RESINWORKS3D

Visit Our Page

Start by visiting our printer setting page to find the printer that matches your model or in a same brand (e.g. Phrozen).
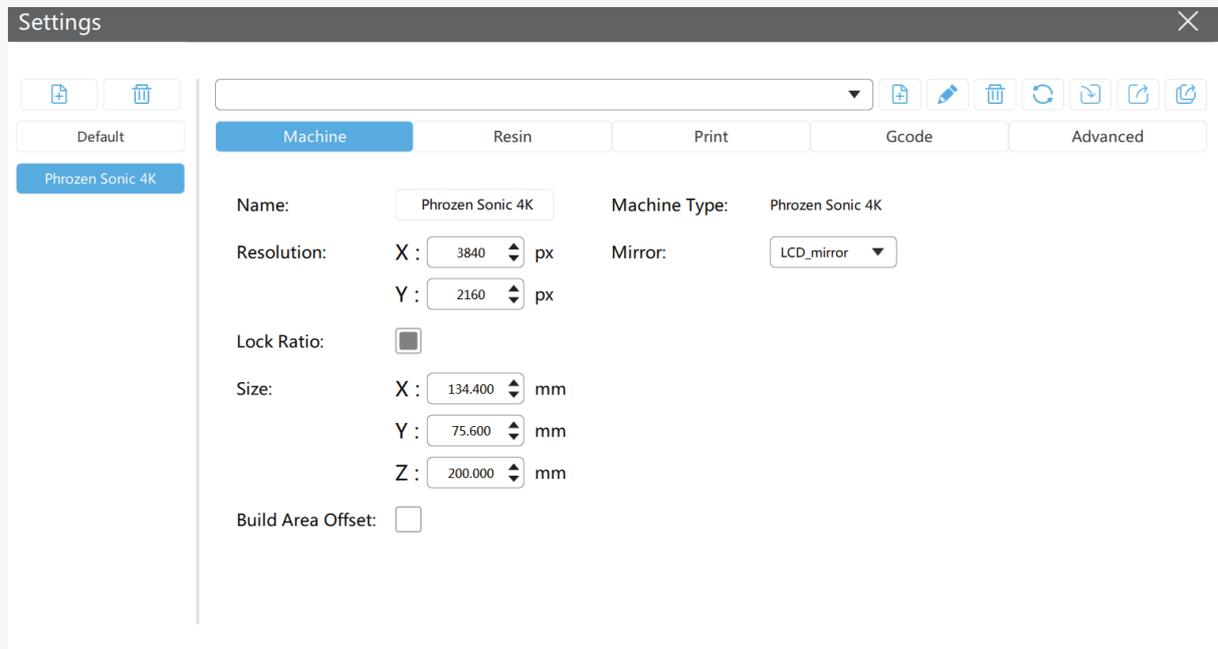

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Phrozen Sonic 4k

Settings (50um)	Series 200	Series 400	Violet	SureCast - Open Grow
Bottom Layer Count	6	6	6	6
Exposure Time	7.5 to 9	7.5 to 9	4.7 to 5	7.5 to 9
Bottom Exposure Time	35 to 40	35 to 40	40 to 50	35 to 40
Transition Layer Count	6	6	6	6
Transition Type	Linear	Linear	Linear	Linear
Transition Time Decrement	N/A	N/A	N/A	N/A
Waiting Mode During Printing	Light Off Delay	Light Off Delay	Light Off Delay	Light Off Delay
Light-off Delay	14	14	15	14
Bottom Light Off Delay	14	14	15	14
Bottom Lifting Distance	6 + 0	6 + 0	6 + 0	6 + 0
Lifting Distance	6 + 0	6 + 0	6 + 0	6 + 0
Bottom Retract Distance	6 + 0	6 + 0	6 + 0	6 + 0
Retract Distance	6 + 0	6 + 0	6 + 0	6 + 0
Bottom Lift Speed	60 & 0	60 & 0	60 & 0	60 & 0
Lifting Speed	60 & 0	60 & 0	60 & 0	60 & 0
Bottom Retract Speed	150 & 0	150 & 0	150 & 0	150 & 0
Retract Speed	150 & 0	150 & 0	150 & 0	150 & 0

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TIPS

Always find the same printer brand or updated profile to be your reference as your starting point.

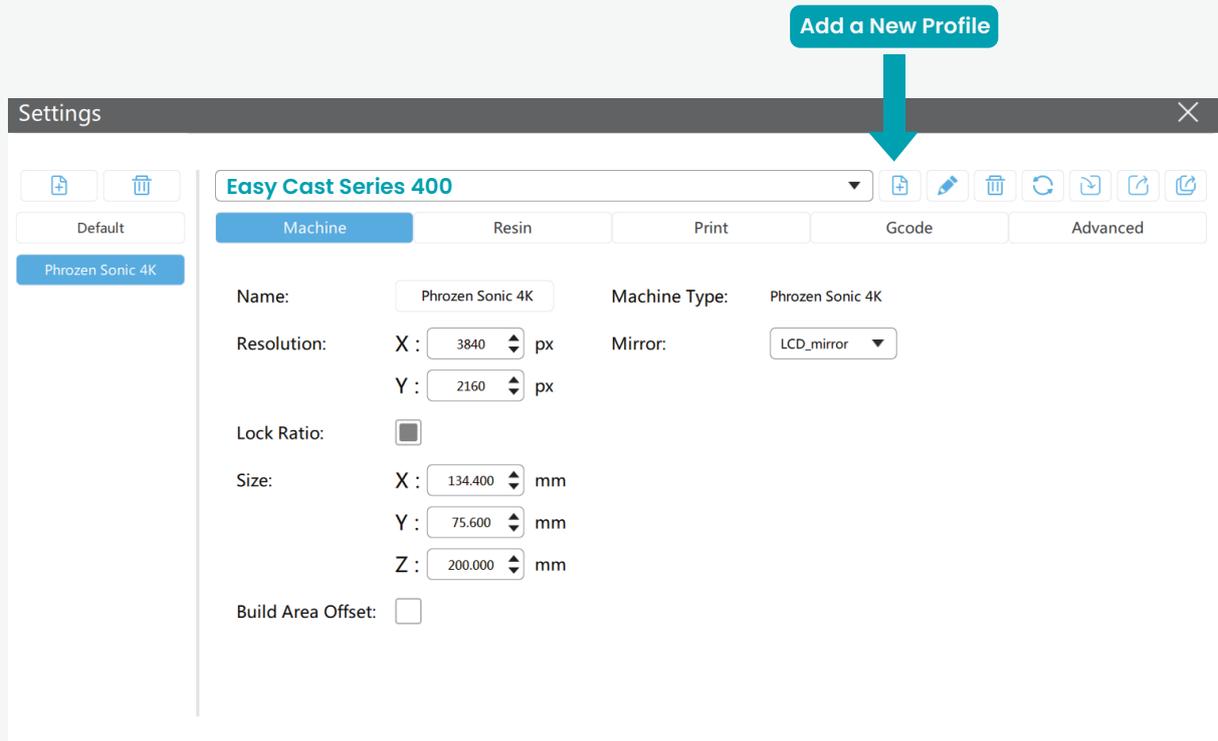*This guideline is compatible exclusively for LCD printers only

Settings

| Machine | Resin | Print | Gcode | Advanced |

Default

Phrozen Sonic 4K

Name: Phrozen Sonic 4K   Machine Type: Phrozen Sonic 4K

Resolution: X :   3840   px   Mirror: LCD_mirror ▼

                 Y :   2160   px

Lock Ratio: ☐

Size: X :   134.400   mm

                 Y :   75.600   mm

                 Z :   200.000   mm

Build Area Offset: ☐

* Before attempting to test the profile settings yourself, it is advisable to carefully follow manufacturer's instructions. This is crucial to avoid the potential risk of mishandling your 3D printer.

* This guideline is compatible exclusively for LCD printers only

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Choose your Printer

Choose your specific 3D printer model from the software's settings or configuration menu. This step is crucial because it ensures that the software uses the correct print parameters for your machine.

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Add a New Profile

Settings

Easy Cast Series 400 ▼				
Machine	Resin	Print	Gcode	Advanced

Name: Phrozen Sonic 4K   Machine Type: Phrozen Sonic 4K

Resolution: X : [3840] px   Mirror: [LCD_mirror ▼]

               Y : [2160] px

Lock Ratio: ☐

Size: X : [134.400] mm

          Y : [75.600] mm

          Z : [200.000] mm

Build Area Offset: ☐

Default   Phrozen Sonic 4K

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Add a New Profile

Create a new profile and give it the name of our resin for future reference. Enter the profile settings as directed on our printer setting page.

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Test Print

Print a 10x10x10mm Block with those recommended settings.

10X10X10 mm

Measure each length of the block in the X and Y directions. If it is less than 10mm, slightly increase the Exposure Time by 0.5-1 second each time.
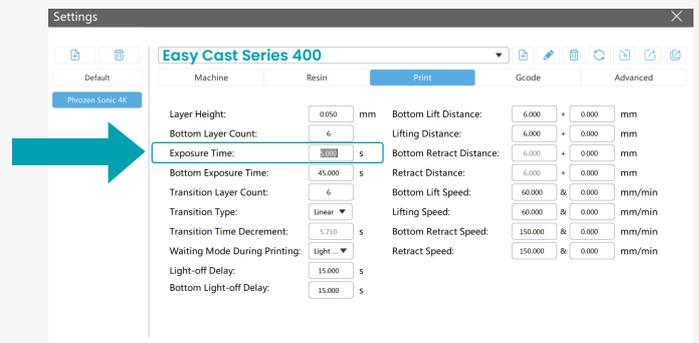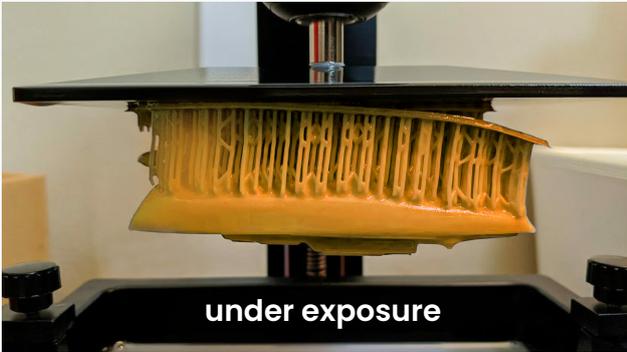
Exposure Time: ~~5~~ s

5.5

Under Exposure

If it exceeds 10mm, slightly decrease the Exposure Time by 0.5-1 second each time.

Exposure Time: ~~5~~ s

4.5

Over Exposure

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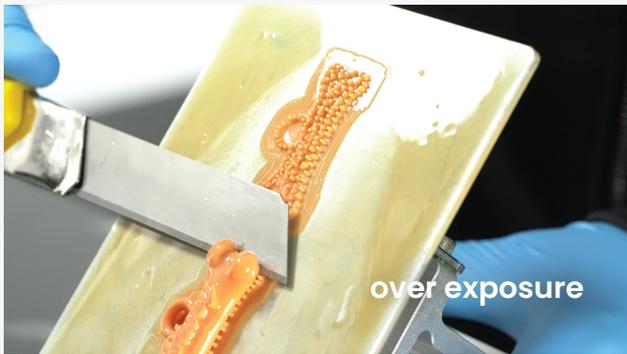**under exposure**

over exposure

Bottom Exposure Time

If you notice the print has difficulty adhering to the buildplate while printing, increase the bottom exposure time by 3-5 second each time.
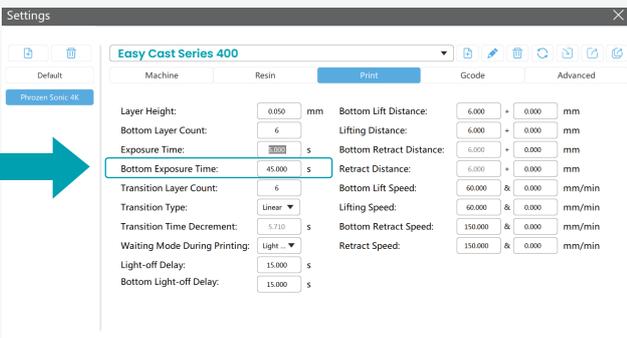
Bottom Exposure Time: 45.000   s

48.000

If you notice the print is hard to remove from the buildplate, decrease the bottom exposure time by 3-5 second each time.

Bottom Exposure Time: 45.000   s

42.000

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TIPS

Chitubox has a default bottom exposure time of 50 seconds. You can often make small adjustments, typically between 3 and 5 seconds, to correct for overexposure or underexposure.