keep resin in the vat for more than **2 days**. Filter out all debris in the case of fail print.

Note: Slight pigment settlement is normal. Gentally mix remaining resin in resin vat with soft wiper for color evenness.