

Liquid Crystal 10" Resin Settings

Resin	Colour	Exposure time (ms)	Slice Height (mm)	Number of First Layers	Exposure Time for First Layers (ms)	Z Lift Distance (mm)	Lift Speed (mm/m)	Top Delay (ms)*	Bottom Delay (ms)*
Hard	Amber	23000	100	4	150000	4	50	15000	7000
	Red	30000							
	Grey								
	Green								
	Cream								
	Black								
	Castable								
Firm	Amber	23000							
	Red	30000							
	Grey								
	Cream								
	Green								
	Black								
Flex	Amber	41000							
	Red	45000							
	Grey	50000							
	Cream								
	Green								
	Black								

Liquid Crystal HR Resin Settings – Standard – Large Objects (around 50% build area)

Resin	Colour	Exposure time (ms)	Slice Height (mm)	Number of First Layers	Exposure Time for First Layers (ms)	Bottom Layer Delays (ms)*	Z Lift Distance (mm)	Lift and Bottom Speed (mm/m)	Retract Speed (mm/m)	Top Delay (ms)*	Bottom Delay (ms)*
Hard	Amber	23000	100	1	350000	40000	8	15	50	2500	7000
	Red	30000									
	Grey										
	Green										
	Cream										
	Black										
	Castable										
Firm	Amber	23000									
	Red	30000									
	Grey										
	Cream										
	Green										
	Black										
Flex	Amber	44000									
	Red	48000									
	Grey	53000									
	Cream										
	Green										
	Black										

Liquid Crystal HR Resin Settings – Standard Fast – Medium Objects (around 25% build area)

Resin	Colour	Exposure time (ms)	Slice Height (mm)	Number of First Layers	Exposure Time for First Layers (ms)	Bottom Layer Delays (ms)*	Z Lift Distance (mm)	Lift and Bottom Speed (mm/m)	Retract Speed (mm/m)	Top Delay (ms)*	Bottom Delay (ms)*
Hard	Amber	23000	100	1	350000	7000	2	15	50	2500	7000
	Red	30000									
	Grey										
	Green										
	Cream										
	Black										
	Castable										
Firm	Amber	23000									
	Red	30000									
	Grey										
	Cream										
	Green										
	Black										
Flex	Amber	44000									
	Red	48000									
	Grey	53000									
	Cream										
	Green										
	Black										

Liquid Crystal HR Resin Settings – Detail – Small Objects (around 10% build area)

Resin	Colour	Exposure time (ms)	Slice Height (mm)	Number of First Layers	Exposure Time for First Layers (ms)	Bottom Layer Delays (ms)*	Z Lift Distance (mm)	Lift and Bottom Speed (mm/m)	Retract Speed (mm/m)	Top Delay (ms)*	Bottom Delay (ms)*
Hard	Amber	18000	50	1	350000	7000	1	15	50	2500	7000
	Red	25000									
	Grey										
	Green										
	Cream										
	Black										
	Castable										
Firm	Amber	18000									
	Red	25000									
	Grey										
	Cream										
	Green										
	Black										