

|                                                                                   |                            |                            |
|-----------------------------------------------------------------------------------|----------------------------|----------------------------|
|  | <b>3D Printer Settings</b> | Document No. F.3D.PS.01    |
|                                                                                   |                            | Issue No. 01               |
|                                                                                   | <b>PREVEST//3D</b>         | Revision No. 01            |
|                                                                                   |                            | Effective Date. 03/04/2024 |

# PREVEST//3D



## 3D PRINTER SETTINGS

|                     |                          |                           |
|---------------------|--------------------------|---------------------------|
| Asiga Max UV 385    | Phrozen Sonic Mini 8K    | Anycubic Photon Mono X 6K |
| Uniformation GK 2   | Phrozen Sonic Mini 4K    | Phrozen Sonic Mini 8KS    |
| Piocreat CO2        | Anycubic Photon Mono 4K  | Elegoo Mars 5 Ultra       |
| Anycubic photon x   | Anycubic Photon Mono SE  | Anycubic photon ultra     |
| Elegoo Mars 4 Ultra | Anycubic Photon S        | Elegoo Saturn 2           |
| Elegoo Saturn 8K    | Anycubic Photon Mono M5s |                           |

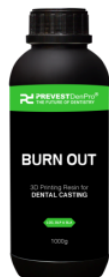


### Asiga Max UV 385 (0.025 – 0.1 μ)



- Slicing Software Asiga Composer 2.0.

How to use Prevest Resins on Asiga Printers ?

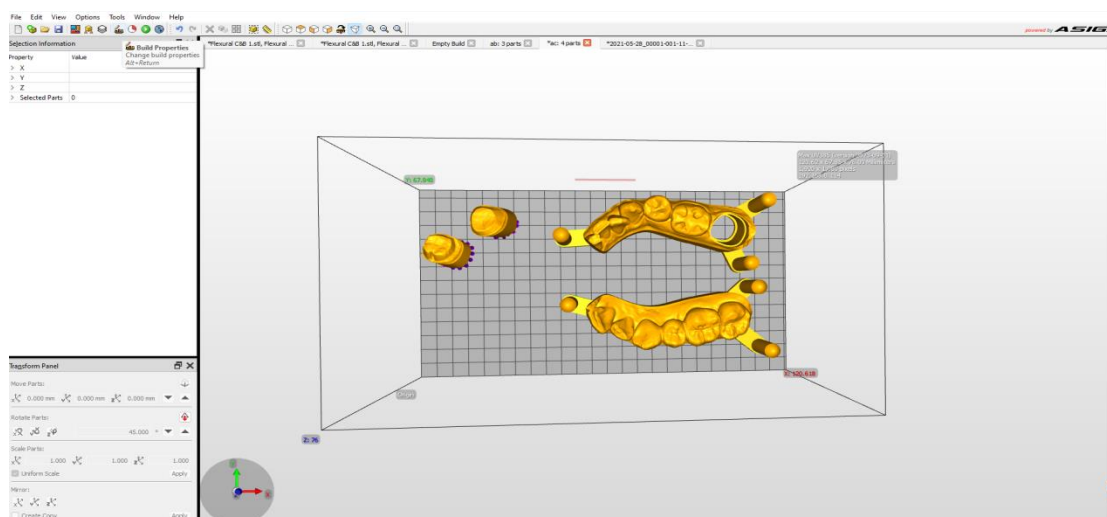


To access the .ini Files please visit our website [www.prevest3d.com](http://www.prevest3d.com)

|                                                                                   |                              |                            |
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1. First download and save the Prevest Model Pro---2.ini file in any folder of the drive.
2. Open Asiga composer and click on the build properties icon.



3. In build properties folder, click Import Material Profile and then small window opens which depicts Import Into Composer or HP (depends upon type of system, using).

4. Click the second option rather than Composer and new windows open which takes into the computer system and then move into the folder where.INI has been saved. Select the file and click yes for upload. Finally the composer will show **Loaded:.INI**

|                                                                                   |                            |                            |
|-----------------------------------------------------------------------------------|----------------------------|----------------------------|
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## Validated Post Curing Unit

- Printed Materials are validated for Post Curing on Asiga Flash Cure Box or any post curing unit with specifications (UV 405NM, 36W).



**Prevest Model Pro**  
Post Curing Time: 30 min.



**Prevest Model**  
Post Curing Time: 20 min.



**Prevest Surgical Guide**  
Post Curing Time: 3-5 min.



**Prevest Denture**  
Post Curing Time: 15 min.



**Prevest Burn Out**  
Post Curing Time: 15 min.



**Prevest C&B Interim**  
Post Curing Time: 30 min.



**Prevest C&B Ceramic**  
Post Curing Time: 30 min.



**Prevest C&B Permanent**  
Post Curing Time: 30 min.



|                                                                                   |                              |                            |
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# Support Settings In Chitubox

## For Basic Chitubox Basic V1.9.3 version

Z Lift Height(mm)5.00

Support Setting:

Light

Medium

Heavy

Top

Middle

Bottom

Raft

Contact ShapeNone

Contact Diameter(mm)1.20

Contact Depth(mm)1.20

Connection ShapeCone

Upper Diameter(mm)0.80

Lower Diameter(mm)1.20

Connection Length(mm)2.00

Auto/Manual Support:

Cross Width(mm)4.00

Cross Start Height(mm)3.00

Density(%)50.00

Angle(°)45.00

+Platform

+All

Remove All

Z Lift Height(mm)5.00

Support Setting:

Light

Medium

Heavy

Top

Middle

Bottom

Raft

ShapeCylinder

Diameter(mm)1.20

Angle(°)70.00

Small Pillar ShapeCone

Diameter(mm)0.50

Upper Depth(mm)0.30

Lower Depth(mm)0.30

Auto/Manual Support:

Cross Width(mm)4.00

Cross Start Height(mm)3.00

Density(%)50.00

Angle(°)45.00

+Platform

+All

Remove All

Z Lift Height(mm)5.00

Support Setting:

Light

Medium

Heavy

Top

Middle

Bottom

Raft

Platform Touch ShapeSkate

Touch Diameter(mm)12.00

Thickness1.00

Model Contact ShapeNone

Contact Diameter(mm)0.60

Contact Depth(mm)0.20

Contact Point1

Auto/Manual Support:

Cross Width(mm)4.00

Cross Start Height(mm)3.00

Density(%)50.00

Angle(°)45.00

+Platform

+All

Remove All

Z Lift Height(mm)5.00

Support Setting:

Light

Medium

Heavy

Top

Middle

Bottom

Raft

Raft ShapeNone

Raft Area Ratio(%)110.00

Raft Thickness(mm)1.00

Raft Height(mm)1.80

Raft Slope(°)30.00

Auto/Manual Support:

Cross Width(mm)4.00

Cross Start Height(mm)3.00

Density(%)50.00

Angle(°)45.00

+Platform

+All

Remove All

[www.prevest3d.com](http://www.prevest3d.com)  
 Printer Settings

## Support Settings In Chitubox

### For Basic Chitubox Basic V2 version

| Top                                    | Middle                                                   |
|----------------------------------------|----------------------------------------------------------|
| Touch Shape <div>None</div>            | Shape <div>Cylinder</div>                                |
| Contact Depth(mm) <div>1.20</div>      | Diameter(mm) <div>1.20</div>                             |
| Connection Shape <div>Cone</div>       | Angle(°) <div>70.00</div>                                |
| Tip Upper Diameter(mm) <div>1.20</div> | Small Pillar Shape <div>Cone</div>                       |
| Tip Down Diameter(mm) <div>1.20</div>  | Diameter(mm) <div>0.50</div>                             |
| Connection Length(mm) <div>2.00</div>  | Upper Depth(mm) <div>0.30</div>                          |
|                                        | Lower Depth(mm) <div>0.30</div>                          |
|                                        | Maximum Spacing Of Cross Structure(...) <div>30.00</div> |
|                                        | Cross Start Height <div>3.00</div>                       |

| Bottom                                | Raft                                  |
|---------------------------------------|---------------------------------------|
| Platform Touch Shape <div>Skate</div> | Raft Shape <div>None</div>            |
| Touch Diameter(mm) <div>12.00</div>   | Raft Area Ratio(%) <div>110.00</div>  |
| Thickness(mm) <div>1.00</div>         | Raft Thickness (mm) <div>1.00</div>   |
| Model Contact Shape <div>None</div>   | Raft Height(mm) <div>1.80</div>       |
| Contact Diameter(mm) <div>0.60</div>  | Raft Slope(°) <div>30.00</div>        |
| Contact Depth(mm) <div>0.20</div>     | Grid Side Length (mm) <div>2.00</div> |
| Contact Point <div>1</div>            | Grid Width (mm) <div>2.00</div>       |



## UniFORMATION GK TWO (0.025 – 0.1 μ)



- Slicing Software Chitu Box.
- Follow the settings of **Prevest Model Pro.**




Settings

+

+

Default

AnyCubic Photon Ultra

UniFORMATION GKtwo

Prevest Model Pro

MachineResinPrintGcodeAdvanced

Layer Height:

0.050

mm

Bottom Lift Distance:

3.000

+

4.000

mm

Bottom Layer Count:

5

Lifting Distance:

2.000

+

4.000

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

5.500

+

1.500

mm

Bottom Exposure Time:

50.000

s

Retract Distance:

4.500

+

1.500

mm

Transition Layer Count:

5

Bottom Lift Speed:

90.000

&

320.000

mm/min

Transition Type:

Linear

Lifting Speed:

90.000

&

320.000

mm/min

Transition Time Decrement:

7.500

s

Bottom Retract Speed:

320.000

&

90.000

mm/min

Waiting Mode During Printing:

Restin...

Retract Speed:

320.000

&

90.000

mm/min

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

1.000

s

- Follow the settings of **Prevest Model.**




Settings

+

+

Default

AnyCubic Photon Ultra

UniFORMATION GKtwo

Prevest Model

MachineResinPrintGcodeAdvanced

Layer Height:

0.050

mm

Bottom Lift Distance:

3.000

+

4.000

mm

Bottom Layer Count:

5

Lifting Distance:

2.000

+

4.000

mm

Exposure Time:

2.000

s

Bottom Retract Distance:

5.500

+

1.500

mm

Bottom Exposure Time:

30.000

s

Retract Distance:

4.500

+

1.500

mm

Transition Layer Count:

8

Bottom Lift Speed:

90.000

&

320.000

mm/min

Transition Type:

Linear

Lifting Speed:

90.000

&

320.000

mm/min

Transition Time Decrement:

3.110

s

Bottom Retract Speed:

320.000

&

90.000

mm/min

Waiting Mode During Printing:

Restin...

Retract Speed:

320.000

&

90.000

mm/min

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

1.000

s

[www.prevest3d.com](http://www.prevest3d.com)

Printer Settings

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- Follow the settings of **Prevest Surgical Guide**.




Settings
 ✕

+

✖

Default

AnyCubic Photon Ultra

UniForm GKtwo

Prevest Surgical Guide

Machine

Resin

Print

Gcode

Advanced

|                               |                                     |    |                          |                                      |   |                                      |        |
|-------------------------------|-------------------------------------|----|--------------------------|--------------------------------------|---|--------------------------------------|--------|
| Layer Height:                 | <input type="text" value="0.050"/>  | mm | Bottom Lift Distance:    | <input type="text" value="3.000"/>   | + | <input type="text" value="4.000"/>   | mm     |
| Bottom Layer Count:           | <input type="text" value="5"/>      |    | Lifting Distance:        | <input type="text" value="3.000"/>   | + | <input type="text" value="4.000"/>   | mm     |
| Exposure Time:                | <input type="text" value="5.000"/>  | s  | Bottom Retract Distance: | <input type="text" value="5.500"/>   | + | <input type="text" value="1.500"/>   | mm     |
| Bottom Exposure Time:         | <input type="text" value="50.000"/> | s  | Retract Distance:        | <input type="text" value="5.500"/>   | + | <input type="text" value="1.500"/>   | mm     |
| Transition Layer Count:       | <input type="text" value="5"/>      |    | Bottom Lift Speed:       | <input type="text" value="90.000"/>  | & | <input type="text" value="320.000"/> | mm/min |
| Transition Type:              | <div>Linear ▾</div>                 |    | Lifting Speed:           | <input type="text" value="90.000"/>  | & | <input type="text" value="320.000"/> | mm/min |
| Transition Time Decrement:    | <input type="text" value="7.500"/>  | s  | Bottom Retract Speed:    | <input type="text" value="320.000"/> | & | <input type="text" value="90.000"/>  | mm/min |
| Waiting Mode During Printing: | <div>Restin... ▾</div>              |    | Retract Speed:           | <input type="text" value="320.000"/> | & | <input type="text" value="90.000"/>  | mm/min |
| Rest Time Before Lift:        | <input type="text" value="0.000"/>  | s  |                          |                                      |   |                                      |        |
| Rest Time After Lift:         | <input type="text" value="0.000"/>  | s  |                          |                                      |   |                                      |        |
| Rest Time After Retract:      | <input type="text" value="1.000"/>  | s  |                          |                                      |   |                                      |        |

- Follow the settings of **Prevest Denture**.




Settings
 ✕

+

✖

Default

AnyCubic Photon Ultra

UniForm GKtwo

Prevest Denture

Machine

Resin

Print

Gcode

Advanced

|                               |                                     |    |                          |                                      |   |                                      |        |
|-------------------------------|-------------------------------------|----|--------------------------|--------------------------------------|---|--------------------------------------|--------|
| Layer Height:                 | <input type="text" value="0.050"/>  | mm | Bottom Lift Distance:    | <input type="text" value="3.000"/>   | + | <input type="text" value="4.000"/>   | mm     |
| Bottom Layer Count:           | <input type="text" value="5"/>      |    | Lifting Distance:        | <input type="text" value="3.000"/>   | + | <input type="text" value="4.000"/>   | mm     |
| Exposure Time:                | <input type="text" value="5.000"/>  | s  | Bottom Retract Distance: | <input type="text" value="5.500"/>   | + | <input type="text" value="1.500"/>   | mm     |
| Bottom Exposure Time:         | <input type="text" value="50.000"/> | s  | Retract Distance:        | <input type="text" value="5.500"/>   | + | <input type="text" value="1.500"/>   | mm     |
| Transition Layer Count:       | <input type="text" value="8"/>      |    | Bottom Lift Speed:       | <input type="text" value="90.000"/>  | & | <input type="text" value="320.000"/> | mm/min |
| Transition Type:              | <div>Linear ▾</div>                 |    | Lifting Speed:           | <input type="text" value="90.000"/>  | & | <input type="text" value="320.000"/> | mm/min |
| Transition Time Decrement:    | <input type="text" value="5.000"/>  | s  | Bottom Retract Speed:    | <input type="text" value="320.000"/> | & | <input type="text" value="90.000"/>  | mm/min |
| Waiting Mode During Printing: | <div>Restin... ▾</div>              |    | Retract Speed:           | <input type="text" value="320.000"/> | & | <input type="text" value="90.000"/>  | mm/min |
| Rest Time Before Lift:        | <input type="text" value="0.000"/>  | s  |                          |                                      |   |                                      |        |
| Rest Time After Lift:         | <input type="text" value="0.000"/>  | s  |                          |                                      |   |                                      |        |
| Rest Time After Retract:      | <input type="text" value="1.000"/>  | s  |                          |                                      |   |                                      |        |

[www.prevest3d.com](http://www.prevest3d.com)  
 Printer Settings

8

- Follow the settings of **Prevest Burn Out**.




Settings
 

+

🗑️

Default

AnyCubic Photon Ultra

UniFormation GKtwo

Prevest Burn Out

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

1.000

s

Bottom Lift Distance:

3.000

+

4.000

mm

Lifting Distance:

3.000

+

4.000

mm

Bottom Retract Distance:

5.500

+

1.500

mm

Retract Distance:

5.500

+

1.500

mm

Bottom Lift Speed:

90.000

&

320.000

mm/min

Lifting Speed:

90.000

&

320.000

mm/min

Bottom Retract Speed:

320.000

&

90.000

mm/min

Retract Speed:

320.000

&

90.000

mm/min

- Follow the settings of **Prevest C&B Ceramic**.




Settings
 

+

🗑️

Default

AnyCubic Photon Ultra

UniFormation GKtwo

Prevest C&B Ceramic

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

8

Transition Type:

Linear

Transition Time Decrement:

5.000

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

1.000

s

Bottom Lift Distance:

3.000

+

4.000

mm

Lifting Distance:

3.000

+

4.000

mm

Bottom Retract Distance:

5.500

+

1.500

mm

Retract Distance:

5.500

+

1.500

mm

Bottom Lift Speed:

90.000

&

320.000

mm/min

Lifting Speed:

90.000

&

320.000

mm/min

Bottom Retract Speed:

320.000

&

90.000

mm/min

Retract Speed:

320.000

&

90.000

mm/min

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 Printer Settings

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|                                                                                   |                              |                            |
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- Follow the settings of **Prevest C&B Permanent**.




Settings

+

✖

Default

AnyCubic Photon Ultra

UniFormation GKtwo

Prevest C&B Permanent

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.05

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

1.000

s

Bottom Lift Distance:

3.000

+

4.000

mm

Lifting Distance:

3.000

+

4.000

mm

Bottom Retract Distance:

5.500

+

1.500

mm

Retract Distance:

5.500

+

1.500

mm

Bottom Lift Speed:

90.000

&

320.000

mm/min

Lifting Speed:

90.000

&

320.000

mm/min

Bottom Retract Speed:

320.000

&

90.000

mm/min

Retract Speed:

320.000

&

90.000

mm/min

- Follow the settings of **Prevest C&B Interim**.




Settings

+

✖

Default

AnyCubic Photon Ultra

UniFormation GKtwo

Prevest C&B Interim

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.05

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

8

Transition Type:

Linear

Transition Time Decrement:

5.000

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

1.000

s

Bottom Lift Distance:

3.000

+

4.000

mm

Lifting Distance:

3.000

+

4.000

mm

Bottom Retract Distance:

5.500

+

1.500

mm

Retract Distance:

5.500

+

1.500

mm

Bottom Lift Speed:

90.000

&

320.000

mm/min

Lifting Speed:

90.000

&

320.000

mm/min

Bottom Retract Speed:

320.000

&

90.000

mm/min

Retract Speed:

320.000

&

90.000

mm/min

[www.prevest3d.com](http://www.prevest3d.com)  
 Printer Settings

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### PIOCREAT C02 (0.025 – 0.1 μ)

- Slicing Software Chitu Box.
- Follow the settings of **Prevest Model Pro.**



Prevest Model Pro

Prevest Denture

Prevest C&B Interim

Prevest C&B Permanent

Prevest C&B Ceramic

Prevest Surgical Guide

Prevest Burn Out

Print

Layer Height

0.050

mm

Bottom Layer Count

5

Exposure Time

5.000

s

Bottom Exposure Time

50.000

s

Light-off Delay

4.000

s

Lifting Distance

8.000

+

0.000

mm

Lifting Speed

600.000

+

0.000

mm/min

Advance

Bottom Light PWM

255

/

Light PWM

255

/

Picture Grayscale

255

Anti-aliasing

None

- Follow the settings of **Prevest Model.**



Prevest Model Pro

Prevest Denture

Prevest C&B Interim

Prevest C&B Permanent

Prevest C&B Ceramic

Prevest Model

Prevest Surgical Guide

Prevest Burn Out

Print

Layer Height

0.050

mm

Bottom Layer Count

5

Exposure Time

5.000

s

Bottom Exposure Time

50.000

s

Light-off Delay

4.000

s

Lifting Distance

8.000

+

0.000

mm

Lifting Speed

600.000

+

0.000

mm/min

Advance

Bottom Light PWM

255

/

Light PWM

255

/

Picture Grayscale

255

Anti-aliasing

None



|                                                                                   |                     |  |                            |
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- Follow the settings of **Prevest Surgical Guide**.



Prevest Surgical Guide

Print

Layer Height

0.050

mm

Bottom Layer Count

5

Exposure Time

5.000

s

Bottom Exposure Time

50.000

s

Light-off Delay

4.000

s

Lifting Distance

8.000

+

0.000

mm

Lifting Speed

600.000

+

0.000

mm/min

Advance

Bottom Light PWM

255

/

Light PWM

255

/

Picture Grayscale

255

Anti-aliasing

None

- Follow the settings of **Prevest Denture**.



Prevest Denture

Prevest Surgical Guide

Prevest Burn Out

Print

Layer Height

0.050

mm

Bottom Layer Count

5

Exposure Time

5.000

s

Bottom Exposure Time

50.000

s

Light-off Delay

4.000

s

Lifting Distance

8.000

+

0.000

mm

Lifting Speed

600.000

+

0.000

mm/min

Advance

Bottom Light PWM

255

/

Light PWM

255

/

Picture Grayscale

255

Anti-aliasing

None

|                                                                                   |                            |  |                            |
|-----------------------------------------------------------------------------------|----------------------------|--|----------------------------|
|  | <b>3D Printer Settings</b> |  | Document No. F.3D.PS.01    |
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- Follow the settings of **Prevest Burn Out**.



Prevest Surgical Guide

Prevest Burn Out

Print

Layer Height

0.050

mm

Bottom Layer Count

5

Exposure Time

5.000

s

Bottom Exposure Time

50.000

s

Lifting Distance

8.000

+

0.000

mm

Lifting Speed

600.000

+

0.000

mm/min

Light-off Delay

4.000

s

Advance

Bottom Light PWM

255

/

Light PWM

255

/

Picture Grayscale

255

Anti-aliasing

None

- Follow the settings of **Prevest C&B Ceramic**.



Prevest Denture

Prevest C&B Interim

Prevest C&B Permanent

Prevest C&B Ceramic

Prevest Surgical Guide

Prevest Burn Out

Print

Layer Height

0.050

mm

Bottom Layer Count

5

Exposure Time

5.000

s

Bottom Exposure Time

50.000

s

Lifting Distance

8.000

+

0.000

mm

Lifting Speed

600.000

+

0.000

mm/min

Light-off Delay

4.000

s

Advance

Bottom Light PWM

255

/

Light PWM

255

/

Picture Grayscale

255

Anti-aliasing

None

- Follow the settings of **Prevest C&B Permanent**.



Prevest Denture

Prevest C&B Interim

**Prevest C&B Permanent**

Prevest Surgical Guide

Prevest Burn Out

Print

Layer Height

0.050

mm

Bottom Layer Count

5

Exposure Time

5.000

s

Bottom Exposure Time

50.000

s

Light-off Delay

4.000

s

Advance

Bottom Light PWM

255

/

Light PWM

255

/

Picture Grayscale

255

Anti-aliasing

None

Lifting Distance

8.000

+

0.000

mm

Lifting Speed

600.000

+

0.000

mm/min

- Follow the settings of **Prevest C&B Interim**.



Prevest Denture

**Prevest C&B Interim**

Prevest Surgical Guide

Prevest Burn Out

Print

Layer Height

0.050

mm

Bottom Layer Count

5

Exposure Time

5.000

s

Bottom Exposure Time

50.000

s

Light-off Delay

4.000

s

Advance

Bottom Light PWM

255

/

Light PWM

255

/

Picture Grayscale

255

Anti-aliasing

None

Lifting Distance

8.000

+

0.000

mm

Lifting Speed

600.000

+

0.000

mm/min

|                                                                                  |                              |                            |
|----------------------------------------------------------------------------------|------------------------------|----------------------------|
|  | <h1>3D Printer Settings</h1> | Document No. F.3D.PS.01    |
|                                                                                  |                              | Issue No. 01               |
|                                                                                  | <h2>PREVEST//3D</h2>         | Revision No. 01            |
|                                                                                  |                              | Effective Date. 03/04/2024 |

## Any cubic Photon Ultra (0.05 – 0.1 μ)



- Slicing Software Chitu Box all versions.
- Follow the settings of **Prevest Model Pro.**



Settings

+

−

Default

Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 8K

AnyCubic Photon Ultra

AnyCubic Photon S \*1

Prevest New Printer

EPAX DX1 PRO

Galaxy 1

Galaxy 1 \*1

Galaxy 1 \*2

AnyCubic P... Mono X 6K

ELEGOO MARS 3

Prevest Model Pro

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

5.000

mm

Lifting Distance:

5.000

mm

Bottom Retract Distance:

5.000

mm

Retract Distance:

5.000

mm

Bottom Lift Speed:

120.000

mm/min

Lifting Speed:

120.000

mm/min

Bottom Retract Speed:

120.000

mm/min

Retract Speed:

120.000

mm/min

- Follow the settings of **Prevest Model.**



Settings

+

−

Default

Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 8K

AnyCubic Photon Ultra

AnyCubic Photon S \*1

Prevest New Printer

EPAX DX1 PRO

Galaxy 1

Galaxy 1 \*1

Galaxy 1 \*2

AnyCubic P... Mono X 6K

ELEGOO MARS 3

Prevest Model

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

5.000

mm

Lifting Distance:

5.000

mm

Bottom Retract Distance:

5.000

mm

Retract Distance:

5.000

mm

Bottom Lift Speed:

120.000

mm/min

Lifting Speed:

120.000

mm/min

Bottom Retract Speed:

120.000

mm/min

Retract Speed:

120.000

mm/min

Document No. F.3D.PS.01

Issue No. 01

Revision No. 01

Effective Date. 03/04/2024

**PREVEST // 3D**



- Follow the settings of **Prevest Denture**.



|                                                                                   |                              |                            |
|-----------------------------------------------------------------------------------|------------------------------|----------------------------|
|  | <h1>3D Printer Settings</h1> | Document No. F.3D.PS.01    |
|                                                                                   |                              | Issue No. 01               |
|                                                                                   | <h2>PREVEST//3D</h2>         | Revision No. 01            |
|                                                                                   |                              | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest Burn Out**.




Settings

+

+

Default

Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 8K

AnyCubic Photon Ultra

AnyCubic Photon S \*1

Prevest New Printer

EPAX DX1 PRO

Galaxy 1

Galaxy 1 \*1

Galaxy 1 \*2

AnyCubic P... Mono X 6K

ELEGOO MARS 3

Prevest Burn Out

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.0

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

5.000

mm

Lifting Distance:

5.000

mm

Bottom Retract Distance:

5.000

mm

Retract Distance:

5.000

mm

Bottom Lift Speed:

120.000

mm/min

Lifting Speed:

120.000

mm/min

Bottom Retract Speed:

120.000

mm/min

Retract Speed:

120.000

mm/min

- Follow the settings of **Prevest C&B Ceramic**.




Settings

+

+

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

UniFormation GKtwo

Prevest C&B Ceramic

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

5.000

mm

Lifting Distance:

5.000

mm

Bottom Retract Distance:

5.000

mm

Retract Distance:

5.000

mm

Bottom Lift Speed:

120.000

mm/min

Lifting Speed:

120.000

mm/min

Bottom Retract Speed:

120.000

mm/min

Retract Speed:

120.000

mm/min

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Printer Settings

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|                                                                                   |                     |  |                            |
|-----------------------------------------------------------------------------------|---------------------|--|----------------------------|
|  | 3D Printer Settings |  | Document No. F.3D.PS.01    |
|                                                                                   |                     |  | Issue No. 01               |
|                                                                                   | PREVEST//3D         |  | Revision No. 01            |
|                                                                                   |                     |  | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest C&B Permanent**.




Settings

+

−

Default

Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 8K

**AnyCubic Photon Ultra**

AnyCubic Photon S \*1

Prevest New Printer

EPAX DX1 PRO

Galaxy 1

Galaxy 1 \*1

Galaxy 1 \*2

AnyCubic P... Mono X 6K

ELEGOO MARS 3

Prevest C&B Permanent

Machine

Resin

**Print**

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

5.000

mm

Lifting Distance:

5.000

mm

Bottom Retract Distance:

5.000

mm

Retract Distance:

5.000

mm

Bottom Lift Speed:

120.000

mm/min

Lifting Speed:

120.000

mm/min

Bottom Retract Speed:

120.000

mm/min

Retract Speed:

120.000

mm/min

- Follow the settings of **Prevest C&B Interim**.




Settings

+

−

Default

Phrozen Sonic Mighty 4K

Phrozen Sonic Mini 8K

**AnyCubic Photon Ultra**

AnyCubic Photon S \*1

Prevest New Printer

EPAX DX1 PRO

Galaxy 1

Galaxy 1 \*1

Galaxy 1 \*2

AnyCubic P... Mono X 6K

ELEGOO MARS 3

Prevest C&B Interim

Machine

Resin

**Print**

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

5.000

mm

Lifting Distance:

5.000

mm

Bottom Retract Distance:

5.000

mm

Retract Distance:

5.000

mm

Bottom Lift Speed:

120.000

mm/min

Lifting Speed:

120.000

mm/min

Bottom Retract Speed:

120.000

mm/min

Retract Speed:

120.000

mm/min



Document No. F.3D.PS.01

Issue No. 01

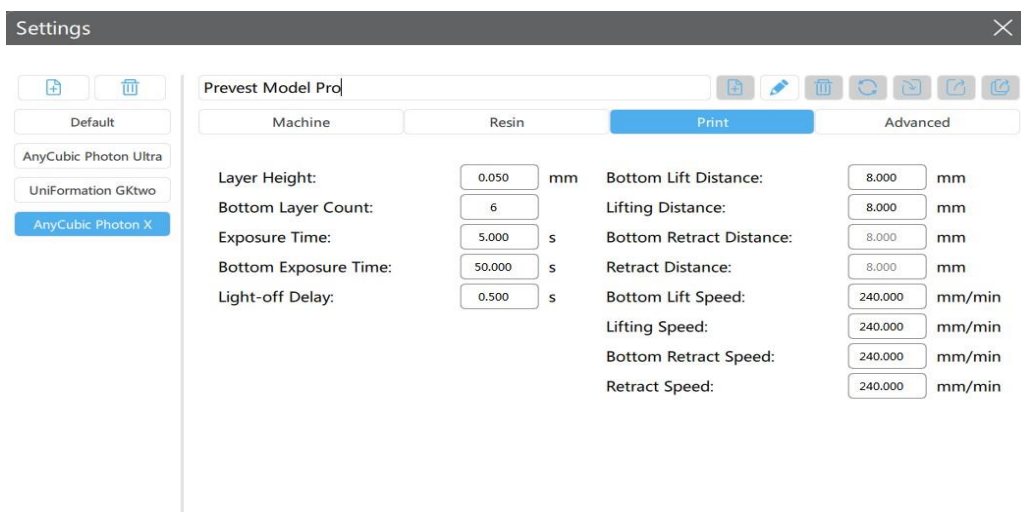
Revision No. 01

Effective Date. 03/04/2024

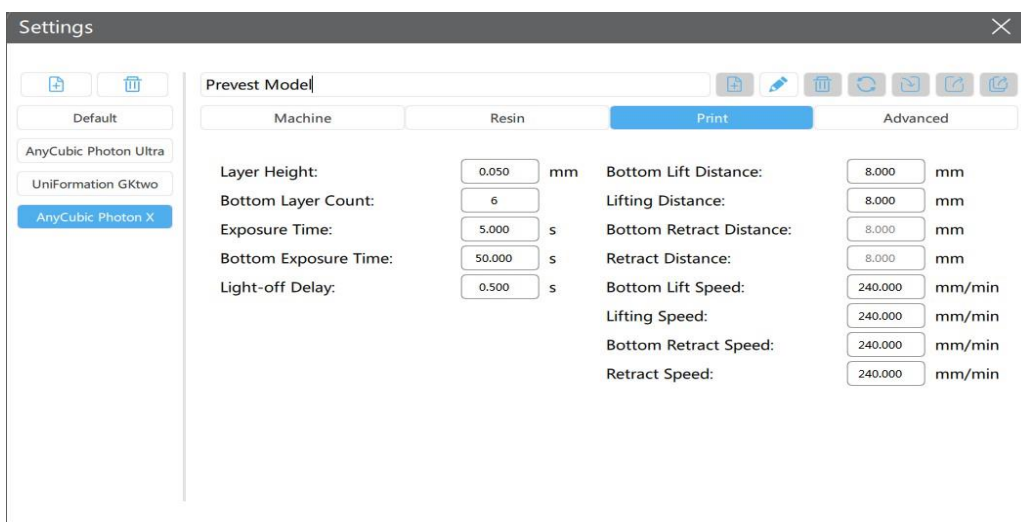
**PREVEST // 3D**



- Slicing Software Chitu Box all versions.
- Follow the settings of **Prevest Model Pro**.



- Follow the settings of **Prevest Model**.



|                                                                                   |                              |                            |
|-----------------------------------------------------------------------------------|------------------------------|----------------------------|
|  | <h1>3D Printer Settings</h1> | Document No. F.3D.PS.01    |
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|                                                                                   | <h2>PREVEST//3D</h2>         | Revision No. 01            |
|                                                                                   |                              | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest Surgical Guide**.




Settings

+

🗑

Default

AnyCubic Photon Ultra

UniFormation GKtwo

AnyCubic Photon X

Prevest Surgical Guide

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Light-off Delay:

0.500

s

Bottom Lift Distance:

8.000

mm

Lifting Distance:

8.000

mm

Bottom Retract Distance:

8.000

mm

Retract Distance:

8.000

mm

Bottom Lift Speed:

240.000

mm/min

Lifting Speed:

240.000

mm/min

Bottom Retract Speed:

240.000

mm/min

Retract Speed:

240.000

mm/min

- Follow the settings of **Prevest Denture**.




Settings

+

🗑

Default

AnyCubic Photon Ultra

UniFormation GKtwo

AnyCubic Photon X

Prevest Denture

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Light-off Delay:

0.500

s

Bottom Lift Distance:

8.000

mm

Lifting Distance:

8.000

mm

Bottom Retract Distance:

8.000

mm

Retract Distance:

8.000

mm

Bottom Lift Speed:

240.000

mm/min

Lifting Speed:

240.000

mm/min

Bottom Retract Speed:

240.000

mm/min

Retract Speed:

240.000

mm/min

- Follow the settings of **Prevest Burn Out**.



Settings

+

🗑️

Default

AnyCubic Photon Ultra

UniFormation GKtwo

AnyCubic Photon X

Prevest Burn Out

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Light-off Delay:

0.500

s

Bottom Lift Distance:

8.000

mm

Lifting Distance:

8.000

mm

Bottom Retract Distance:

8.000

mm

Retract Distance:

8.000

mm

Bottom Lift Speed:

240.000

mm/min

Lifting Speed:

240.000

mm/min

Bottom Retract Speed:

240.000

mm/min

Retract Speed:

240.000

mm/min

- Follow the settings of **Prevest C&B Ceramic**.



Settings

+

🗑️

Default

AnyCubic Photon Ultra

UniFormation GKtwo

AnyCubic Photon X

Prevest C&B Ceramic

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Light-off Delay:

0.500

s

Bottom Lift Distance:

8.000

mm

Lifting Distance:

8.000

mm

Bottom Retract Distance:

8.000

mm

Retract Distance:

8.000

mm

Bottom Lift Speed:

240.000

mm/min

Lifting Speed:

240.000

mm/min

Bottom Retract Speed:

240.000

mm/min

Retract Speed:

240.000

mm/min

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 Printer Settings

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- Follow the settings of **Prevest C&B Permanent**.



Settings

Prevest C&B Permanent

MachineResinPrintAdvanced

|                       |        |    |                          |         |        |
|-----------------------|--------|----|--------------------------|---------|--------|
| Layer Height:         | 0.050  | mm | Bottom Lift Distance:    | 8.000   | mm     |
| Bottom Layer Count:   | 6      |    | Lifting Distance:        | 8.000   | mm     |
| Exposure Time:        | 5.000  | s  | Bottom Retract Distance: | 8.000   | mm     |
| Bottom Exposure Time: | 50.000 | s  | Retract Distance:        | 8.000   | mm     |
| Light-off Delay:      | 0.500  | s  | Bottom Lift Speed:       | 240.000 | mm/min |
|                       |        |    | Lifting Speed:           | 240.000 | mm/min |
|                       |        |    | Bottom Retract Speed:    | 240.000 | mm/min |
|                       |        |    | Retract Speed:           | 240.000 | mm/min |

- Follow the settings of **Prevest C&B Interim**.



Settings

Prevest C&B Interim

MachineResinPrintAdvanced

|                       |        |    |                          |         |        |
|-----------------------|--------|----|--------------------------|---------|--------|
| Layer Height:         | 0.050  | mm | Bottom Lift Distance:    | 8.000   | mm     |
| Bottom Layer Count:   | 6      |    | Lifting Distance:        | 8.000   | mm     |
| Exposure Time:        | 5.000  | s  | Bottom Retract Distance: | 8.000   | mm     |
| Bottom Exposure Time: | 50.000 | s  | Retract Distance:        | 8.000   | mm     |
| Light-off Delay:      | 0.500  | s  | Bottom Lift Speed:       | 240.000 | mm/min |
|                       |        |    | Lifting Speed:           | 240.000 | mm/min |
|                       |        |    | Bottom Retract Speed:    | 240.000 | mm/min |
|                       |        |    | Retract Speed:           | 240.000 | mm/min |

Document No. F.3D.PS.01

Issue No. 01

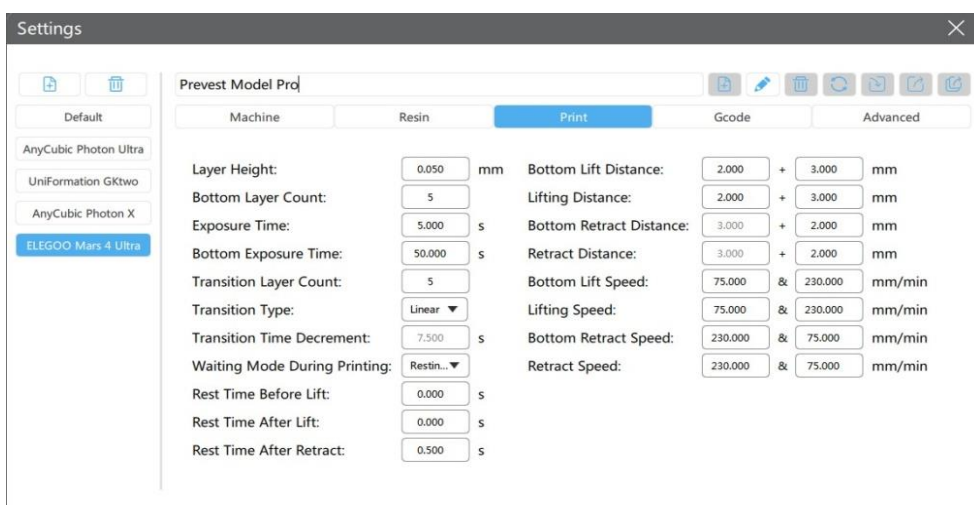
Revision No. 01

Effective Date. 03/04/2024

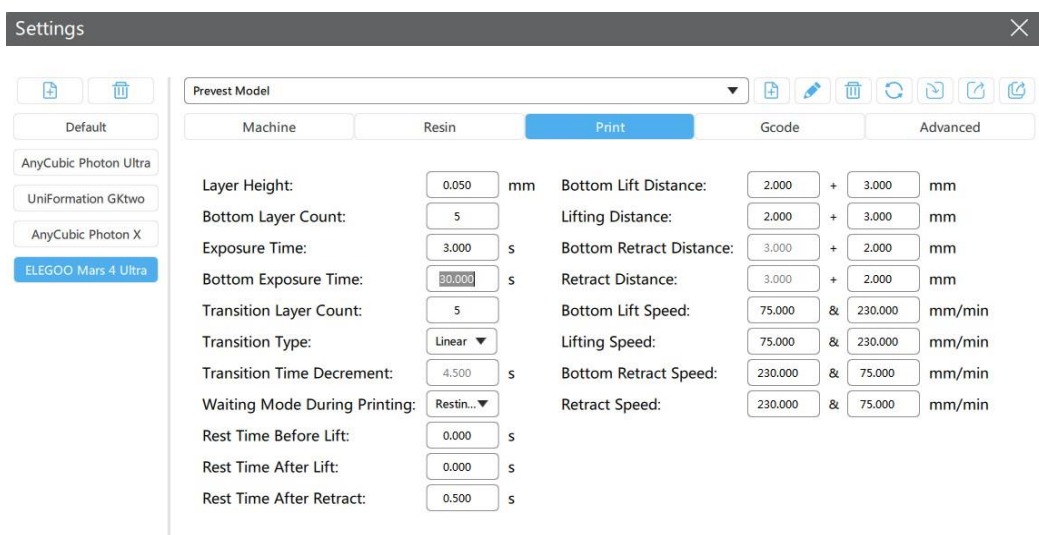
**PREVEST // 3D**



- Slicing Software Chitu Box all versions.
- Follow the settings of **Prevest Model Pro**.



- Follow the settings of **Prevest Model**.





|                                                                                  |                            |  |                            |
|----------------------------------------------------------------------------------|----------------------------|--|----------------------------|
|  | <b>3D Printer Settings</b> |  | Document No. F.3D.PS.01    |
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|                                                                                  |                            |  | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest Surgical Guide**.




Settings

+

+

Default

AnyCubic Photon Ultra

UniFormation Gktwo

AnyCubic Photon X

ELEGOO Mars 4 Ultra

Prevest Surgical Guide

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

Bottom Lift Distance:

2.000

+

3.000

mm

Lifting Distance:

2.000

+

3.000

mm

Bottom Retract Distance:

3.000

+

2.000

mm

Retract Distance:

3.000

+

2.000

mm

Bottom Lift Speed:

75.000

&

230.000

mm/min

Lifting Speed:

75.000

&

230.000

mm/min

Bottom Retract Speed:

230.000

&

75.000

mm/min

Retract Speed:

230.000

&

75.000

mm/min

- Follow the settings of **Prevest Denture**.




Settings

+

+

Default

AnyCubic Photon Ultra

UniFormation Gktwo

AnyCubic Photon X

ELEGOO Mars 4 Ultra

Prevest Denture

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.0

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

Bottom Lift Distance:

2.000

+

3.000

mm

Lifting Distance:

2.000

+

3.000

mm

Bottom Retract Distance:

3.000

+

2.000

mm

Retract Distance:

3.000

+

2.000

mm

Bottom Lift Speed:

75.000

&

230.000

mm/min

Lifting Speed:

75.000

&

230.000

mm/min

Bottom Retract Speed:

230.000

&

75.000

mm/min

Retract Speed:

230.000

&

75.000

mm/min

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Printer Settings

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|                                                                                  |                     |  |                            |
|----------------------------------------------------------------------------------|---------------------|--|----------------------------|
|  | 3D Printer Settings |  | Document No. F.3D.PS.01    |
|                                                                                  |                     |  | Issue No. 01               |
|                                                                                  | PREVEST//3D         |  | Revision No. 01            |
|                                                                                  |                     |  | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest C&B Permanent**.




### Settings

Prevest C&B Permanent

Default    Machine    Resin    **Print**    Gcode    Advanced

AnyCubic Photon Ultra  
UniFormation GKtwo  
AnyCubic Photon X  
**ELEGOO Mars 4 Ultra**

|                               |           |    |                          |         |   |         |        |
|-------------------------------|-----------|----|--------------------------|---------|---|---------|--------|
| Layer Height:                 | 0.050     | mm | Bottom Lift Distance:    | 2.000   | + | 3.000   | mm     |
| Bottom Layer Count:           | 5         |    | Lifting Distance:        | 2.000   | + | 3.000   | mm     |
| Exposure Time:                | 5.000     | s  | Bottom Retract Distance: | 3.000   | + | 2.000   | mm     |
| Bottom Exposure Time:         | 50.000    | s  | Retract Distance:        | 3.000   | + | 2.000   | mm     |
| Transition Layer Count:       | 5         |    | Bottom Lift Speed:       | 75.000  | & | 230.000 | mm/min |
| Transition Type:              | Linear    |    | Lifting Speed:           | 75.000  | & | 230.000 | mm/min |
| Transition Time Decrement:    | 7.500     | s  | Bottom Retract Speed:    | 230.000 | & | 75.000  | mm/min |
| Waiting Mode During Printing: | Restin... |    | Retract Speed:           | 230.000 | & | 75.000  | mm/min |
| Rest Time Before Lift:        | 0.000     | s  |                          |         |   |         |        |
| Rest Time After Lift:         | 0.000     | s  |                          |         |   |         |        |
| Rest Time After Retract:      | 0.500     | s  |                          |         |   |         |        |

- Follow the settings of **Prevest C&B Interim**.




### Settings

Prevest C&B Interim

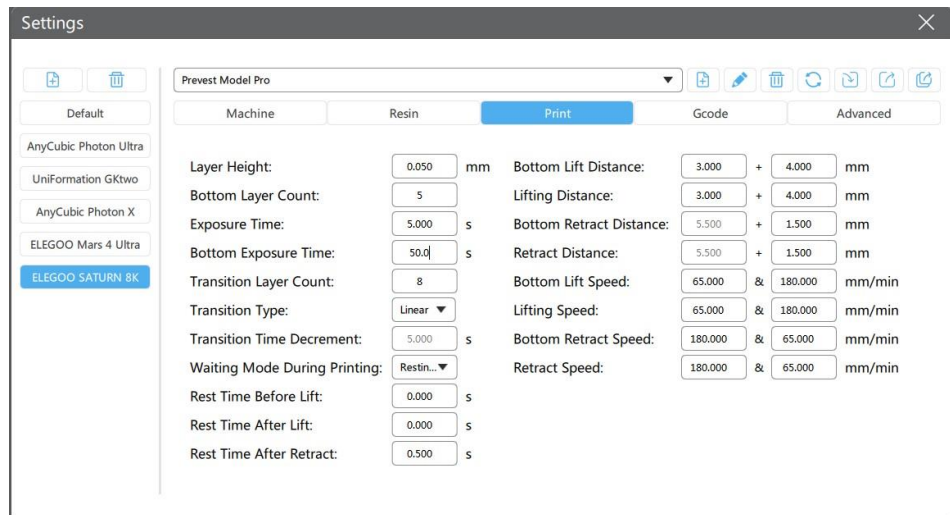
Default    Machine    Resin    **Print**    Gcode    Advanced

AnyCubic Photon Ultra  
UniFormation GKtwo  
AnyCubic Photon X  
**ELEGOO Mars 4 Ultra**

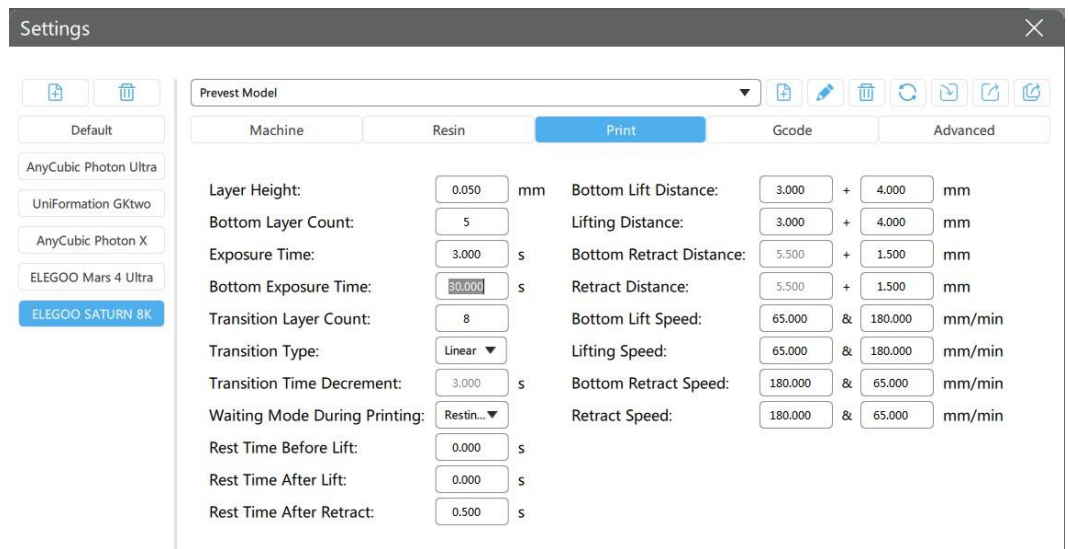
|                               |           |    |                          |         |   |         |        |
|-------------------------------|-----------|----|--------------------------|---------|---|---------|--------|
| Layer Height:                 | 0.050     | mm | Bottom Lift Distance:    | 2.000   | + | 3.000   | mm     |
| Bottom Layer Count:           | 5         |    | Lifting Distance:        | 2.000   | + | 3.000   | mm     |
| Exposure Time:                | 5.000     | s  | Bottom Retract Distance: | 3.000   | + | 2.000   | mm     |
| Bottom Exposure Time:         | 50.000    | s  | Retract Distance:        | 3.000   | + | 2.000   | mm     |
| Transition Layer Count:       | 5         |    | Bottom Lift Speed:       | 75.000  | & | 230.000 | mm/min |
| Transition Type:              | Linear    |    | Lifting Speed:           | 75.000  | & | 230.000 | mm/min |
| Transition Time Decrement:    | 7.500     | s  | Bottom Retract Speed:    | 230.000 | & | 75.000  | mm/min |
| Waiting Mode During Printing: | Restin... |    | Retract Speed:           | 230.000 | & | 75.000  | mm/min |
| Rest Time Before Lift:        | 0.000     | s  |                          |         |   |         |        |
| Rest Time After Lift:         | 0.000     | s  |                          |         |   |         |        |
| Rest Time After Retract:      | 0.500     | s  |                          |         |   |         |        |



- Slicing Software Chitu Box all versions.
- Follow the settings of **Prevest Model Pro**.



- Follow the settings of **Prevest Model**.



Effective Date. 03/04/2024

**PREVEST // 3D**





Effective Date. 03/04/2024

**PREVEST // 3D**



|                                                                                   |                              |                            |
|-----------------------------------------------------------------------------------|------------------------------|----------------------------|
|  | <h1>3D Printer Settings</h1> | Document No. F.3D.PS.01    |
|                                                                                   |                              | Issue No. 01               |
|                                                                                   | <h2>PREVEST//3D</h2>         | Revision No. 01            |
|                                                                                   |                              | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest C&B Permanent**.




Settings

+

−

Default

AnyCubic Photon Ultra

UniFormation GKtwo

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Prevest C&B Permanent

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

3.000

+

4.000

mm

Bottom Layer Count:

5

Lifting Distance:

3.000

+

4.000

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

5.500

+

1.500

mm

Bottom Exposure Time:

50.000

s

Retract Distance:

5.500

+

1.500

mm

Transition Layer Count:

8

Bottom Lift Speed:

65.000

&

180.000

mm/min

Transition Type:

Linear

Lifting Speed:

65.000

&

180.000

mm/min

Transition Time Decrement:

5.000

s

Bottom Retract Speed:

180.000

&

65.000

mm/min

Waiting Mode During Printing:

Restin...

Retract Speed:

180.000

&

65.000

mm/min

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

- Follow the settings of **Prevest C&B Interim**.




Settings

+

−

Default

AnyCubic Photon Ultra

UniFormation GKtwo

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Prevest C&B Interim

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

3.000

+

4.000

mm

Bottom Layer Count:

5

Lifting Distance:

3.000

+

4.000

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

5.500

+

1.500

mm

Bottom Exposure Time:

50.000

s

Retract Distance:

5.500

+

1.500

mm

Transition Layer Count:

8

Bottom Lift Speed:

65.000

&

180.000

mm/min

Transition Type:

Linear

Lifting Speed:

65.000

&

180.000

mm/min

Transition Time Decrement:

5.000

s

Bottom Retract Speed:

180.000

&

65.000

mm/min

Waiting Mode During Printing:

Restin...

Retract Speed:

180.000

&

65.000

mm/min

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

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 Printer Settings

30





- 

- Follow the settings of **Prevest Model**.



Settings

Default

AnyCubic Photon Ultra

UniFormation GkTwo

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Prevest Model

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

3.000

s

Bottom Exposure Time:

30.00

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

4.500

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

5.000

s

Bottom Lift Distance:

8.000

+

0.000

mm

Lifting Distance:

7.000

+

0.000

mm

Bottom Retract Distance:

8.000

+

0.000

mm

Retract Distance:

7.000

+

0.000

mm

Bottom Lift Speed:

60.000

&

0.000

mm/min

Lifting Speed:

60.000

&

0.000

mm/min

Bottom Retract Speed:

150.000

&

0.000

mm/min

Retract Speed:

150.000

&

0.000

mm/min

- Follow the settings of **Prevest Surgical Guide**.



Settings

+

+

Default

AnyCubic Photon Ultra

UniFormation GKtwo

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Prevest Surgical Guide

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.0

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

5.000

s

Bottom Lift Distance:

8.000

+

0.000

mm

Lifting Distance:

7.000

+

0.000

mm

Bottom Retract Distance:

8.000

+

0.000

mm

Retract Distance:

7.000

+

0.000

mm

Bottom Lift Speed:

60.000

&

0.000

mm/min

Lifting Speed:

60.000

&

0.000

mm/min

Bottom Retract Speed:

150.000

&

0.000

mm/min

Retract Speed:

150.000

&

0.000

mm/min

- Follow the settings of **Prevest Denture**.



Settings

+

+

Default

AnyCubic Photon Ultra

UniFormation GKtwo

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Prevest Denture

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

5.000

s

Bottom Lift Distance:

8.000

+

0.000

mm

Lifting Distance:

7.000

+

0.000

mm

Bottom Retract Distance:

8.000

+

0.000

mm

Retract Distance:

7.000

+

0.000

mm

Bottom Lift Speed:

60.000

&

0.000

mm/min

Lifting Speed:

60.000

&

0.000

mm/min

Bottom Retract Speed:

150.000

&

0.000

mm/min

Retract Speed:

150.000

&

0.000

mm/min

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 Printer Settings

32

- Follow the settings of **Prevest Burn Out**.



Settings ✕

Default

AnyCubic Photon Ultra

UniFormation Gktwo

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Prevest Burn Out

| Machine                       | Resin       | Print                    | Advanced               |
|-------------------------------|-------------|--------------------------|------------------------|
| Layer Height:                 | 0.050 mm    | Bottom Lift Distance:    | 8.000 + 0.000 mm       |
| Bottom Layer Count:           | 5           | Lifting Distance:        | 7.000 + 0.000 mm       |
| Exposure Time:                | 5.000 s     | Bottom Retract Distance: | 8.000 + 0.000 mm       |
| Bottom Exposure Time:         | 50.000 s    | Retract Distance:        | 7.000 + 0.000 mm       |
| Transition Layer Count:       | 5           | Bottom Lift Speed:       | 60.000 & 0.000 mm/min  |
| Transition Type:              | Linear ▼    | Lifting Speed:           | 60.000 & 0.000 mm/min  |
| Transition Time Decrement:    | 7.500 s     | Bottom Retract Speed:    | 150.000 & 0.000 mm/min |
| Waiting Mode During Printing: | Restin... ▼ | Retract Speed:           | 150.000 & 0.000 mm/min |
| Rest Time Before Lift:        | 0.000 s     |                          |                        |
| Rest Time After Lift:         | 0.000 s     |                          |                        |
| Rest Time After Retract:      | 5.000 s     |                          |                        |

- Follow the settings of **Prevest C&B Ceramic**.



Settings ✕

Default

AnyCubic Photon Ultra

UniFormation Gktwo

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Prevest C&B Ceramic

| Machine                       | Resin       | Print                    | Advanced               |
|-------------------------------|-------------|--------------------------|------------------------|
| Layer Height:                 | 0.050 mm    | Bottom Lift Distance:    | 8.000 + 0.000 mm       |
| Bottom Layer Count:           | 5           | Lifting Distance:        | 7.000 + 0.000 mm       |
| Exposure Time:                | 5.000 s     | Bottom Retract Distance: | 8.000 + 0.000 mm       |
| Bottom Exposure Time:         | 50.0 s      | Retract Distance:        | 7.000 + 0.000 mm       |
| Transition Layer Count:       | 5           | Bottom Lift Speed:       | 60.000 & 0.000 mm/min  |
| Transition Type:              | Linear ▼    | Lifting Speed:           | 60.000 & 0.000 mm/min  |
| Transition Time Decrement:    | 7.500 s     | Bottom Retract Speed:    | 150.000 & 0.000 mm/min |
| Waiting Mode During Printing: | Restin... ▼ | Retract Speed:           | 150.000 & 0.000 mm/min |
| Rest Time Before Lift:        | 0.000 s     |                          |                        |
| Rest Time After Lift:         | 0.000 s     |                          |                        |
| Rest Time After Retract:      | 5.000 s     |                          |                        |

- Follow the settings of **Prevest C&B Permanent**.



Settings

Prevest C&B Permanent

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

5.000

s

Bottom Lift Distance:

8.000

+

0.000

mm

Lifting Distance:

7.000

+

0.000

mm

Bottom Retract Distance:

8.000

+

0.000

mm

Retract Distance:

7.000

+

0.000

mm

Bottom Lift Speed:

60.000

&

0.000

mm/min

Lifting Speed:

60.000

&

0.000

mm/min

Bottom Retract Speed:

150.000

&

0.000

mm/min

Retract Speed:

150.000

&

0.000

mm/min

- Follow the settings of **Prevest C&B Interim**.



Settings

Prevest C&B Interim

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

7.500

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

5.000

s

Bottom Lift Distance:

8.000

+

0.000

mm

Lifting Distance:

7.000

+

0.000

mm

Bottom Retract Distance:

8.000

+

0.000

mm

Retract Distance:

7.000

+

0.000

mm

Bottom Lift Speed:

60.000

&

0.000

mm/min

Lifting Speed:

60.000

&

0.000

mm/min

Bottom Retract Speed:

150.000

&

0.000

mm/min

Retract Speed:

150.000

&

0.000

mm/min





- Slicing Software Chitu Box all versions.
- Follow the settings of **Prevest Model Pro**.



Settings

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

UniFormation GKtwo

Prevest Model Pro

| Machine                       | Resin                | Print                    | Gcode                                        | Advanced |
|-------------------------------|----------------------|--------------------------|----------------------------------------------|----------|
| Layer Height:                 | <div>0.050</div> mm  | Bottom Lift Distance:    | <div>6.000</div> + <div>0.000</div> mm       |          |
| Bottom Layer Count:           | <div>5</div>         | Lifting Distance:        | <div>5.000</div> + <div>0.000</div> mm       |          |
| Exposure Time:                | <div>5.000</div> s   | Bottom Retract Distance: | <div>6.000</div> + <div>0.000</div> mm       |          |
| Bottom Exposure Time:         | <div>50.000</div> s  | Retract Distance:        | <div>5.000</div> + <div>0.000</div> mm       |          |
| Transition Layer Count:       | <div>5</div>         | Bottom Lift Speed:       | <div>80.000</div> & <div>0.000</div> mm/min  |          |
| Transition Type:              | <div>Linear</div>    | Lifting Speed:           | <div>80.000</div> & <div>0.000</div> mm/min  |          |
| Transition Time Decrement:    | <div>7.500</div> s   | Bottom Retract Speed:    | <div>150.000</div> & <div>0.000</div> mm/min |          |
| Waiting Mode During Printing: | <div>Light ...</div> | Retract Speed:           | <div>150.000</div> & <div>0.000</div> mm/min |          |
| Light-off Delay:              | <div>9.000</div> s   |                          |                                              |          |
| Bottom Light-off Delay:       | <div>9.000</div> s   |                          |                                              |          |

- Follow the settings of **Prevest Model**.



Settings

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

UniFormation Gktwo

Prevest Model

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

3.000

s

Bottom Exposure Time:

30.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

4.500

s

Waiting Mode During Printing:

Light ...

Light-off Delay:

9.000

s

Bottom Light-off Delay:

9.000

s

Bottom Lift Distance:

6.000

+

0.000

mm

Lifting Distance:

5.000

+

0.000

mm

Bottom Retract Distance:

6.000

+

0.000

mm

Retract Distance:

5.000

+

0.000

mm

Bottom Lift Speed:

80.000

&

0.000

mm/min

Lifting Speed:

80.000

&

0.000

mm/min

Bottom Retract Speed:

150.000

&

0.000

mm/min

Retract Speed:

150.000

&

0.000

mm/min



|                                                                                                                                     |                              |                            |
|-------------------------------------------------------------------------------------------------------------------------------------|------------------------------|----------------------------|
|  <b>PREVEST DenPro®</b><br>THE FUTURE OF DENTISTRY | <h1>3D Printer Settings</h1> | Document No. F.3D.PS.01    |
|                                                                                                                                     |                              | Issue No. 01               |
|                                                                                                                                     | <h1>PREVEST//3D</h1>         | Revision No. 01            |
|                                                                                                                                     |                              | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest Surgical Guide**.



Settings

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✖

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

UniFormation GKTwo

Prevest Surgical Guide

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

6.000

+

0.000

mm

Bottom Layer Count:

4

Lifting Distance:

5.000

+

0.000

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

6.000

+

0.000

mm

Bottom Exposure Time:

50.000

s

Retract Distance:

5.000

+

0.000

mm

Transition Layer Count:

4

Bottom Lift Speed:

80.000

&

0.000

mm/min

Transition Type:

Linear

Lifting Speed:

80.000

&

0.000

mm/min

Transition Time Decrement:

9.000

s

Bottom Retract Speed:

150.000

&

0.000

mm/min

Waiting Mode During Printing:

Light ...

Retract Speed:

150.000

&

0.000

mm/min

Light-off Delay:

9.000

s

Bottom Light-off Delay:

9.000

s

- Follow the settings of **Prevest Denture**.



Settings

+

✖

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

UniFormation GKTwo

Prevest Denture

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

6.000

+

0.000

mm

Bottom Layer Count:

5

Lifting Distance:

5.000

+

0.000

mm

Exposure Time:

3.000

s

Bottom Retract Distance:

6.000

+

0.000

mm

Bottom Exposure Time:

30.000

s

Retract Distance:

5.000

+

0.000

mm

Transition Layer Count:

5

Bottom Lift Speed:

80.000

&

0.000

mm/min

Transition Type:

Linear

Lifting Speed:

80.000

&

0.000

mm/min

Transition Time Decrement:

4.500

s

Bottom Retract Speed:

150.000

&

0.000

mm/min

Waiting Mode During Printing:

Light ...

Retract Speed:

150.000

&

0.000

mm/min

Light-off Delay:

9.000

s

Bottom Light-off Delay:

9.000

s

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 Printer Settings

36

- Follow the settings of **Prevest Burn Out**.



Settings

Prevest Burn Out

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

6.000

+

0.000

mm

Bottom Layer Count:

5

Lifting Distance:

5.000

+

0.000

mm

Exposure Time:

3.000

s

Bottom Retract Distance:

6.000

+

0.000

mm

Bottom Exposure Time:

30.000

s

Retract Distance:

5.000

+

0.000

mm

Transition Layer Count:

5

Bottom Lift Speed:

80.000

&

0.000

mm/min

Transition Type:

Linear

Lifting Speed:

80.000

&

0.000

mm/min

Transition Time Decrement:

4.500

s

Bottom Retract Speed:

150.000

&

0.000

mm/min

Waiting Mode During Printing:

Light ...

Retract Speed:

150.000

&

0.000

mm/min

Light-off Delay:

9.000

s

Bottom Light-off Delay:

9.000

s

- Follow the settings of **Prevest C&B Ceramic**.



Settings

Prevest C&B Ceramic

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

6.000

+

0.000

mm

Bottom Layer Count:

5

Lifting Distance:

5.000

+

0.000

mm

Exposure Time:

3.000

s

Bottom Retract Distance:

6.000

+

0.000

mm

Bottom Exposure Time:

30.000

s

Retract Distance:

5.000

+

0.000

mm

Transition Layer Count:

5

Bottom Lift Speed:

80.000

&

0.000

mm/min

Transition Type:

Linear

Lifting Speed:

80.000

&

0.000

mm/min

Transition Time Decrement:

4.500

s

Bottom Retract Speed:

150.000

&

0.000

mm/min

Waiting Mode During Printing:

Light ...

Retract Speed:

150.000

&

0.000

mm/min

Light-off Delay:

9.000

s

Bottom Light-off Delay:

9.000

s

|                                                                                                                                    |                              |  |                            |
|------------------------------------------------------------------------------------------------------------------------------------|------------------------------|--|----------------------------|
|  <b>PREVESTDenPro®</b><br>THE FUTURE OF DENTISTRY | <h1>3D Printer Settings</h1> |  | Document No. F.3D.PS.01    |
|                                                                                                                                    |                              |  | Issue No. 01               |
|                                                                                                                                    | <h2>PREVEST//3D</h2>         |  | Revision No. 01            |
|                                                                                                                                    |                              |  | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest C&B Permanent**.




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Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

UniFormation GKtwo

Settings

Prevest C&B Permanent

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

3.000

s

Bottom Exposure Time:

30.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

4.500

s

Waiting Mode During Printing:

Light ...

Light-off Delay:

9.000

s

Bottom Light-off Delay:

9.000

s

Bottom Lift Distance:

6.000

+

0.000

mm

Lifting Distance:

5.000

+

0.000

mm

Bottom Retract Distance:

6.000

+

0.000

mm

Retract Distance:

5.000

+

0.000

mm

Bottom Lift Speed:

80.000

&

0.000

mm/min

Lifting Speed:

80.000

&

0.000

mm/min

Bottom Retract Speed:

150.000

&

0.000

mm/min

Retract Speed:

150.000

&

0.000

mm/min

- Follow the settings of **Prevest C&B Interim**.




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Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

UniFormation GKtwo

Settings

Prevest C&B Interim

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

3.000

s

Bottom Exposure Time:

30.000

s

Transition Layer Count:

5

Transition Type:

Linear

Transition Time Decrement:

4.500

s

Waiting Mode During Printing:

Light ...

Light-off Delay:

9.000

s

Bottom Light-off Delay:

9.000

s

Bottom Lift Distance:

6.000

+

0.000

mm

Lifting Distance:

5.000

+

0.000

mm

Bottom Retract Distance:

6.000

+

0.000

mm

Retract Distance:

5.000

+

0.000

mm

Bottom Lift Speed:

80.000

&

0.000

mm/min

Lifting Speed:

80.000

&

0.000

mm/min

Bottom Retract Speed:

150.000

&

0.000

mm/min

Retract Speed:

150.000

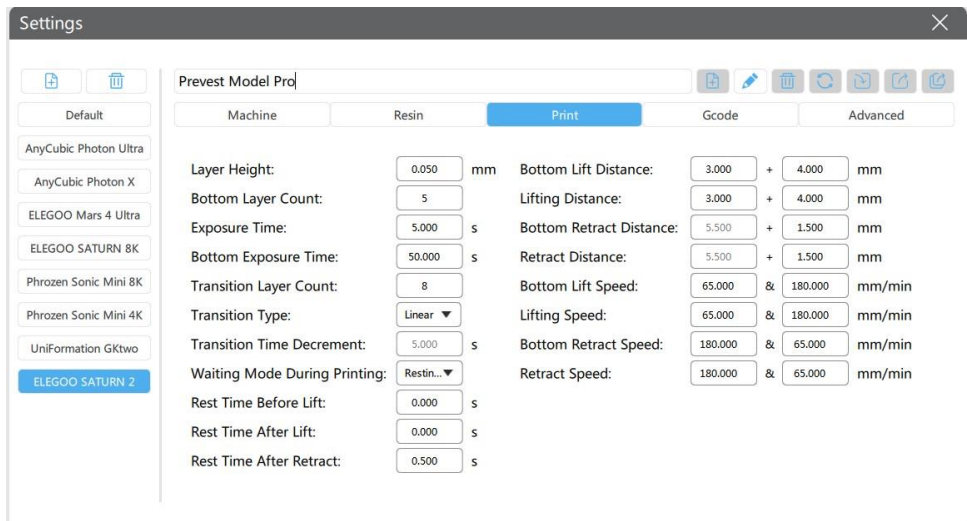
&

0.000

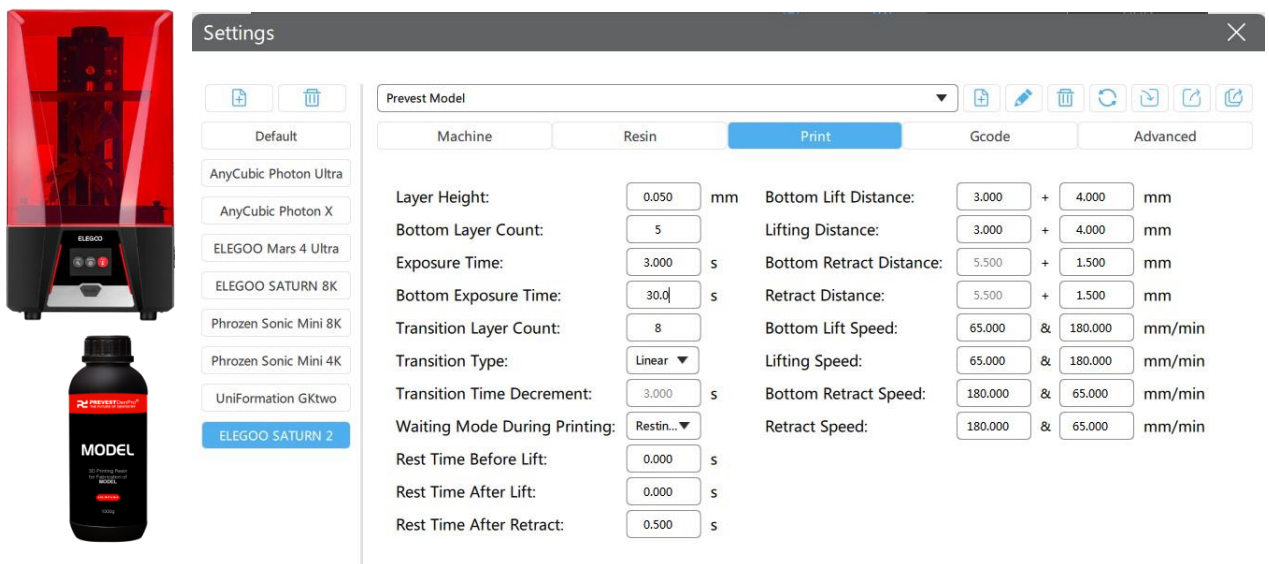
mm/min



- Slicing Software Chitu Box all versions.
- Follow the settings of **Prevest Model Pro**.



- Follow the settings of **Prevest Model**.



- Follow the settings of **Prevest Surgical Guide**.



Settings

+

-

Prevest Surgical Guide

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.0

s

Transition Layer Count:

8

Transition Type:

Linear

Transition Time Decrement:

5.000

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

Bottom Lift Distance:

3.000

+

4.000

mm

Lifting Distance:

3.000

+

4.000

mm

Bottom Retract Distance:

5.500

+

1.500

mm

Retract Distance:

5.500

+

1.500

mm

Bottom Lift Speed:

65.000

&

180.000

mm/min

Lifting Speed:

65.000

&

180.000

mm/min

Bottom Retract Speed:

180.000

&

65.000

mm/min

Retract Speed:

180.000

&

65.000

mm/min

- Follow the settings of **Prevest Denture**.



Settings

+

-

Prevest Denture

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

8

Transition Type:

Linear

Transition Time Decrement:

5.000

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

Bottom Lift Distance:

3.000

+

4.000

mm

Lifting Distance:

3.000

+

4.000

mm

Bottom Retract Distance:

5.500

+

1.500

mm

Retract Distance:

5.500

+

1.500

mm

Bottom Lift Speed:

65.000

&

180.000

mm/min

Lifting Speed:

65.000

&

180.000

mm/min

Bottom Retract Speed:

180.000

&

65.000

mm/min

Retract Speed:

180.000

&

65.000

mm/min



Settings

✕

+

🗑️

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

UniFormation Gktwo

Prevest Burn Out

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🗑️

🔄

↶

↷

📄

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

8

Transition Type:

Linear ▼

Transition Time Decrement:

5.000

s

Waiting Mode During Printing:

Restin... ▼

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

Bottom Lift Distance:

3.000

+

4.000

mm

Lifting Distance:

3.000

+

4.000

mm

Bottom Retract Distance:

5.500

+

1.500

mm

Retract Distance:

5.500

+

1.500

mm

Bottom Lift Speed:

65.000

&

180.000

mm/min

Lifting Speed:

65.000

&

180.000

mm/min

Bottom Retract Speed:

180.000

&

65.000

mm/min

Retract Speed:

180.000

&

65.000

mm/min

Settings

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

UniFormation GKtwo

ELEGOO SATURN 2

Prevest C&B Ceramic

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

3.000

+

4.000

mm

Bottom Layer Count:

5

Lifting Distance:

3.000

+

4.000

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

5.500

+

1.500

mm

Bottom Exposure Time:

50.000

s

Retract Distance:

5.500

+

1.500

mm

Transition Layer Count:

8

Bottom Lift Speed:

65.000

&

180.000

mm/min

Transition Type:

Linear ▼

Lifting Speed:

65.000

&

180.000

mm/min

Transition Time Decrement:

5.000

s

Bottom Retract Speed:

180.000

&

65.000

mm/min

Waiting Mode During Printing:

Restin... ▼

Retract Speed:

180.000

&

65.000

mm/min

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

- Follow the settings of **Prevest C&B Permanent**.



Settings

+

✖

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

UniFormation Gktwo

ELEGOO SATURN 2

Prevest C&B Permanent

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

8

Transition Type:

Linear

Transition Time Decrement:

5.000

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

Bottom Lift Distance:

3.000

+

4.000

mm

Lifting Distance:

3.000

+

4.000

mm

Bottom Retract Distance:

5.500

+

1.500

mm

Retract Distance:

5.500

+

1.500

mm

Bottom Lift Speed:

65.000

&

180.000

mm/min

Lifting Speed:

65.000

&

180.000

mm/min

Bottom Retract Speed:

180.000

&

65.000

mm/min

Retract Speed:

180.000

&

65.000

mm/min

- Follow the settings of **Prevest C&B Interim**.



Settings

+

✖

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

UniFormation Gktwo

ELEGOO SATURN 2

Prevest C&B Interim

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

5

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

8

Transition Type:

Linear

Transition Time Decrement:

5.000

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

0.500

s

Bottom Lift Distance:

3.000

+

4.000

mm

Lifting Distance:

3.000

+

4.000

mm

Bottom Retract Distance:

5.500

+

1.500

mm

Retract Distance:

5.500

+

1.500

mm

Bottom Lift Speed:

65.000

&

180.000

mm/min

Lifting Speed:

65.000

&

180.000

mm/min

Bottom Retract Speed:

180.000

&

65.000

mm/min

Retract Speed:

180.000

&

65.000

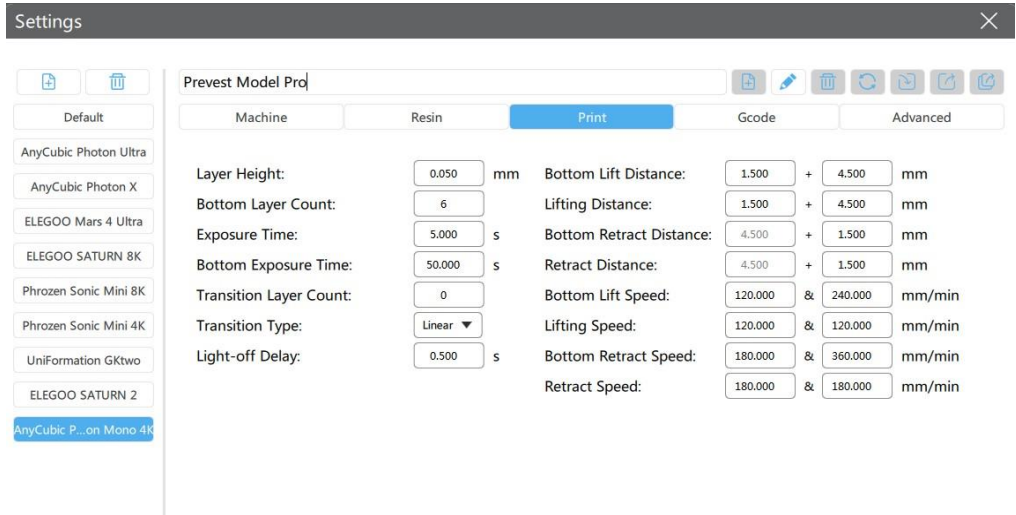
mm/min

[www.prevest3d.com](http://www.prevest3d.com)  
 Printer Settings

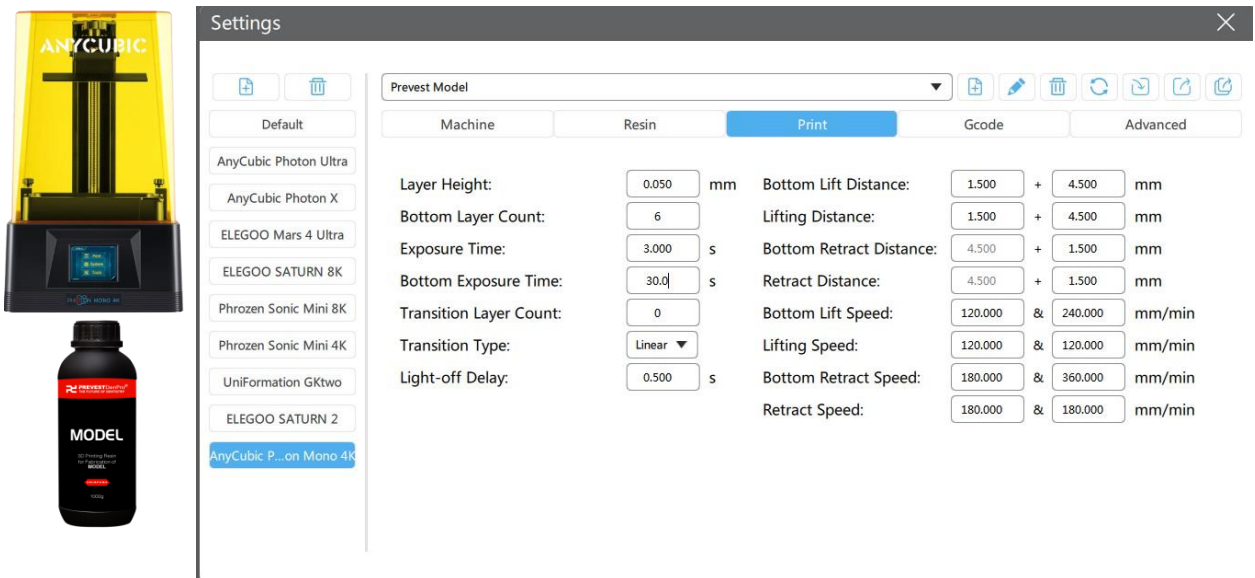
42



- Slicing Software Chitu Box all versions.
- Follow the settings of **Prevest Model Pro**.



- Follow the settings of **Prevest Model**.



|                                                                                  |                              |                            |
|----------------------------------------------------------------------------------|------------------------------|----------------------------|
|  | <h1>3D Printer Settings</h1> | Document No. F.3D.PS.01    |
|                                                                                  |                              | Issue No. 01               |
|                                                                                  | <h2>PREVEST//3D</h2>         | Revision No. 01            |
|                                                                                  |                              | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest Surgical Guide**.



Settings

+

−

Prevest Surgical Guide

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

1.500

+

4.500

mm

Bottom Layer Count:

6

Lifting Distance:

1.500

+

4.500

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

4.500

+

1.500

mm

Bottom Exposure Time:

50.0

s

Retract Distance:

4.500

+

1.500

mm

Transition Layer Count:

0

Bottom Lift Speed:

120.000

&

240.000

mm/min

Transition Type:

Linear

Lifting Speed:

120.000

&

120.000

mm/min

Light-off Delay:

0.500

s

Bottom Retract Speed:

180.000

&

360.000

mm/min

Retract Speed:

180.000

&

180.000

mm/min

- Follow the settings of **Prevest Denture**.



Settings

+

−

Prevest Denture

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

1.500

+

4.500

mm

Bottom Layer Count:

6

Lifting Distance:

1.500

+

4.500

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

4.500

+

1.500

mm

Bottom Exposure Time:

50.000

s

Retract Distance:

4.500

+

1.500

mm

Transition Layer Count:

0

Bottom Lift Speed:

120.000

&

240.000

mm/min

Transition Type:

Linear

Lifting Speed:

120.000

&

120.000

mm/min

Light-off Delay:

0.500

s

Bottom Retract Speed:

180.000

&

360.000

mm/min

Retract Speed:

180.000

&

180.000

mm/min



• Follow the settings of **Prevest Burn Out**.




Settings

Prevest Burn Out

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

0

Transition Type:

Linear

Light-off Delay:

0.500

s

Bottom Lift Distance:

1.500

+

4.500

mm

Lifting Distance:

1.500

+

4.500

mm

Bottom Retract Distance:

4.500

+

1.500

mm

Retract Distance:

4.500

+

1.500

mm

Bottom Lift Speed:

120.000

&

240.000

mm/min

Lifting Speed:

120.000

&

120.000

mm/min

Bottom Retract Speed:

180.000

&

360.000

mm/min

Retract Speed:

180.000

&

180.000

mm/min

• Follow the settings of **Prevest C&B Ceramic**.




Settings

Prevest C&B Ceramic

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

0

Transition Type:

Linear

Light-off Delay:

0.500

s

Bottom Lift Distance:

1.500

+

4.500

mm

Lifting Distance:

1.500

+

4.500

mm

Bottom Retract Distance:

4.500

+

1.500

mm

Retract Distance:

4.500

+

1.500

mm

Bottom Lift Speed:

120.000

&

240.000

mm/min

Lifting Speed:

120.000

&

120.000

mm/min

Bottom Retract Speed:

180.000

&

360.000

mm/min

Retract Speed:

180.000

&

180.000

mm/min



- Follow the settings of **Prevest C&B Permanent**.



Settings

Prevest C&B Permanent

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

1.500

+

4.500

mm

Bottom Layer Count:

6

Lifting Distance:

1.500

+

4.500

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

4.500

+

1.500

mm

Bottom Exposure Time:

50.000

s

Retract Distance:

4.500

+

1.500

mm

Transition Layer Count:

0

Bottom Lift Speed:

120.000

&

240.000

mm/min

Transition Type:

Linear

Lifting Speed:

120.000

&

120.000

mm/min

Light-off Delay:

0.500

s

Bottom Retract Speed:

180.000

&

360.000

mm/min

Retract Speed:

180.000

&

180.000

mm/min

- Follow the settings of **Prevest C&B Interim**.



Settings

Prevest C&B Interim

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

1.500

+

4.500

mm

Bottom Layer Count:

6

Lifting Distance:

1.500

+

4.500

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

4.500

+

1.500

mm

Bottom Exposure Time:

50.000

s

Retract Distance:

4.500

+

1.500

mm

Transition Layer Count:

0

Bottom Lift Speed:

120.000

&

240.000

mm/min

Transition Type:

Linear

Lifting Speed:

120.000

&

120.000

mm/min

Light-off Delay:

0.500

s

Bottom Retract Speed:

180.000

&

360.000

mm/min

Retract Speed:

180.000

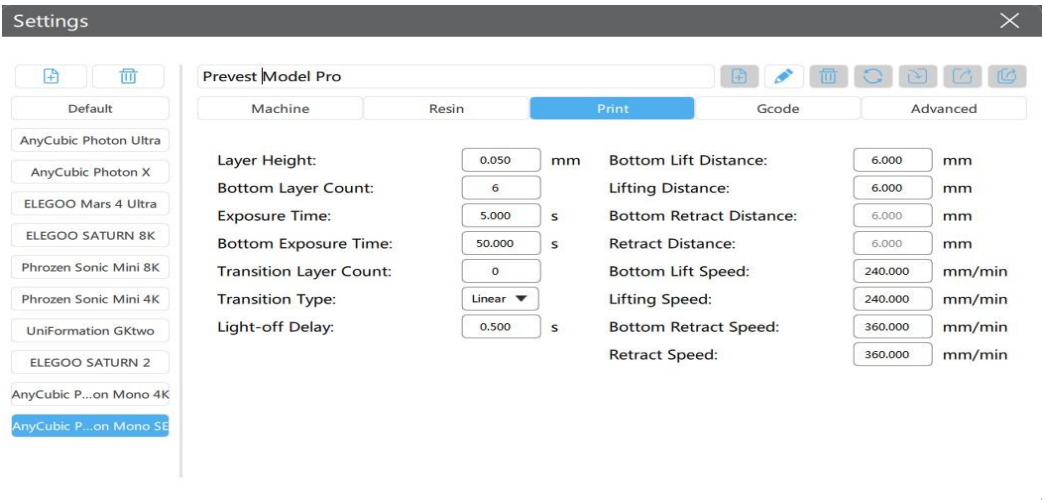
&

180.000

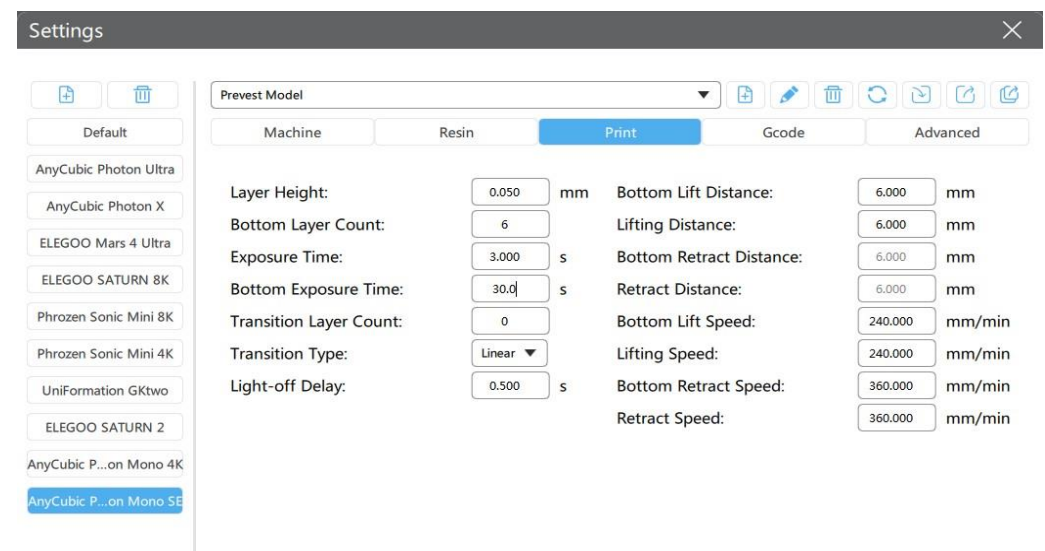
mm/min



- Slicing Software Chitu Box all versions.
- Follow the settings of **Prevest Model Pro**.



- Follow the settings of **Prevest Model**.



|                                                                                   |                              |                            |
|-----------------------------------------------------------------------------------|------------------------------|----------------------------|
|  | <h1>3D Printer Settings</h1> | Document No. F.3D.PS.01    |
|                                                                                   |                              | Issue No. 01               |
|                                                                                   | <h2>PREVEST//3D</h2>         | Revision No. 01            |
|                                                                                   |                              | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest Surgical Guide**.




Settings

+

+

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

UniFormation GKtwo

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

Prevest Surgical Guide

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.0

s

Transition Layer Count:

0

Transition Type:

Linear

Light-off Delay:

0.500

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

240.000

mm/min

Lifting Speed:

240.000

mm/min

Bottom Retract Speed:

360.000

mm/min

Retract Speed:

360.000

mm/min

- Follow the settings of **Prevest Denture**.




Settings

+

+

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

UniFormation GKtwo

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

Prevest Denture

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

0

Transition Type:

Linear

Light-off Delay:

0.500

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

240.000

mm/min

Lifting Speed:

240.000

mm/min

Bottom Retract Speed:

360.000

mm/min

Retract Speed:

360.000

mm/min

[www.prevest3d.com](http://www.prevest3d.com)  
 Printer Settings

48

|                                                                                   |                              |                            |
|-----------------------------------------------------------------------------------|------------------------------|----------------------------|
|  | <h1>3D Printer Settings</h1> | Document No. F.3D.PS.01    |
|                                                                                   |                              | Issue No. 01               |
|                                                                                   | <h2>PREVEST//3D</h2>         | Revision No. 01            |
|                                                                                   |                              | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest Burn Out**.



Settings

Prevest Burn Out

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

0

Transition Type:

Linear

Light-off Delay:

0.500

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

240.000

mm/min

Lifting Speed:

240.000

mm/min

Bottom Retract Speed:

360.000

mm/min

Retract Speed:

360.000

mm/min

- Follow the settings of **Prevest C&B Ceramic**.



Settings

Prevest C&B Ceramic

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

0

Transition Type:

Linear

Light-off Delay:

0.500

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

240.000

mm/min

Lifting Speed:

240.000

mm/min

Bottom Retract Speed:

360.000

mm/min

Retract Speed:

360.000

mm/min



- Follow the settings of **Prevest C&B Permanent**.



Settings

+

−

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

UniFormation GKtwo

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

Prevest C&B Permanent

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

0

Transition Type:

Linear

Light-off Delay:

0.500

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

240.000

mm/min

Lifting Speed:

240.000

mm/min

Bottom Retract Speed:

360.000

mm/min

Retract Speed:

360.000

mm/min

- Follow the settings of **Prevest C&B Interim**.



Settings

+

−

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

UniFormation GKtwo

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

Prevest C&B Interim

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Transition Layer Count:

0

Transition Type:

Linear

Light-off Delay:

0.500

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

240.000

mm/min

Lifting Speed:

240.000

mm/min

Bottom Retract Speed:

360.000

mm/min

Retract Speed:

360.000

mm/min





### Any cubic Photon S (0.05 – 0.1 μ)



- Slicing Software Chitu Box all versions.
- Follow the settings of **Prevest Model Pro.**



Settings

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

UniFormation Gktwo

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

Prevest Model Pro

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

180.000

mm/min

Lifting Speed:

180.000

mm/min

Bottom Retract Speed:

180.000

mm/min

Retract Speed:

180.000

mm/min

- Follow the settings of **Prevest Model.**



Settings

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

UniFormation Gktwo

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

Prevest Model

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

3.000

s

Bottom Exposure Time:

30.0

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

180.000

mm/min

Lifting Speed:

180.000

mm/min

Bottom Retract Speed:

180.000

mm/min

Retract Speed:

180.000

mm/min

|                                                                                   |                              |                            |
|-----------------------------------------------------------------------------------|------------------------------|----------------------------|
|  | <h1>3D Printer Settings</h1> | Document No. F.3D.PS.01    |
|                                                                                   |                              | Issue No. 01               |
|                                                                                   | <h2>PREVEST//3D</h2>         | Revision No. 01            |
|                                                                                   |                              | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest Surgical Guide**.



Settings

Prevest Surgical Guide

MachineResinPrintAdvanced

Layer Height:

0.050

mm

Bottom Lift Distance:

6.000

mm

Bottom Layer Count:

6

Lifting Distance:

6.000

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

6.000

mm

Bottom Exposure Time:

50.0

s

Retract Distance:

6.000

mm

Light-off Delay:

1.000

s

Bottom Lift Speed:

180.000

mm/min

Lifting Speed:

180.000

mm/min

Bottom Retract Speed:

180.000

mm/min

Retract Speed:

180.000

mm/min

- Follow the settings of **Prevest Denture**.



Settings

Prevest Denture

MachineResinPrintAdvanced

Layer Height:

0.050

mm

Bottom Lift Distance:

6.000

mm

Bottom Layer Count:

6

Lifting Distance:

6.000

mm

Exposure Time:

5.000

s

Bottom Retract Distance:

6.000

mm

Bottom Exposure Time:

50.000

s

Retract Distance:

6.000

mm

Light-off Delay:

1.000

s

Bottom Lift Speed:

180.000

mm/min

Lifting Speed:

180.000

mm/min

Bottom Retract Speed:

180.000

mm/min

Retract Speed:

180.000

mm/min

|                                                                                                                                    |                            |  |                            |
|------------------------------------------------------------------------------------------------------------------------------------|----------------------------|--|----------------------------|
|  <b>PREVESTDenPro®</b><br>THE FUTURE OF DENTISTRY | <b>3D Printer Settings</b> |  | Document No. F.3D.PS.01    |
|                                                                                                                                    |                            |  | Issue No. 01               |
|                                                                                                                                    | <b>PREVEST//3D</b>         |  | Revision No. 01            |
|                                                                                                                                    |                            |  | Effective Date. 03/04/2024 |

- Follow the settings of **Prevest Burn Out**.



### Settings

+

✖

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

UniFormation GKtwo

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

Prevest Burn Out

MachineResinPrintAdvanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

180.000

mm/min

Lifting Speed:

180.000

mm/min

Bottom Retract Speed:

180.000

mm/min

Retract Speed:

180.000

mm/min

- Follow the settings of **Prevest C&B Ceramic**.



### Settings

+

✖

Default

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

UniFormation GKtwo

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

Prevest C&B Ceramic

MachineResinPrintAdvanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

180.000

mm/min

Lifting Speed:

180.000

mm/min

Bottom Retract Speed:

180.000

mm/min

Retract Speed:

180.000

mm/min

- Follow the settings of **Prevest C&B Permanent**.



Settings

Prevest C&B Permanent

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

180.000

mm/min

Lifting Speed:

180.000

mm/min

Bottom Retract Speed:

180.000

mm/min

Retract Speed:

180.000

mm/min

- Follow the settings of **Prevest C&B Interim**.



Settings

Prevest C&B Interim

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.000

s

Light-off Delay:

1.000

s

Bottom Lift Distance:

6.000

mm

Lifting Distance:

6.000

mm

Bottom Retract Distance:

6.000

mm

Retract Distance:

6.000

mm

Bottom Lift Speed:

180.000

mm/min

Lifting Speed:

180.000

mm/min

Bottom Retract Speed:

180.000

mm/min

Retract Speed:

180.000

mm/min



### Any cubic Photon Mono M5s (0.05 – 0.1 μ)



- Slicing Software Chitu Box all versions.
- Follow the settings of **Prevest C&B Ceramic**.

Settings

+

🗑

AnyCubic Photon Ultra

AnyCubic Photon X

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

UniFormation GKtwo

AnyCubic ... Mono M5s

Prevest C&B Ceramic

+

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📄

📄

Machine

Resin

Print

Gcode

Advanced

Layer Height:

0.050

mm

Bottom Lift Distance:

10.000

+

0.000

mm

Bottom Layer Count:

5

Lifting Distance:

5.000

+

0.000

mm

Exposure Time:

10.000

s

Bottom Retract Distance:

10.000

+

0.000

mm

Bottom Exposure Time:

100.000

s

Retract Distance:

5.000

+

0.000

mm

Transition Layer Count:

0

Bottom Lift Speed:

360.000

&

0.000

mm/min

Transition Type:

Linear

▼

Lifting Speed:

360.000

&

0.000

mm/min

Waiting Mode During Printing:

Light ...

▼

Bottom Retract Speed:

360.000

&

0.000

mm/min

Light-off Delay:

0.500

s

Retract Speed:

360.000

&

0.000

mm/min

Bottom Light-off Delay:

5.000

s





### Phrozen Sonic Mini 8K s (0.05 – 0.1 μ)



- Slicing Software Chitu Box all versions.
- Follow the settings of **Prevest C&B Ceramic**.

Settings

ELEGOO Mars 4 Ultra

ELEGOO SATURN 8K

Phrozen Sonic Mini 8K

Phrozen Sonic Mini 4K

ELEGOO SATURN 2

AnyCubic P...on Mono 4K

AnyCubic P...on Mono SE

AnyCubic Photon S

AnyCubic ... Mono M5s

AnyCubic P... Mono X 6K

UniFormation Gktwo

Phrozen Sonic Mini 8K S

Prevest C&B Ceramic

Machine

Resin

Print

Advanced

Layer Height:

0.050

mm

Bottom Layer Count:

6

Exposure Time:

5.000

s

Bottom Exposure Time:

50.0

s

Transition Layer Count:

6

Transition Type:

Linear

Transition Time Decrement:

6.430

s

Waiting Mode During Printing:

Restin...

Rest Time Before Lift:

0.000

s

Rest Time After Lift:

0.000

s

Rest Time After Retract:

4.000

s

Bottom Lift Distance:

3.000

+

4.000

mm

Lifting Distance:

3.000

+

4.000

mm

Bottom Retract Distance:

5.000

+

2.000

mm

Retract Distance:

5.000

+

2.000

mm

Bottom Lift Speed:

40.000

&

120.000

mm/min

Lifting Speed:

40.000

&

120.000

mm/min

Bottom Retract Speed:

180.000

&

90.000

mm/min

Retract Speed:

180.000

&

90.000

mm/min

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Printer Settings

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|                                                                                   |                              |                            |
|-----------------------------------------------------------------------------------|------------------------------|----------------------------|
|  | <h1>3D Printer Settings</h1> | Document No. F.3D.PS.01    |
|                                                                                   |                              | Issue No. 01               |
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Elegoo Mars 5 Ultra (0.05 – 0.1 μ)



- Slicing Software Chitu Box basic versions.
- Follow the settings of **Prevest C&B Ceramic**.

Resin

Resin Type

C&B

Resin Name

Prevest C&B Ceramic

Resin Color

Resin Density

1.100

g/ml

Resin Cost

29.990

\$

/

Kg

Print

Layer Height

0.050

mm

Bottom Layer Count

5

Exposure Time

5.000

s

Bottom Exposure Time

50.000

s

Transition Layer Count

5

Transition Type

Linear

Transition Layer Interval Time Difference

7.50

s

Waiting Mode During Printing

Resting time

Rest Time Before Release

0.000

s

Rest Time After Release

0.000

s

Rest Time After Retract

0.500

s

Advance

Bottom Light PWM

255

/

Light PWM

255

/

Picture Grayscale

255

Anti-aliasing

None

Shrinkage Compensation

Tolerance Compensation

a

-0.200

mm

b

-0.100

mm

Bottom Tolerance Compensation

Print Time Compensation

[www.prevest3d.com](http://www.prevest3d.com)  
 Printer Settings

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|                                                                                   |                              |                            |
|-----------------------------------------------------------------------------------|------------------------------|----------------------------|
|  | <h1>3D Printer Settings</h1> | Document No. F.3D.PS.01    |
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|                                                                                   |                              | Effective Date. 03/04/2024 |



### Elegoo Mars 5 Ultra (0.05 – 0.1 μ)



- Slicing Software Chitu Box basic versions.
- Follow the Prevest C&B Permanent settings.

Resin

Resin Type

C&B

Resin Name

Prevest C&B Permanent

Resin Color

Resin Density

1.100

g/ml

Resin Cost

29.990

\$

/

Kg

Print

Layer Height

0.050

mm

Bottom Layer Count

5

Exposure Time

5.000

s

Bottom Exposure Time

50.000

s

Transition Layer Count

5

Transition Type

Linear

Transition Layer Interval Time Difference

7.50

s

Waiting Mode During Printing

Resting time

Rest Time Before Release

0.000

s

Rest Time After Release

0.000

s

Rest Time After Retract

0.500

s

Advance

Bottom Light PWM

255

/

Light PWM

255

/

Picture Grayscale

255

Anti-aliasing

None

☐ Shrinkage Compensation

☐ Tolerance Compensation

☒ Bottom Tolerance Compensation



a

-0.200

mm

b

-0.100

mm

☐ Print Time Compensation

[www.prevest3d.com](http://www.prevest3d.com)  
 Printer Settings

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|                                                                                   |                              |  |                            |
|-----------------------------------------------------------------------------------|------------------------------|--|----------------------------|
|  | <h1>3D Printer Settings</h1> |  | Document No. F.3D.PS.01    |
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### Elegoo Mars 5 Ultra (0.05 – 0.1 μ)



- Slicing Software Chitu Box basic versions.
- Follow the **Prevest Denture** settings.

Resin

Resin Type

Denture

Resin Name

Prevest Denture



Resin Color



Resin Density

1.100

g/ml

Resin Cost

29.990

\$

/

Kg

Print

Layer Height

0.050

mm

Bottom Layer Count

5

Exposure Time

5.000

s

Bottom Exposure Time

50.000

s

Transition Layer Count

5

Transition Type

Linear

Transition Layer Interval Time Difference

7.50

s

Waiting Mode During Printing

Resting time

Rest Time Before Release

0.000

s

Rest Time After Release

0.000

s

Rest Time After Retract

0.500

s

Advance

Bottom Light PWM

255

/

Light PWM

255

/

Picture Grayscale

255

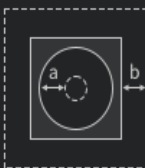
Anti-aliasing

None

☐ Shrinkage Compensation

☐ Tolerance Compensation

☒ Bottom Tolerance Compensation



a

-0.200

mm

b

-0.100

mm

☐ Print Time Compensation