



Document No. F.3D.PS.01Issue No.01Revision No.01Effective Date.03/04/2024



3D PRINTER SETTINGS

Asiga Max UV 385 Phrozen Sonic Mini 8K Anycubic Photon Mono X 6K Phrozen Sonic Mini 8KS **Uniformation GK 2** Phrozen Sonic Mini 4K **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**



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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



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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



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Support Settings In Chitubox

For Basic Chitubox Basic V2 version

Тор			Middle		
Touch Shape	None		Shape	Cylinder	
Contact Denth(mm)	1.20		Diameter(mm)	1.20	
Connection Shano	Cono	·	Angle(°)	70.00	
	Cone		Small Pillar Shape	Cone	
Tip Upper Diameter(mm)	1.20		Diamator(mm)	0.50	
Tip Down Diameter(mm)	1.20		Diameter(mm)	0.50	
Connection Length(mm)	2.00	\$	Upper Depth(mm)	0.30	÷
			Lower Depth(mm)	0.30	
			Maximum Spacing Of Cross Structure(30.00	
			Cross Start Height	3.00	
Bottom			Raft		
Platform Touch Shape	Skate		Raft Shape	None	
· · · · · · · · ·	10.00				
Iouch Diameter(mm)	12.00		Raft Area Ratio(%)		
Thickness(mm)	1.00		Raft Thickness (mm)		
Model Contact Shape	None		Raft Height(mm)		
Contact Diameter(mm)	0.60		Raft Slope(°)		
Contact Depth(mm)	0.20		Grid Side Length (mm)		
Contact Point	1		Grid Width (mm)		



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Uniformation GK TWO $(0.025 - 0.1 \mu)$



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

	Settings								×
		Prevest Model Pro			•) 🕒 🥖	•		00
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra			<u>,</u>					<u>`</u>
and the second se	UniFormation GKtwo	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	8	320.000	mm/min
		Transition Type:	Linear 🔻		Lifting Speed:	90.000	8	320.000	mm/min
C PREVENT Double		Transition Time Decrement:	7.500	s	Bottom Retract Speed:	320.000	8	90.000	mm/min
		Waiting Mode During Printing:	Restin v)	Retract Speed:	320.000	8	90.000	mm/min
		Rest Time Before Lift:	0.000	s					
30 Protog Roan No Patriciatori al Thermonitation Medrin		Rest Time After Lift:	0.000	s					
1000g		Rest Time After Retract:	1.000	s					

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

	Settings								×
		Prevest Model	•				900		
GKTWO	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra			<u>,</u>					<u>_</u>
	UniFormation GKtwo	Layer Height:	0.05þ	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	8	320.000	mm/min
		Transition Type:	Linear 🔻		Lifting Speed:	90.000	8	320.000	mm/min
		Transition Time Decrement:	3.110	s	Bottom Retract Speed:	320.000	8	90.000	mm/min
REPERTED Configure		Waiting Mode During Printing:	Restin v)	Retract Speed:	320.000	8	90.000	mm/min
MODEL		Rest Time Before Lift:	0.000	s					
3D Preting Rean for Fait instead of MODIL		Rest Time After Lift:	0.000	s					
1000g		Rest Time After Retract:	1.000	s					



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

	Settings								X
		Prevest Surgical Guide	•) 🗄 📝	•][1		9 9 9		
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra	laver Height:	0.050	mm	Bottom Lift Distance:	3 000] .	4.000	mm
	UniFormation GKtwo	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:	5)	Bottom Lift Speed:	90.000	&	320.000	mm/min
		Transition Type:	Linear v		Lifting Speed:	90.000	&	320.000	mm/min
SURGICAL GUIDE		Transition Time Decrement:	7.500	s	Bottom Retract Speed:	320.000	&	90.000	mm/min
30 Printing Reason for Alaboration of Sangled Curde		Waiting Mode During Printing:	Restin v)	Retract Speed:	320.000	&	90.000	mm/min
1000p		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 Denture**.

UNIFORMATION GKTWO		Prevest Denture			•				NG
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra			<u>`</u>			_		
	UniFormation GKtwo	Layer Height:	0.þ50	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
2 PREVENTION Prof		Transition Layer Count:	8)	Bottom Lift Speed:	90.000	8	320.000	mm/min
DENTURE		Transition Type:	Linear 🔻)	Lifting Speed:	90.000	8	320.000	mm/min
30 Printing Rear Nr DSNTUME BASE		Transition Time Decrement:	5.000) s	Bottom Retract Speed:	320.000	8	90.000	mm/min
90009		Waiting Mode During Printing:	Restin 🔻)	Retract Speed:	320.000	8	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					



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

	Settings								×
UNFORMATION GKTWO	Default	Prevest Burn Out Machine	Resin		▼ Print	Gcode			Advanced
	AnyCubic Photon Ultra UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000) +	4.000	mm
		Bottom Layer Count: Exposure Time:	5.000]] s	Lifting Distance: Bottom Retract Distance:	3.000 5.500) +) +	4.000	mm mm
		Bottom Exposure Time: Transition Layer Count:	50.000 5] s]	Retract Distance: Bottom Lift Speed:	5.500 90.000) +) &	1.500 320.000	mm mm/min
Management		Transition Type: Transition Time Decrement:	Linear ▼ 7.500)] s	Lifting Speed: Bottom Retract Speed:	90.000 320.000) &) &	320.000 90.000	mm/min mm/min
BURN OUT		Waiting Mode During Printing: Rest Time Before Lift:	Restin▼ 0.000)] s	Retract Speed:	320.000) &	90.000	mm/min
		Rest Time After Lift: Rest Time After Retract:	0.000)s)s					

• Follow the settings of Prevest C&B Ceramic.

								Х
st C&B Ceramic Machine F	Resin		▼ Print	Gcode			Advanced	Ľ
ver Height: ttom Layer Count: posure Time:	0.050 5 5.000) mm) s	Bottom Lift Distance: Lifting Distance: Bottom Retract Distance:	3.000 3.000 5.500) +) +) +	4.000 4.000 1.500	mm mm mm	
ttom Exposure Time: Insition Layer Count: Insition Type: Insition Time Decrement:	50.000 8 Linear ▼ 5.000	s	Retract Distance: Bottom Lift Speed: Lifting Speed: Bottom Retract Speed:	5.500 90.000 90.000 320.000	+ & & &	1.500 320.000 320.000 90.000	mm mm/min mm/min mm/min	
niting Mode During Printing: st Time Before Lift: st Time After Lift: st Time After Retract:	Restin▼ 0.000 0.000 1.000	s s s	Retract Speed:	320.000	8	90.000	mm/min	
	t C&B Ceramic Machine F er Height: tom Layer Count: osure Time: tom Exposure Time: nsition Layer Count: nsition Time Decrement: ting Mode During Printing: t Time Before Lift: t Time After Lift: t Time After Retract:	t C&B Ceramic Machine Resin er Height: 0.050 tom Layer Count: 5 osure Time: 5.000 tom Exposure Time: 5.000 tom Exposure Time: 50.000 nsition Layer Count: 8 nsition Type: Linear ▼ nsition Type: 5.000 ting Mode During Printing: Restin▼ t Time Before Lift: 0.000 t Time After Lift: 0.000 t Time After Retract: 1.000	t C&B Ceramic Machine Resin er Height: 0.050 mm tom Layer Count: 5 osure Time: 5.000 s tom Exposure Time: 50.000 s tom Exposure Time: 50.000 s nsition Layer Count: 8 nsition Type: Linear ▼ nsition Type: S.000 s ting Mode During Printing: Restin▼ t Time Before Lift: 0.000 s t Time After Lift: 0.000 s t Time After Retract: 1.000 s	t C&B Ceramic ▼ Machine Resin Print er Height: 0.050 mm Bottom Lift Distance: tom Layer Count: 5 Lifting Distance: osure Time: 5.000 s Bottom Retract Distance: tom Exposure Time: 50.000 s Retract Distance: nsition Layer Count: 8 Bottom Lift Speed: nsition Type: Linear ▼ Lifting Speed: nsition Type: 5.000 s Bottom Retract Speed: nsition Type: S.000 s Bottom Retract Speed: ting Mode During Printing: Restin▼ Retract Speed: t Time Before Lift: 0.000 s s t Time After Lift: 0.000 s s t Time After Retract: 1.000 s s	t C&B Ceramic ▼ E ✓ Machine Resin Print Gcode er Height: 0.050 mm Bottom Lift Distance: 3.000 tom Layer Count: 5 Lifting Distance: 3.000 osure Time: 5.000 s Bottom Retract Distance: 5.500 tom Exposure Time: 50.000 s Retract Distance: 5.500 nsition Layer Count: 8 Bottom Lift Speed: 90.000 nsition Type: Linear ▼ Lifting Speed: 90.000 nsition Type: Linear ▼ Lifting Speed: 320.000 ting Mode During Printing: Restin▼ Retract Speed: 320.000 t Time Before Lift: 0.000 s s t Time After Lift: 0.000 s s t Time After Retract: 1.000 s s	t C&B Ceramic ▼ Image: Constant of the second	t C&& Ceramic Image: Constraint of the constraint of th	t C&B Ceramic ▼ Image: Constraint of the second seco



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• Follow the settings of Prevest C&B Permanent.

	Settings								×
		Prevest C&B Permanent							909
	Default	Machine Resin Print			Print	Gcode			Advanced
	AnyCubic Photon Ultra)					
	UniFormation GKtwo	Layer Height:	0.05	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:	5)	Bottom Lift Speed:	90.000	&	320.000	mm/min
₽ CARACTERCIAL		Transition Type:	Linear 🔻)	Lifting Speed:	90.000	&	320.000	mm/min
CG-P		Transition Time Decrement:	7.500) s	Bottom Retract Speed:	320.000	&	90.000	mm/min
20 Printing Room		Waiting Mode During Printing:	Restin v)	Retract Speed:	320.000	&	90.000	mm/min
1.000		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 C&B Interim.

	Settings								X
UNIFORMATION GK TWO	Default	Prevest C&B Interim Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra	Layer Height:	0.05	mm	Bottom Lift Distance:	3.000) +	4.000	mm
	One official of Skiwo	Bottom Layer Count:	5)	Lifting Distance:	3.000	+	4.000	mm
—		Exposure Time: Bottom Exposure Time:	5.000	s s	Bottom Retract Distance: Retract Distance:	5.500	+	1.500	mm mm
		Transition Layer Count:	8)	Bottom Lift Speed:	90.000	8	320.000	mm/min
		Transition Type:	Linear ▼)] s	Lifting Speed: Bottom Retract Speed:	90.000	& &	320.000	mm/min
550)		Waiting Mode During Printing:	Restin V)	Retract Speed:	320.000	8	90.000	mm/min
		Rest Time Before Lift:	0.000	s					
		Rest Time After Lift: Rest Time After Retract:	0.000	s s					



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PIOCREAT C02 $(0.025 - 0.1 \ \mu)$



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

	Prevest Model Pro			
	Prevest Denture	Print		
i	Prevest C&B Interim			
	Prevest C&B Permanent		Lifting Speed	
	Prevest C&B Ceramic			
PIDCHEAY	Prevest Surgical Guide			
	Prevest Burn Out			
		Advance		
30 Programmer The Programmer Theorem Theorem Construction Construction Construction Construction				

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

	Prevest Model Pro	:					
	Prevest Denture	Print					
	Prevest C&B Interim						
- Inda	Prevest C&B Permanent				Lifting Speed		
	Prevest C&B Ceramic						
	Prevest Model	Bottom Exposure Time					
PIDEHLAY	Prevest Surgical Guide	:					
	Prevest Burn Out						
		Advance					
		Bottom Light PWM					
to Argonica							
		Anti-aliasing	None	٠			

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• Follow the settings of Prevest Surgical Guide.

	Prevest Surgical Guide					
		Print				
		Layer Height		Lifting Distance		
		Bottom Layer Count		Lifting Speed		
		Exposure Time				
PICETEAY		Bottom Exposure Time				
		Light-off Delay				
Ref Contraction		Advance				
		Bottom Light PWM				
Kingca Gata						
		Picture Grayscale				
		Anti-aliasing				

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

	Prevest Denture			
	Prevest Surgical Guide	Print		
	Prevest Burn Out	Layer Height	Lifting Distance	
PIDEREAY		Bottom Layer Count	Lifting Speed	600.000 🛟 + 0.000 📫 mm/min
		Exposure Time		
-		Bottom Exposure Time		
		Light-off Delay Advance		
1000g		Bottom Light PWM 255 💡 /		
		Light PWM 255 🖕 /		
		Picture Grayscale 255 🖕		
		Anti-aliasing None		

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

Print				
		Lifting Distance		
Bottom Layer Count		Lifting Speed		
Exposure Time				
Bottom Exposure Time				
Light-off Delay				
Advance				
Bottom Light PWM 255 🖕 /				
Picture Grayscale 255				
Anti-aliasing None				
	Print Layer Height Bottom Layer Count Exposure Time Bottom Exposure Time Light-off Delay Advance Bottom Light PWM 255 Light PWM 255 Picture Grayscale 255 Anti-aliasing None	Print Layer Height Bottom Layer Count Bottom Layer Count Exposure Time Bottom Exposure Time S0000 S0000 S0000 S0000 S0000 S0000 S0000 Sonon Bottom Light PWM 255 / * Picture Grayscale 255 None	Print Layer Height Bottom Layer Count 5 Bottom Layer Count 5 Count 5000 s Bottom Eposure Time 50000 s Light-off Delay 4000 s Rotrom Light PWM 255 / * Picture Grayscale 255 None	Print Layer Height 0.050 mm Bottom Layer Count 5 5 Exposure Time 5000 5 Bottom Exposure Time 5000 5 Light off Delay 4000 4000 5 Advance Bottom Light PVM 255 / Picture Grayscale 235 . Anti-aliasing

• Follow the settings of Prevest C&B Ceramic.

	Prevest Denture			
	Prevest C&B Interim	Print		
	Prevest C&B Permanent	Layer Height	Lifting Distance	
	Prevest C&B Ceramic	Bottom Layer Count	Lifting Speed	600.000 🛟 + 0.000 🛟 mm/min
PIDEREAT	Prevest Surgical Guide	Exposure Time		
	Prevest Burn Out	Bottom Exposure Time		
		Light-off Delay		
		Advance		
20 Pering Ahana Bridge Crear & Bridge Today		Bottom Light PWM 255 🔹 /		
		Light PWM 255 🗸 /		
		Picture Grayscale 255		
		Anti-aliasing None		



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• Follow the settings of Prevest C&B Permanent.

	Prevest Denture			
	Prevest C&B Interim	Print		
	Prevest C&B Permanent	Layer Height	Lifting Distance	
Prevest	Prevest Surgical Guide	Bottom Layer Count	Lifting Speed	
	Prevest Burn Out	Exposure Time		
		Bottom Exposure Time		
		Light-off Delay		
		Advance		
С&В		Bottom Light PWM 255		
20 Prince Dear Court & Bridge Court & Bridge Court & Court Court & Court Court				
		Picture Grayscale 255		
		Anti-aliasing None		

• Follow the settings of Prevest C&B Interim.

	Prevest Denture				
En o	Prevest C&B Interim	Print			
	Prevest Surgical Guide	Layer Height		Lifting Distance	
	Prevest Burn Out	Bottom Layer Count		Lifting Speed	600.000 🗘 + 0.000 🗘 mm/min
PRESERVE AV		Exposure Time			
		Bottom Exposure Time			
		Light-off Delay Advance Bottom Light PWM 255 , / Light PWM 255 , / Picture Grayscale 255 , Anti-aliasing None	4000 ÷ s		



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Any cubic Photon Ultra ($0.05 - 0.1 \mu$)



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

		Prevest Model Pro						
	Default	Machine Re	sin		Print	Gcode	Ad	dvanced
	Phrozen Sonic Mighty 4K	Laver Height	0.050	mm	Bottom Lift D)istance:	5.000	mm
<u>(00</u>	Phrozen Sonic Mini 8K	Bottom Laver Count:	5]	Lifting Distan	ce:	5.000	mm
308	AnyCubic Photon Ultra	Exposure Time:	5.000	s	Bottom Retra	ct Distance:	5.000	mm
INCTON ULINA	AnyCubic Photon S *1	Bottom Exposure Time:	50.000	s	Retract Dista	nce:	5.000	mm
	Prevest New Printer	Transition Layer Count:	5)	Bottom Lift S	peed:	120.000	
	EPAX DX1 PRO	Transition Type:	Linear 🔻)	Lifting Speed	:	120.000	mm/min
	Galaxy 1	Transition Time Decrement:	7.500	s	Bottom Retra	ict Speed:	120.000	mm/min
C PREVENTION OF CONTROL	Galaxy 1 *1	Light-off Delay:	1.000	s	Retract Speed	d:	120.000	mm/min
MODEL	Galaxy 1 *2							
30 Printing Research For Path Landon of Theorementation Medium	AnyCubic P Mono X 6K							
10009	ELEGOO MARS 3							

• Follow the settings of Prevest Model.

	Settings							\times
ANYCUBIC		Prevest Model						
	Default	Machine	Resin		Print	Gcode	Ad	dvanced
	Phrozen Sonic Mighty 4K							7
i and a second	Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Life	t Distance:	5.000	mm
	AnyCubic Photon Ultra	Bottom Layer Count:	5		Lifting Dist	ance:	5.000	mm
1 3 0 5 B	- All Carlot and Carlo	Exposure Time:	5.000	s	Bottom Re	tract Distance:	5.000	mm
PHOTON ULTRA	AnyCubic Photon S *1	Bottom Exposure Time:	50.000	s	Retract Dis	tance:	5.000	mm
	Prevest New Printer	Transition Layer Count:	5		Bottom Life	Speed:	120.000	mm/min
	EPAX DX1 PRO	Transition Type:	Linear	•	Lifting Spe	ed:	120.000] mm/min
	Galaxy 1	Transition Time Decreme	ent: 7.500	s	Bottom Re	tract Speed:	120.000	mm/min
	Galaxy 1 *1	Light-off Delay:	1.000	s	Retract Spe	eed:	120.000] mm/min
MODEL	Galaxy 1 *2							
ter Patropiconol	AnyCubic P Mono X 6K							
10089	ELEGOO MARS 3							



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

	Settings							×
ANYCUBIC		Prevest Surgical Guide	Pesin		Drint	Grade		
	Derduit	Macinite	Resili		, and the second s	GCOUE		Wanced
<u>.</u>	Phrozen Sonic Mighty 4K	Laver Height:	0.050	mm	Bottom Lift	Distance:	5.000	mm
COLOR AND A DECIMAL AND A DECI	Phrozen Sonic Mini 8K	Bottom Laver Count:	5)	Lifting Dista	nce.	5.000	mm
305	AnyCubic Photon Ultra	Exposure Time:	5.000] <u>-</u>	Bottom Retr	act Distance:	5.000	mm
PHOTON ULTRA	AnyCubic Photon S *1	Bottom Exposure Time:	50.000		Retract Dist:		5.000	mm
	Prevest New Printer	Transition Laver Count:	50.000	ן א	Bottom Lift	Speed:	120,000	mm/min
	EPAX DY1 PPO	Transition Type:	Linear V	J	Lifting Spee	d.	120.000	mm/min
	LFAA DAI FRO)]	Detters Det	u.	120.000	
SURGICAL GUIDE	Galaxy 1	Transition Time Decrement		s	Bottom Retr	act Speed:	120.000	_ mm/min
SD Printing Ream for Extension of Surgical Guide	Galaxy 1 *1	Light-off Delay:	1.000	S	Retract Spee	ed:	120.000	mm/min
1000g	Galaxy 1 *2							
	AnyCubic P Mono X 6K							
	ELEGOO MARS 3							

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

ELEGOO MARS 3

	Settings							X
ANYCUBIC		Prevest Denture			•) 🗈 💉 🛍	00	
	Default	Machine	Resin		Print	Gcode	Ac	lvanced
i de la compañía de	Phrozen Sonic Mighty 4K		_					
	Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Lift D	istance:	5.000	mm
	AnyCubic Photon Liltra	Bottom Layer Count:	5	ļ	Lifting Distant	ce:	5.000	mm
		Exposure Time:	5.000	s	Bottom Retra	ct Distance:	5.000	mm
	AnyCubic Photon S *1	Bottom Exposure Time:	50.0	s	Retract Distar	nce:	5.000	mm
HPREVENTION Prof	Prevest New Printer	Transition Layer Count:	5)	Bottom Lift Sp	peed:	120.000] mm/min
DENTURE	EPAX DX1 PRO	Transition Type:	Linear 🔻)	Lifting Speed:		120.000] mm/min
	Galaxy 1	Transition Time Decrement:	7.500	s	Bottom Retra	ct Speed:	120.000	mm/min
10001	Galaxy 1 *1	Light-off Delay:	1.000	s	Retract Speed	Ŀ	120.000] mm/min
	Galaxy 1 *2							
	AnyCubic P Mono X 6K							



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

	Settings ×												
ANICOBIC		Prevest Burn Out											
	Default	Machine	Resin		Print	Gcode	Ad	lvanced					
-	Phrozen Sonic Mighty 4K												
(Bup	Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Lift	Distance:	5.000	mm					
3 . S	ApuCubic Photon Ultra	Bottom Layer Count:	5]	Lifting Dista	ance:	5.000	mm					
PHOTON ULTINA	Anycubic Photon Ultra	Exposure Time:	5.000	s	Bottom Ret	tract Distance:	5.000	mm					
	AnyCubic Photon S *1	Bottom Exposure Time:	50.0	s	Retract Dist	tance:	5.000	mm					
	Prevest New Printer	Transition Layer Count:	5]	Bottom Lift	Speed:	120.000	mm/min					
REVENT David of the second	EPAX DX1 PRO	Transition Type:	Linear 🔻)	Lifting Spee	ed:	120.000	mm/min					
BURN OUT	Galaxy 1	Transition Time Decrement:	7.500	s	Bottom Ret	tract Speed:	120.000	mm/min					
3D Persing Rean for DENTAL CASTWO	Galaxy 1 *1	Light-off Delay:	1.000	s	Retract Spe	ed:	120.000	mm/min					
1000	Galaxy 1 *2												
	AnyCubic P Mono X 6K												
	ELEGOO MARS 3												

• Follow the settings of Prevest C&B Ceramic.

UniFormation GKtwo

	Settings	Settings											
ANTCOBIC		Prevest C&B Ceramic											
	Default	Machine	Resin			Print	Gcode	Ad	vanced				
in hi	AnyCubic Photon Ultra												
B.C.C	AnyCubic Photon X	Layer Height:	(0.050	mm	Bottom Lift [Distance:	5.000	mm				
PHOTON ULTRA		Bottom Layer Count:	(5)	Lifting Distar	nce:	5.000	mm				
	ELEGOO Mars 4 Ultra	Exposure Time:	(5.000	s	Bottom Retra	act Distance:	5.000	mm				
R MANANDAR	ELEGOO SATURN 8K	Bottom Exposure Tim	ne:	50.000	s	Retract Dista	ince:	5.000	mm				
	Phrozen Sonic Mini 8K	Transition Layer Cour	nt:	5	Ĵ	Bottom Lift S	Speed:	120.000	mm/min				
22 Preveng filean ter fabruaring filean Grown & Badge	Phrozen Sonic Mini 4K	Transition Type:		Linear 🔻		Lifting Speed	d:	120.000	mm/min				
	ELEGOO SATURN 2	Transition Time Decre	ement:	7.500) s	Bottom Retra	act Speed:	120.000	mm/min				
	AnyCubic Pon Mono 4K	Light-off Delay:		1.000) s	Retract Spee	d:	120.000	mm/min				
	AnyCubic Pon Mono SE												
	AnyCubic Photon S												



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• Follow the settings of Prevest C&B Permanent.

ANYCUBIC	Settings					_	_	
	🕒 🗇	Prevest C&B Permanent				🕒 💉 🗊	S C I	
	Default	Machine	Resin		Print	Gcode	Ad	dvanced
	Phrozen Sonic Mighty 4K			-				_
	Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Lift	Distance:	5.000	mm
	AnyCubic Photon Liltra	Bottom Layer Count:	5	J	Lifting Distar	nce:	5.000	mm
PHOTON MUTHA	Anycobic Photomonia	Exposure Time:	5.000	s	Bottom Retra	act Distance:	5.000	mm
	AnyCubic Photon S *1	Bottom Exposure Time:	50.000	s	Retract Dista	nce:	5.000	mm
	Prevest New Printer	Transition Layer Count:	5]	Bottom Lift S	Speed:	120.000	mm/min
	EPAX DX1 PRO	Transition Type:	Linear 🔻)	Lifting Speed	J:	120.000	mm/min
Receives of loanshop	Galaxy 1	Transition Time Decrement:	7.500	s	Bottom Retra	act Speed:	120.000	mm/min
C&B 20 Pages Breat	Galaxy 1 *1	Light-off Delay:	1.000	s	Retract Spee	d:	120.000	mm/min
tor Patroaden of Covers & Britige International Antipersonal Totolog	Galaxy 1 *2							
	AnyCubic P Mono X 6K							
	ELEGOO MARS 3							

• Follow the settings of Prevest C&B Interim.

	Settings							X
TANYCUBIC		Prevest C&B Interim					102	
	Default	Machine	Resin		Print	Gcode	Ac	lvanced
	Phrozen Sonic Mighty 4K							-
3.2	Phrozen Sonic Mini 8K	Layer Height:	0.050	mm	Bottom Lift	Distance:	5.000	mm
PHOTON ULTRA	Throzen Some min or	Bottom Layer Count:	5		Lifting Dista	nce:	5.000	mm
	AnyCubic Photon Ultra	Exposure Time:	5.000	s	Bottom Retr	act Distance:	5.000	mm
	AnyCubic Photon S *1	Bottom Exposure Time:	50.000	s	Retract Dista	ince:	5.000	mm
	Prevest New Printer	Transition Layer Count:	5]	Bottom Lift	Speed:	120.000	mm/min
20 Proting Reun for Patriceson und Charleson	EPAX DX1 PRO	Transition Type:	Linear 🔻)	Lifting Speed	d:	120.000	mm/min
10000	Galaxy 1	Transition Time Decrement:	7.500	s	Bottom Retr	act Speed:	120.000	mm/min
	Galaxy 1 *1	Light-off Delay:	1.000	s	Retract Spee	ed:	120.000] mm/min
	Galaxy 1 *2							
	AnvCubic P Mono X 6K							

ELEGOO MARS 3



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PREVEST//3D

Any cubic Photon X (0.05 – 0.1 μ)



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

ANTCUBIC	Settings						×
		Prevest Model Pro					
	Default	Machine	Resin		Print	Advar	nced
řena na n	AnyCubic Photon Ultra	Layer Height:	0.050	mm	Bottom Lift Distance:	8.000	mm
		Bottom Layer Count:	6		Lifting Distance:	8.000	mm
	AnyCubic Photon X	Exposure Time:	5.000	S	Bottom Retract Distance:	8.000	mm
In Broom a		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
Reference and the second					Retract Speed:	240.000	mm/min
NODEL ERC District Honor Storescenter							

• Follow the settings of Prevest Model.





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• Follow the settings of Prevest Surgical Guide.

Settings					\times
	Prevest Surgical Guide				C
Default	Machine	Resin	Print	Advanced	
AnyCubic Photon Ultra UniFormation GKtwo AnyCubic Photon X	Layer Height: Bottom Layer Count: Exposure Time: Bottom Exposure Time: Light-off Delay:	0.050 mm 6 5.000 s 50.000 s 0.500 s	Bottom Lift Distance: Lifting Distance: Bottom Retract Distance: Retract Distance: Bottom Lift Speed: Lifting Speed: Bottom Retract Speed: Retract Speed:	8.000 mm 8.000 mm 8.000 mm 8.000 mm 240.000 mm/mi 240.000 mm/mi 240.000 mm/mi 240.000 mm/mi 240.000 mm/mi	n n n

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





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• Follow the settings of Prevest Burn Out.

BIC B m	Prevest Burn Out					61
Default	Machine	Resin		Print	Adva	nced
AnyCubic Photon Ultra UniFormation GKtwo AnyCubic Photon X	Layer Height: Bottom Layer Count: Exposure Time: Bottom Exposure Time: Light-off Delay:	0.050 6 5.000 0.500	mm s s s	Bottom Lift Distance: Lifting Distance: Bottom Retract Distance: Retract Distance: Bottom Lift Speed: Lifting Speed: Bottom Retract Speed: Retract Speed:	8.000 8.000 8.000 8.000 240.000 240.000 240.000 240.000) mm) mm) mm) mm/mi) mm/mi) mm/mi

• Follow the settings of Prevest C&B Ceramic.





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• Follow the settings of Prevest C&B Permanent.

	Settings						×
ANYCUBIC	Default	Prevest C&B Permanent Machine	Resin		Print	Advan	nced
	AnyCubic Photon Ultra UniFormation GKtwo AnyCubic Photon X	Layer Height: Bottom Layer Count: Exposure Time: Bottom Exposure Time: Light-off Delay:	0.050 6 5.000 50.000 0.500	mm s s s	Bottom Lift Distance: Lifting Distance: Bottom Retract Distance: Retract Distance: Bottom Lift Speed: Lifting Speed: Bottom Retract Speed: Retract Speed:	8.000 8.000 8.000 240.000 240.000 240.000 240.000) mm mm mm mm/min mm/min mm/min mm/min

• Follow the settings of Prevest C&B Interim.





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Elegoo Mars 4 Ultra (0.025 – 0.1 μ)



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

		Prevest Model Pro					•		DC
1	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra UniFormation GKtwo AnyCubic Photon X ELEGOO Mars 4 Ultra	Layer Height: Bottom Layer Count: Exposure Time: Bottom Exposure Time: Transition Layer Count: Transition Type: Transition Time Decrement: Waiting Mode During Printing: Rest Time Before Lift:	0.050 5 5.000 5 Uinear ▼ 7.500 Restin▼ 0.000) mm) s) s) s) s) s) s	Bottom Lift Distance: Lifting Distance: Bottom Retract Distance: Retract Distance: Bottom Lift Speed: Lifting Speed: Bottom Retract Speed: Retract Speed:	2.000 2.000 3.000 75.000 75.000 230.000 230.000	+ + + + + + & & & & & & & & & & & & & &	3.000 3.000 2.000 230.000 230.000 75.000 75.000	mm mm mm mm/min mm/min mm/min mm/min
		Rest Time After Lift: Rest Time After Retract:	0.000	s s					

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

	D	Prevest Model			•) 🗄 ⊿	<u>م</u>		DC
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra								_
	UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	2.000	+	3.000	mm
100		Bottom Layer Count:	5]	Lifting Distance:	2.000) +	3.000	mm
	AnyCubic Photon X	Exposure Time:	3.000	s	Bottom Retract Distance:	3.000	+	2.000	mm
	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	30.000	s	Retract Distance:	3.000) +	2.000	mm
		Transition Layer Count:	5]	Bottom Lift Speed:	75.000	8	230.000	mm/mi
2		Transition Type:	Linear v]	Lifting Speed:	75.000	8	230.000	mm/mir
STDerri ^p 10 ⁰		Transition Time Decrement:	4.500	s	Bottom Retract Speed:	230.000	8	75.000	mm/mi
		Waiting Mode During Printing:	Restin v)	Retract Speed:	230.000	&	75.000	mm/mi
		Rest Time Before Lift:	0.000	s					
aton of ALL		Rest Time After Lift:	0.000	s					
		Part Time After Petract	0.500	1					



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• Follow the settings of Prevest Surgical Guide.

		Prevest Surgical Guide							
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra								
20	UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	2.000	+	3.000	mm
ltra		Bottom Layer Count:	5)	Lifting Distance:	2.000) +	3.000	mm
	AnyCubic Photon X	Exposure Time:	5.000	s	Bottom Retract Distance:	3.000	+	2.000	mm
	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.000	s	Retract Distance:	3.000	+	2.000	mm
Į		Transition Layer Count:	5)	Bottom Lift Speed:	75.000	&	230.000	mm/mi
undrug ^a		Transition Type:	Linear 🔻)	Lifting Speed:	75.000	&	230.000	mm/mi
AL		Transition Time Decrement:	7.500	s	Bottom Retract Speed:	230.000	&	75.000	mm/mi
E 10		Waiting Mode During Printing:	Restin V)	Retract Speed:	230.000	&	75.000	mm/mi
		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 Denture.





PREVEST//3D

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

Default Machine Resin Print Gcode Advance AnyCubic Photon Ultra UniFormation GKtwo AnyCubic Photon X Layer Height: 0.050 mm Bottom Lift Distance: 2.000 + 3.000 mm AnyCubic Photon X ELEGOO Mars 4 Ultra Bottom Layer Count: 5 Lifting Distance: 3.000 + 2.000 mm Bottom Layer Count: 5 Bottom Retract Distance: 3.000 + 2.000 mm Transition Layer Count: 5 Bottom Lift Speed: 75.000 & 230.000 mm/r Transition Type: Linear ▼ Lifting Speed: 230.000 & 75.000 mm/r Waiting Mode During Printing: RestTime Before Lift: 0.000 s Retract Speed: 230.000 mm/r			Prevest Burn Out					2		DC
AnyCubic Photon Ultra UniFormation GKtwo AnyCubic Photon X ELEGOO Mars 4 Ultra Bottom Exposure Time: 5.000 s Bottom Retract Distance: 3.000 + 2.000 mm Bottom Exposure Time: 5.000 s Bottom Retract Distance: 3.000 + 2.000 mm Transition Layer Count: 5 Bottom Lift Speed: 75.000 & 230.000 mm/r Transition Type: Linear Lifting Speed: 75.000 & 230.000 mm/r Transition Time Decrement: 7.500 s Bottom Retract Speed: 230.000 & 75.000 mm/r Waiting Mode During Printing: Restin Retract Speed: 230.000 & 75.000 mm/r		Default	Machine	Resin		Print	Gcode			Advanced
Layer Height: 0.050 mm Bottom Lift Distance: 2.000 + 3.000 mm AnyCubic Photon X ELEGOO Mars 4 Ultra Bottom Layer Count: 5 Lifting Distance: 2.000 + 3.000 mm Bottom Layer Count: 5 Bottom Retract Distance: 3.000 + 2.000 mm Transition Layer Count: 5 Bottom Lift Speed: 75.000 & 230.000 mm/r Transition Type: Linear Lifting Speed: 75.000 & 230.000 mm/r Waiting Mode During Printing: Restin▼ Retract Speed: 230.000 & 75.000 mm/r	F1 5000	AnyCubic Photon Ultra						_		~
AnyCubic Photon X Bottom Layer Count: 5 Lifting Distance: 2.000 + 3.000 mm ELEGOO Mars 4 Ultra Bottom 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/r Transition Type: Linear ▼ Lifting Speed: 75.000 & 230.000 mm/r Transition Type: Transition Time Decrement: 7.500 s Bottom Retract Speed: 230.000 mm/r Waiting Mode During Printing: Restim▼ Retract Speed: 230.000 & mm/r Rest Time Before Lift: 0.000 s s Printing: Retract Speed: 230.000 & mm/r	Mars 4 Ultra	UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	2.000	+	3.000	mm
AnyCubic Photon X 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/r Transition Type: Linear ▼ Lifting Speed: 75.000 & 75.000 mm/r Waiting Mode During Printing: Restin▼ Retract Speed: 230.000 & 75.000 mm/r Rest Time Before Lift: 0.000 s s S			Bottom Layer Count:	5)	Lifting Distance:	2.000	+	3.000	mm
ELEGOO Mars 4 Ultra 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/r Transition Type: Linear V Lifting Speed: 75,000 & 230,000 mm/r Transition Time Decrement: 7,500 s Bottom Retract Speed: 230,000 mm/r Waiting Mode During Printing: Rest Time Before Lift: 0,000 s S S		AnyCubic Photon X	Exposure Time:	5.000	s	Bottom Retract Distance:	3.000	+	2.000	mm
Transition Layer Count: 5 Bottom Lift Speed: 75.000 & 230.000 mm/r Transition Type: Linear ▼ Lifting Speed: 75.000 & 230.000 mm/r Transition Type: Transition Time Decrement: 7.500 s Bottom Retract Speed: 230.000 mm/r Transition Time Decrement: 7.500 s Bottom Retract Speed: 230.000 mm/r Waiting Mode During Printing: Restin▼ Retract Speed: 230.000 & 75.000 mm/r Rest Time Before Lift: 0.000 s s s s s s	-	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.000	s	Retract Distance:	3.000)+	2.000	mm
Image: second secon			Transition Layer Count:	5)	Bottom Lift Speed:	75.000	&	230.000	mm/min
RN OUT Transition Time Decrement: 7.500 s Bottom Retract Speed: 230.000 & 75.000 mm/r Waiting Mode During Printing: Restin▼ Retract Speed: 230.000 & 75.000 mm/r Rest Time Before Lift: 0.000 s s s s	REVEST Dan Fro [®]		Transition Type:	Linear 🔻)	Lifting Speed:	75.000	8	230.000	mm/min
Waiting Mode During Printing: Restin▼ Retract Speed: 230.000 & 75.000 mm/r			Transition Time Decrement:	7.500	s	Bottom Retract Speed:	230.000	8	75.000	mm/min
Rest Time Before Lift: 0.000 s	Proting Resin for NTAL CASITING		Waiting Mode During Printing:	Restin v)	Retract Speed:	230.000	&	75.000	mm/min
	1000g		Rest Time Before Lift:	0.000	s					
			Rest Time After Retract:	0.500	s					

• Follow the settings of Prevest C&B Ceramic.

Settings								×
	Prevest C&B Ceramic							DCC
Default	Machine	Resin		Print	Gcode			Advanced
AnyCubic Photon Ultra UniFormation GKtwo AnyCubic Photon X ELEGOO Mars 4 Ultra	Layer Height: Bottom Layer Count: Exposure Time: Bottom Exposure Time: Transition Layer Count: Transition Type: Transition Time Decrement:	0.050 5 5.000 5 0.000 5 Linear ▼ 7.500) mm) s) s) s)	Bottom Lift Distance: Lifting Distance: Bottom Retract Distance: Retract Distance: Bottom Lift Speed: Lifting Speed: Bottom Retract Speed:	2.000 2.000 3.000 75.000 75.000 230.000) +) +) +) +) &) &	3.000 3.000 2.000 2.000 230.000 230.000 75.000) mm mm mm mm mm/min mm/min 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					



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• Follow the settings of Prevest C&B Permanent.

	Prevest C&B Permanent				•			
Default	Machine	Resin		Print	Gcode			Advanced
AnyCubic Photon Ultra						_		
UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	2.000] +	3.000	mm
	Bottom Layer Count:	5		Lifting Distance:	2.000) +	3.000	mm
AnyCubic Photon X	Exposure Time:	5.000	s	Bottom Retract Distance:	3.000) +	2.000	mm
ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.000	s	Retract Distance:	3.000) +	2.000	mm
	Transition Layer Count:	5		Bottom Lift Speed:	75.000	8	230.000	mm/mi
	Transition Type:	Linear v		Lifting Speed:	75.000	8	230.000	mm/mi
	Transition Time Decrement:	7.500	s	Bottom Retract Speed:	230.000	8	75.000	mm/mi
	Waiting Mode During Printing:	Restin ▼		Retract Speed:	230.000	8	75.000	mm/mi
	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.

k.

E	Prevest C&B Interim					*		DC
Default	Machine	Resin		Print	Gcode			Advanced
AnyCubic Photon Ultra						_		-
UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	2.000	+	3.000	mm
	Bottom Layer Count:	5)	Lifting Distance:	2.000	+	3.000	mm
AnyCubic Photon X	Exposure Time:	5.000	s	Bottom Retract Distance:	3,000	+	2.000	mm
ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.000	s	Retract Distance:	3.000	+	2.000	mm
	Transition Layer Count:	5)	Bottom Lift Speed:	75.000	8	230.000	mm/mir
	Transition Type:	Linear 🔻)	Lifting Speed:	75.000	8	230.000	mm/mir
	Transition Time Decrement:	7.500	s	Bottom Retract Speed:	230.000	8	75.000	mm/mir
	Waiting Mode During Printing:	Restin 🔻]	Retract Speed:	230.000	8	75.000	mm/mir
	Rest Time Before Lift:	0.000	s					
	Rest Time After Lift:	0.000	s					
	Past Time After Patract	0.500	ĺ.					



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PREVEST//3D

С&В



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

	D	Prevest Model Pro			•				N
Low State	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000] +	4.000	mm
difference of	UniFormation GKtwo	Bottom Layer Count:	5)	Lifting Distance:	3.000	<u>)</u> +	4.000	mm
	AnyCubic Photon X	Exposure Time:	5.000	s	Bottom Retract Distance:	5.500	+	1.500	mm
SATURN SK	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.0	s	Retract Distance:	5.500) +	1.500	mm
	ELEGOO SATURN 8K	Transition Layer Count:	8)	Bottom Lift Speed:	65.000	8	180.000	mm/min
		Transition Type:	Linear 🔻)	Lifting Speed:	65.000	8	180.000	mm/min
		Transition Time Decrement:	5.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/min
R INEXESTIQUIN'		Waiting Mode During Printing:	Restin 🔻)	Retract Speed:	180.000	8	65.000	mm/min
MODEL		Rest Time Before Lift:	0.000	s					
MODEL		Rest Time After Lift:	0.000	s					

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

THE SEAL	E	Prevest Model			•		P [DC
ALCON.	Default	Machine	Resin		Print	Gcode			Advanced
Red.	AnyCubic Photon Ultra								-
	UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000	+	4.000	mm
-		Bottom Layer Count:	5)	Lifting Distance:	3.000) +	4.000	mm
	AnyCubic Photon X	Exposure Time:	3.000	s	Bottom Retract Distance:	5.500	+	1.500	mm
SATURNEER SATURN SK	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	30.000	s	Retract Distance:	5.500) + I	1.500	mm
	ELEGOO SATURN 8K	Transition Layer Count:	8)	Bottom Lift Speed:	65.000	8	180.000	mm/mir
		Transition Type:	Linear v)	Lifting Speed:	65.000	8	180.000	mm/mir
REPREVENT Darring		Transition Time Decrement:	3.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/mir
		Waiting Mode During Printing:	Restin 🔻)	Retract Speed:	180.000	8	65.000	mm/mir
MODEL		Rest Time Before Lift:	0.000	s					
30 Preed need									



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• Follow the settings of Prevest Surgical Guide.

	⊡	Prevest Surgical Guide			•		•		DC
1536	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra								_
	UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000] +	4.000	mm
		Bottom Layer Count:	5		Lifting Distance:	3.000	+	4.000	mm
ATURNES SATURN SK	AnyCubic Photon X	Exposure Time:	5.000	S	Bottom Retract Distance:	5.500	+	1.500	mm
	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.0	s	Retract Distance:	5.500)+	1.500	mm
	ELEGOO SATURN 8K	Transition Layer Count:	8		Bottom Lift Speed:	65.000	8	180.000	mm/min
		Transition Type:	Linear 🔻		Lifting Speed:	65.000	8	180.000	mm/min
CONVERTING.		Transition Time Decrement:	5.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/min
SURGICAL		Waiting Mode During Printing:	Restin 🔻		Retract Speed:	180.000	8	65.000	mm/min
SD Printing Resin for Falabration of Surgical Guide		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 Denture.





PREVEST//3D

Document No. F.3D.PS.01Issue No.01Revision No.01

Effective Date. 03/04/2024

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

	 ① 	Prevest Burn Out							D C
	Default	Machine	Resin		Print	Gcode			Advanced
Any	Cubic Photon Ultra								-
Ur	iFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000	+	4.000	mm
		Bottom Layer Count:	5]	Lifting Distance:	3.000) +	4.000	mm
SATURN 8K	nyCubic Photon X	Exposure Time:	5.000	s	Bottom Retract Distance:	5.500	+	1.500	mm
ELE	EGOO Mars 4 Ultra	Bottom Exposure Time:	50.000	s	Retract Distance:	5.500) +	1.500	mm
EL	EGOO SATURN 8K	Transition Layer Count:	8	j	Bottom Lift Speed:	65.000	8	180.000	mm/min
		Transition Type:	Linear 🔻)	Lifting Speed:	65.000	8	180.000	mm/min
		Transition Time Decrement:	5.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/min
		Waiting Mode During Printing:	Restin 🔻)	Retract Speed:	180.000	8	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 Ceramic.

ALC: N	Settings								X
		Prevest C&B Ceramic					2		000
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra	Laver Height:	0.050	mm	Pottom Lift Dictorco:	2 000	٦.	4.000]
	UniFormation GKtwo	Layer Height.	0.050		Bottom Lift Distance.	5.000] †	4.000	
ELEGOO GATURNER	AnyCubic Photon X	Bottom Layer Count:	5	J	Lifting Distance:	3.000	J +	4.000	_ mm
		Exposure Time:	5.000	S	Bottom Retract Distance:	5.500	+	1.500	mm
	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.000	s	Retract Distance:	5.500) +	1.500	mm
	ELEGOO SATURN 8K	Transition Layer Count:	8)	Bottom Lift Speed:	65.000	8	180.000	mm/min
		Transition Type:	Linear 🔻		Lifting Speed:	65.000	8	180.000	mm/min
References		Transition Time Decrement:	5.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/min
		Waiting Mode During Printing:	Restin 🔻)	Retract Speed:	180.000	8	65.000	mm/min
20 Premy diseas for Patronaise of Crown & Bridge		Rest Time Before Lift:	0.000	s					
rooty		Rest Time After Lift:	0.000	s					
		Rest Time After Retract:	0.500	s					



PREVEST//3D

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• Follow the settings of Prevest C&B Permanent.

		Prevest C&B Permanent							DC
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra							<i>c</i>	~
	UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000	+	4.000	mm
		Bottom Layer Count:	5)	Lifting Distance:	3.000) +	4.000	mm
	AnyCubic Photon X	Exposure Time:	5.000	s	Bottom Retract Distance:	5.500	+	1.500	mm
ETS SATURN 8K	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.000	s	Retract Distance:	5.500) +	1.500	mm
	ELEGOO SATURN 8K	Transition Layer Count:	8	Ĵ	Bottom Lift Speed:	65.000	&	180.000	mm/mir
		Transition Type:	Linear 🔻		Lifting Speed:	65.000	8	180.000	mm/mir
		Transition Time Decrement:	5.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/mir
EST Develope [®]		Waiting Mode During Printing:	Restin •)	Retract Speed:	180.000	8	65.000	mm/min
σB		Rest Time Before Lift:	0.000	s					
ding Penan Analahan di A Behapa		Rest Time After Lift:	0.000	s					
8/1888) XX0g		Rest Time After Retract:	0.500	5					

• Follow the settings of Prevest C&B Interim.

	€	Prevest C&B Interim							DC
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra						_		-
-	UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000	+	4.000	mm
		Bottom Layer Count:	5		Lifting Distance:	3.000] +	4.000	mm
RN 8K	AnyCubic Photon X	Exposure Time:	5.000	s	Bottom Retract Distance:	5.500) +	1.500	mm
	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.000	s	Retract Distance:	5.500] +	1.500	mm
	ELEGOO SATURN 8K	Transition Layer Count:	8		Bottom Lift Speed:	65.000	&	180.000	mm/mi
		Transition Type:	Linear 🔻		Lifting Speed:	65.000	8	180.000	mm/mi
		Transition Time Decrement:	5.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/mi
		Waiting Mode During Printing:	Restin		Retract Speed:	180.000	8	65.000	mm/mi
		Rest Time Before Lift:	0.000	s					
		Rest Time After Lift:	0.000	s					
•		Rest Time After Retract:	0.500	s					



Document No. F.3D.PS.01 Issue No. 01 Revision No. 01



Effective Date. 03/04/2024



Phrozen Sonic Mini 8K $(0.05 - 0.1 \mu)$



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

P	E	Prevest Model Pro							D C
Statement of the local division of the local	Default	Machine	R	esin	Print			Ad	dvanced
	AnyCubic Photon Ultra						_		-
	UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	8.000	+	0.000	mm
ALC: NO		Bottom Layer Count:	5)	Lifting Distance:	7.000	+	0.000	mm
(f from)	AnyCubic Photon X	Exposure Time:	3.000	s	Bottom Retract Distance:	8.000	+	0.000	mm
	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	30.000	s	Retract Distance:	7.000	٦+	0.000	mm
	ELEGOO SATURN 8K	Transition Layer Count:	5	Ĵ	Bottom Lift Speed:	60.000	8	0.000	mm/min
	Phrozen Sonic Mini 8K	Transition Type:	Linear 🔻		Lifting Speed:	60.000	8	0.000	mm/min
		Transition Time Decrement:	4.500	s	Bottom Retract Speed:	150.000	&	0.000	mm/min
D4 PREVESTORNERS*		Waiting Mode During Printing:	Restin 🔻)	Retract Speed:	150.000	&	0.000	mm/min
		Rest Time Before Lift:	0.000	s					
MODEL		Rest Time After Lift:	0.000	s					
30 Printing Resin for Fabrication of		Rest Time After Retract	5.000	5					

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

	Settings								×
	E	Prevest Model			•		۲		900
	Default	Machine	R	esin	Print			Ad	vanced
	AnyCubic Photon Ultra	Layer Height:	0.050	mm	Bottom Lift Distance:	8.000	+	0.000	mm
T. ALL T	UniFormation GKtwo	Bottom Laver Count:	5)	Lifting Distance:	7.000) + [0.000	mm
et frame	AnyCubic Photon X	Exposure Time:	3.000	s	Bottom Retract Distance:	8.000) + (0.000	mm
SCREE MINI	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	30.00	s	Retract Distance:	7.000	+	0.000	mm
ВК	ELEGOO SATURN 8K	Transition Layer Count:	5)	Bottom Lift Speed:	60.000	8	0.000] mm/min
	Phrozen Sonic Mini 8K	Transition Type:	Linear 🔻	l,	Lifting Speed:	60.000	&	0.000	mm/min
		Transition Time Decrement:	4.500	s	Bottom Retract Speed:	150.000	8	0.000] mm/min
		Waiting Mode During Printing:	Restin 🔻)	Retract Speed:	150.000	8	0.000	mm/min
MODEL		Rest Time Before Lift:	0.000	s					
3D Prefrag Resin For Fabrication of MoDEL		Rest Time After Lift:	0.000	s					
1000		Rest Time After Retract:	5.000	s					



PREVEST//3D

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• Follow the settings of Prevest Surgical Guide.



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

	Prevest Denture			•		P) [1		DC
Default	Machine	R	esin	Print			Ac	ivanced
AnyCubic Photon Ultra						_		2
UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	8.000	+	0.000	mm
	Bottom Layer Count:	5)	Lifting Distance:	7.000	+	0.000	mm
AnyCubic Photon X	Exposure Time:	5.000	s	Bottom Retract Distance:	8.000] +	0.000	mm
ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.000	s	Retract Distance:	7.000	+	0.000	mm
ELEGOO SATURN 8K	Transition Layer Count:	5	ĵ	Bottom Lift Speed:	60.000	8	0.000	
Phrozen Sonic Mini 8K	Transition Type:	Linear 🔻		Lifting Speed:	60.000	8	0.000	mm/min
	Transition Time Decrement:	7.500	s	Bottom Retract Speed:	150.000	8	0.000	mm/min
	Waiting Mode During Printing:	Restin 🔻)	Retract Speed:	150.000	8	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					



Document No. F.3D.PS.01

Issue No. 01

PREVEST//3D

Revision No.01Effective Date.03/04/2024

• Follow the settings of Prevest Burn Out.



• Follow the settings of Prevest C&B Ceramic.

		Prevest C&B Ceramic			•		1		DC
	Default	Machine	R	esin	Print			Ad	dvanced
	AnyCubic Photon Ultra						2 6		
a de casa	UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	8.000] + [0.000	mm
	onii oniiddon oktio	Bottom Layer Count:	5]	Lifting Distance:	7.000] +	0.000	mm
BK	AnyCubic Photon X	Exposure Time:	5.000	s	Bottom Retract Distance:	8.000	+	0.000	mm
•	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.0	s	Retract Distance:	7.000] + [0.000	mm
	ELEGOO SATURN 8K	Transition Layer Count:	5	Ĵ	Bottom Lift Speed:	60.000	8	0.000	mm/min
	Phrozen Sonic Mini 8K	Transition Type:	Linear v)	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 V)	Retract Speed:	150.000	&	0.000	mm/min
to Proving Second		Rest Time Before Lift:	0.000	s					
roong		Rest Time After Lift:	0.000	s					
		Rest Time After Retract:	5.000	s					



PREVEST//3D

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• Follow the settings of Prevest C&B Permanent.

	Settings									\times
		Prevest C&B Peermanent							EC	Ø
	Default	Machine	R	esin	Print			Ad	vanced	
7	AnyCubic Photon Ultra					,			-	
() from	UniFormation GKtwo	Layer Height:	0.050	mm	Bottom Lift Distance:	8.000	+	0.000	mm	
		Bottom Layer Count:	5)	Lifting Distance:	7.000) + [0.000	mm	
р — ВК	AnyCubic Photon X	Exposure Time:	5.000	s	Bottom Retract Distance:	8.000	+	0.000	mm	
	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.000	s	Retract Distance:	7.000) + [0.000	mm	
	ELEGOO SATURN 8K	Transition Layer Count:	5)	Bottom Lift Speed:	60.000	&	0.000	mm/min	
D DEVENT Durdent	Phrozen Sonic Mini 8K	Transition Type:	Linear 🔻		Lifting Speed:	60.000	8	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	8	0.000	mm/min	
to Face-sector of Cover A British Coverage Coverage Coverage		Rest Time Before Lift:	0.000	s						
0009		Rest Time After Lift:	0.000	s						
		Rest Time After Retract:	5.000	s						

• Follow the settings of Prevest C&B Interim.

L.

And and a second		Prevest C&B Interim						DØ
	Default	Machine	Resin	Print			Ac	dvanced
	AnyCubic Photon Ultra						_	-
	UniFormation GKtwo	Layer Height:	0.050 mm	Bottom Lift Distance:	8.000	+	0.000	mm
	An Cubic Photon V	Bottom Layer Count:	5	Lifting Distance:	7.000) +	0.000	mm
	AnyCubic Photon X	Exposure Time:	5.000 s	Bottom Retract Distance:	8.000) +	0.000	mm
	ELEGOO Mars 4 Ultra	Bottom Exposure Time:	50.000 s	Retract Distance:	7.000) +	0.000	mm
	ELEGOO SATURN 8K	Transition Layer Count:	5	Bottom Lift Speed:	60.000	8	0.000	mm/min
Revenue Destant	Phrozen Sonic Mini 8K	Transition Type:	Linear 🔻	Lifting Speed:	60.000	8	0.000	mm/min
С&В		Transition Time Decrement:	7.500 S	Bottom Retract Speed:	150.000	8	0.000	mm/min
30 Printing Reals for Patrication of Crown & Bridge		Waiting Mode During Printing:	Restin	Retract Speed:	150.000	8	0.000	mm/min
10003		Rest Time Before Lift:	0.000 s					
		Rest Time After Lift:	0.000 s					
		Rest Time After Retract	5.000 s					



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PREVEST//3D

Revision	No.	01
Effective	Date.	03/04/2024



Phrozen Sonic Mini 4K ($0.05 - 0.1 \mu$)



• Slicing Software Chitu Box all versions.

• Follow the settings of **Prevest Model Pro.**

	Settings								×
		Prevest Model Pro			•) 🕒 🥖			900
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra						_		
1	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	6.000) +	0.000] mm
ji phrase		Bottom Layer Count:	5)	Lifting Distance:	5.000) +	0.000	mm
	ELEGOO Mars 4 Ultra	Exposure Time:	5.000	s	Bottom Retract Distance:	6.000) +	0.000	mm
	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	5.000) +	0.000	mm
	Phrozen Sonic Mini 8K	Transition Layer Count:	5)	Bottom Lift Speed:	80.000	8	0.000] mm/min
	Phrozen Sonic Mini 4K	Transition Type:	Linear 💌)	Lifting Speed:	80.000	8	0.000] mm/min
	ELEGOO SATURN 2	Transition Time Decrement:	7.500) s	Bottom Retract Speed:	150.000) &	0.000] mm/min
24 PREVESTOURING	AnyCubic Pon Mono 4K	Waiting Mode During Printing:	Light 🔻]	Retract Speed:	150.000) &	0.000] mm/min
Pres the Policy of advectory	AnuCubic D. on Mono SE	Light-off Delay:	9.000	s					
MODEL	AnyCubic POn Mono SE	Bottom Light-off Delay:	9.000	s					
30 Printing Reson for Path cartion of Thermonitation Mediate	AnyCubic Photon S			, ,					
1000	UniFormation GKtwo								

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

	Settings								×
		Prevest Model			•) 🗄 🥖			905
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra								
4	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	6.000	+	0.000	mm
A A A A A A A A A A A A A A A A A A A		Bottom Layer Count:	5)	Lifting Distance:	5.000) +	0.000	mm
d from	ELEGOO Mars 4 Ultra	Exposure Time:	3.000) s	Bottom Retract Distance:	6.000	+	0.000	mm
	ELEGOO SATURN 8K	Bottom Exposure Time:	30.000	s	Retract Distance:	5.000	+	0.000	mm
	Phrozen Sonic Mini 8K	Transition Layer Count:	5)	Bottom Lift Speed:	80.000	8	0.000	mm/min
	Phrozen Sonic Mini 4K	Transition Type:	Linear v		Lifting Speed:	80.000	8	0.000	mm/min
	ELEGOO SATURN 2	Transition Time Decrement:	4.500) s	Bottom Retract Speed:	150.000	8	0.000	mm/min
	AnyCubic Pon Mono 4K	Waiting Mode During Printing:	Light 🔻)	Retract Speed:	150.000	8	0.000	mm/min
	ApyCubic P. on Mono SE	Light-off Delay:	9.000) s					
MODEL	Anycubic Pon Mono Se	Bottom Light-off Delay:	9.000	s					
for Particip Rean for Particip Con of BODEL	AnyCubic Photon S								
1006g	UniFormation GKtwo								



PREVEST//3D

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• Follow the settings of Prevest Surgical Guide.

	Settings									X
		Prevest Surgical Guide								C
	Default	Machine	Resin		Print	Gcode			Advanced	
	AnyCubic Photon Ultra			<u>,</u>					<u>`</u>	
A A A	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	6.000	+	0.000	mm	
E press.		Bottom Layer Count:	4)	Lifting Distance:	5.000	+ [0.000	mm	
	ELEGOO Mars 4 Ultra	Exposure Time:	5.000	s	Bottom Retract Distance:	6.000	+ [0.000	mm	
	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	5.000	+	0.000	mm	
<u> </u>	Phrozen Sonic Mini 8K	Transition Layer Count:	4	Ĵ	Bottom Lift Speed:	80.000	8	0.000	mm/min	
	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻		Lifting Speed:	80.000	8	0.000	mm/min	
SURGICAL GUIDE	ELEGOO SATURN 2	Transition Time Decrement:	9.000	s	Bottom Retract Speed:	150.000	&	0.000	mm/min	
3D Pinning Resin for Fabroation of Sungical Calde	AnyCubic Pon Mono 4K	Waiting Mode During Printing:	Light 🔻)	Retract Speed:	150.000	&	0.000	mm/min	
1000		Light-off Delay:	9.000	s						
	AnyCubic Pon Mono SE	Bottom Light-off Delay:	9.000	s						
	AnyCubic Photon S			/						
	UniFormation GKtwo									

• Follow the settings of Prevest Denture.

	Settings							X
		Prevest Denture					00	
	Default	Machine	Resin	Print	Gcode		Adv	anced
* *	AnyCubic Photon Ultra							
and a second	AnyCubic Photon X	Layer Height:	0.050 mm	Bottom Lift Distance:	6.000	+ 0.	000 m	m
		Bottom Layer Count:	5	Lifting Distance:	5.000	+ 0.	000 m	m
Mitte 🛃	ELEGOO Mars 4 Ultra	Exposure Time:	3.000 S	Bottom Retract Distance:	6.000	+ 0.	000 m	m
	ELEGOO SATURN 8K	Bottom Exposure Time:	30.000 s	Retract Distance:	5.000	+ 0.	000 m	m
	Phrozen Sonic Mini 8K	Transition Layer Count:	5	Bottom Lift Speed:	80.000	& 0.	000 m	m/min
DENTURE	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻	Lifting Speed:	80.000	& 0.	000 m	m/min
3D Printering Reven for DENTURIE BASE	ELEGOO SATURN 2	Transition Time Decrement:	4.500 S	Bottom Retract Speed:	150.000	& 0.	000 m	m/min
10000	AnyCubic Pon Mono 4K	Waiting Mode During Printing:	Light 🔻	Retract Speed:	150.000	& 0.	000 m	m/min
	AnyCubic P on Mono SE	Light-off Delay:	9.000 s					
		Bottom Light-off Delay:	9.000 s					
	AnyCubic Photon S							
	UniFormation GKtwo							



PREVEST//3D

Document No. F.3D.PS.01 Issue No. 01

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

	Settings						×
		Prevest Burn Out					
	Default	Machine	Resin	Print	Gcode		Advanced
	AnyCubic Photon Ultra						_
	AnyCubic Photon X	Layer Height:	0.050 mm	Bottom Lift Distance:	6.000	+ 0.000	mm
		Bottom Layer Count:	5	Lifting Distance:	5.000	+ 0.000	mm
	ELEGOO Mars 4 Ultra	Exposure Time:	3.000 s	Bottom Retract Distance:	6.000	+ 0.000	mm
Minis Ca	ELEGOO SATURN 8K	Bottom Exposure Time:	30.000 s	Retract Distance:	5.000	+ 0.000	mm
	Phrozen Sonic Mini 8K	Transition Layer Count:	5	Bottom Lift Speed:	80.000	& 0.000	mm/min
₽ CONSTRUCTION	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻	Lifting Speed:	80.000	& 0.000	mm/min
BURNOUT	ELEGOO SATURN 2	Transition Time Decrement:	4.500 S	Bottom Retract Speed:	150.000	& 0.000	mm/min
30 Pering Rear for DENTAL CASTNO	AnyCubic Pon Mono 4K	Waiting Mode During Printing:	Light	Retract Speed:	150.000	& 0.000	mm/min
900 BERE	AnyCubic Pon Mono SE	Light-off Delay:	9.000 S				
	AnyCubic Photon S	Bottom Light-off Delay:	9.000 S				
	UniFormation GKtwo						

• Follow the settings of Prevest C&B Ceramic.

	Settings						×
	Default	Prevest C&B Ceramic	Resin	Print	Gcode		Advanced
* *	AnyCubic Photon Ultra						
	AnyCubic Photon X	Layer Height:	0.050 mr	m Bottom Lift Distance:	6.000	+ 0.000	mm
1015 4 .		Bottom Layer Count:	5	Lifting Distance:	5.000	+ 0.000	mm
	ELEGOO Mars 4 Ultra	Exposure Time:	3.000 S	Bottom Retract Distan	:e: 6.000	+ 0.000	mm
DJ PREVESTIONPO"	ELEGOO SATURN 8K	Bottom Exposure Time:	30.000 s	Retract Distance:	5.000	+ 0.000	mm
C&B	Phrozen Sonic Mini 8K	Transition Layer Count:	5	Bottom Lift Speed:	80.000	& 0.000	mm/min
CERAMIC 30 Protog from for Ideation of Covers 8 Indige	Phrozen Sonic Mini 4K	Transition Type:	Linear v	Lifting Speed:	80.000	& 0.000	mm/min
NOS	ELEGOO SATURN 2	Transition Time Decrement:	4.500 S	Bottom Retract Speed:	150.000	& 0.000	mm/min
	AnyCubic Pon Mono 4K	Waiting Mode During Printing:	Light 🔻	Retract Speed:	150.000	& 0.000	mm/min
	AnyCubic Pon Mono SE	Light-off Delay:	9.000 S				
	AnyCubic Photon S	Bottom Light-off Delay:	9.000 S				
	UniFormation GKtwo						



PREVEST//3D

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Effective Date. 03/04/2024

• Follow the settings of Prevest C&B Permanent.

No. of Concession, Name	Settings								×
<u>.</u>		Prevest C&B Permanent							<u></u>
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra								
	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	6.000	+	0.000	mm
-		Bottom Layer Count:	5		Lifting Distance:	5.000	+	0.000	mm
	ELEGOO Mars 4 Ultra	Exposure Time:	3.000	s	Bottom Retract Distance:	6.000	+	0.000	mm
100 A	ELEGOO SATURN 8K	Bottom Exposure Time:	30.000	s	Retract Distance:	5.000	+	0.000	mm
	Phrozen Sonic Mini 8K	Transition Layer Count:	5		Bottom Lift Speed:	80.000	8	0.000	mm/min
₽ PREVENT Develop®	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻		Lifting Speed:	80.000	&	0.000	mm/min
CG-P	ELEGOO SATURN 2	Transition Time Decrement:	4.500	s	Bottom Retract Speed:	150.000	<mark>&</mark>	0.000	mm/min
3D Porting Hean for Tablocation of Covers A Bridge	AnyCubic Pon Mono 4K	Waiting Mode During Printing:	Light 🔻		Retract Speed:	150.000	<mark>&</mark>	0.000	mm/min
1000	AnyCubic R. on Mono SE	Light-off Delay:	9.000	s					
	Anycubic Pon Mono Se	Bottom Light-off Delay:	9.000	s					
	AnyCubic Photon S								
	UniFormation GKtwo								

• Follow the settings of **Prevest C&B Interim**. Settings

UniFormation GKtwo

2		Prevest C&B Interim						
1	Default	Machine	Resin	Print	Gcode		Advanced	
*	AnyCubic Photon Ultra						_	
	AnyCubic Photon X	Layer Height:	0.050 mr	n Bottom Lift Distance:	6.000	+ 0.000	mm	
Mini da		Bottom Layer Count:	5	Lifting Distance:	5.000	+ 0.000	mm	
	ELEGOO Mars 4 Ultra	Exposure Time:	3.000 S	Bottom Retract Distance:	6.000	+ 0.000	mm	
	ELEGOO SATURN 8K	Bottom Exposure Time:	30.000 s	Retract Distance:	5.000	+ 0.000	mm	
C&B	Phrozen Sonic Mini 8K	Transition Layer Count:	5	Bottom Lift Speed:	80.000	& 0.000	mm/min	
30 Protocy Ream for Patrication of Crews A Debage Execution	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻	Lifting Speed:	80.000	& 0.000	mm/min	
1000	ELEGOO SATURN 2	Transition Time Decrement:	4.500 S	Bottom Retract Speed:	150.000	& 0.000	mm/min	
	AnyCubic Pon Mono 4K	Waiting Mode During Printing:	Light 🔻	Retract Speed:	150.000	& 0.000	mm/min	
	AnyCubic Pon Mono SE	Light-off Delay: Bottom Light-off Delay:	9.000 s					
	AnyCubic Photon S	zonom zigni on zonaji	9.000 5					



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Elegoo Saturn 2 (0.05 – 0.1 μ)



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

		Prevest Model Pro							D C
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra								_
	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000	+	4.000	mm
MERY .	Anycubic Filocontx	Bottom Layer Count:	5]	Lifting Distance:	3.000	+	4.000	mm
	ELEGOO Mars 4 Ultra	Exposure Time:	5.000	s	Bottom Retract Distance:	5.500	+	1.500	mm
ELEGOD	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	5.500]+	1.500	mm
	Phrozen Sonic Mini 8K	Transition Layer Count:	8	Ĵ	Bottom Lift Speed:	65.000	8	180.000	mm/min
	Phrozen Sonic Mini 4K	Transition Type:	Linear v)	Lifting Speed:	65.000	8	180.000	mm/min
	UniFormation GKtwo	Transition Time Decrement:	5.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/min
	ELEGOO SATURN 2	Waiting Mode During Printing:	Restin 🔻)	Retract Speed:	180.000	8	65.000	mm/min
REPERTURNING		Rest Time Before Lift:	0.000	s					
MODEL		Rest Time After Lift:	0.000	s					
30 Pirtug Resin		Past Time After Petract	0.500						

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

		(
		Prevest Model			•				PC
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra								
INU _	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000] +	4.000	mm
ELEGCO		Bottom Layer Count:	5)	Lifting Distance:	3.000) +	4.000	mm
	ELEGOO Mars 4 Ultra	Exposure Time:	3.000	s	Bottom Retract Distance:	5.500) +	1.500	mm
-	ELEGOO SATURN 8K	Bottom Exposure Time:	30.0	s	Retract Distance:	5.500	+	1.500	mm
_	Phrozen Sonic Mini 8K	Transition Layer Count:	8	j	Bottom Lift Speed:	65.000	8	180.000	
	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻)	Lifting Speed:	65.000	8	180.000	mm/min
PREVEST Dardho [®]	UniFormation GKtwo	Transition Time Decrement:	3.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/min
	ELEGOO SATURN 2	Waiting Mode During Printing:	Restin 🔻)	Retract Speed:	180.000	8	65.000	mm/min
MODEL		Rest Time Before Lift:	0.000	s					
for Patriculion of MODEL		Rest Time After Lift:	0.000	s					
1000g		Rest Time After Retract:	0.500	s					

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

Default AnyCubic Photon U AnyCubic Photon ELEGOO Mars 4 Ult ELEGOO SATURN 8 Phrozen Sonic Mini	Machine a Layer Height: Bottom Layer Count: Exposure Time: Bottom Exposure Time:	Resin 0.050 5 5.000 50.0) mm)) s	Print Bottom Lift Distance: Lifting Distance: Bottom Retract Distance:	Gcode 3.000 3.000 5.500]+]+	4.000	Advanced
AnyCubic Photon U AnyCubic Photon U AnyCubic Photon ELEGOO Mars 4 UH ELEGOO SATURN 8 Phrozen Sonic Mini	a Layer Height: Bottom Layer Count: Exposure Time: Bottom Exposure Time:	0.050 5 5.000 50.0) mm)) s	Bottom Lift Distance: Lifting Distance: Bottom Retract Distance:	3.000 3.000 5.500] +] +] .	4.000) mm) mm
AnyCubic Photon ELEGOO Mars 4 Uff ELEGOO SATURN 8 Phrozen Sonic Mini	Layer Height: Bottom Layer Count: Exposure Time: Bottom Exposure Time:	0.050 5 5.000 50.0	mm	Bottom Lift Distance: Lifting Distance: Bottom Retract Distance:	3.000 3.000 5.500)+)+).	4.000] mm] mm
ELEGOO Mars 4 Uh ELEGOO SATURN & Phrozen Sonic Mini	Bottom Layer Count: Exposure Time: Bottom Exposure Time:	5 5.000 50.0	s	Lifting Distance: Bottom Retract Distance:	3.000)+	4.000] mm
ELEGOO Mais 4 Ui ELEGOO SATURN 8 Phrozen Sonic Mini	Exposure Time: Bottom Exposure Time:	5.000	s	Bottom Retract Distance:	5.500] . (1 500	
ELEGOO SATURN S Phrozen Sonic Mini	Bottom Exposure Time:	50.0			-	1	1.500	mm
Phrozen Sonic Mini			S	Retract Distance:	5.500) +	1.500	mm
	K Transition Layer Count:	8]	Bottom Lift Speed:	65.000	8	180.000	mm/min
Phrozen Sonic Mini	K Transition Type:	Linear 🔻)	Lifting Speed:	65.000	8	180.000] mm/min
UniFormation GKtv	Transition Time Decrement:	5.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/min
SURGICAL ELEGOO SATURN	Waiting Mode During Printing:	Restin •]	Retract Speed:	180.000	8	65.000] mm/min
GUIDE	Rest Time Before Lift:	0.000	s					
tre Februarion of Sangteal Guide	Rest Time After Lift:	0.000	s					

• Follow the settings of Prevest Denture.





PREVEST//3D

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

ſ	Settings)
		Prevest Burn Out			•				29
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra						_		<u>_</u>
	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000	+	4.000	mm
		Bottom Layer Count:	5		Lifting Distance:	3.000) +	4.000	mm
	ELEGOO Mars 4 Ultra	Exposure Time:	5.000	s	Bottom Retract Distance:	5.500	+	1.500	mm
	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	5.500) +	1.500	mm
	Phrozen Sonic Mini 8K	Transition Layer Count:	8		Bottom Lift Speed:	65.000	8	180.000	mm/min
	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻		Lifting Speed:	65.000) <mark>&</mark>	180.000	mm/min
	ELEGOO SATURN 2	Transition Time Decrement:	5.000	S	Bottom Retract Speed:	180.000	&	65.000] mm/min
	AnyCubic Pon Mono 4K	Waiting Mode During Printing:	Restin		Retract Speed:	180.000	&	65.000] mm/min
	AnyCubic Pon Mono SE	Rest Time Before Lift:	0.000	S					
		Rest Time After Lift:	0.000	s					
	AnyCubic Photon S	Rest Time After Retract:	0.500	s					
	UniFormation GKtwo								

• Follow the settings of Prevest C&B Ceramic.

0									
		Prevest C&B Ceramic							DC
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra								-
	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000	+	4.000	mm
ELEGOO		Bottom Layer Count:	5)	Lifting Distance:	3.000	+	4.000	mm
	ELEGOO Mars 4 Ultra	Exposure Time:	5.000	s	Bottom Retract Distance:	5.500	+	1.500	mm
-	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	5.500) +	1.500	mm
	Phrozen Sonic Mini 8K	Transition Layer Count:	8)	Bottom Lift Speed:	65.000	8	180.000	mm/min
	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻		Lifting Speed:	65.000	8	180.000	mm/min
R CREMENTER PORT	UniFormation GKtwo	Transition Time Decrement:	5.000	s	Bottom Retract Speed:	180.000	&	65.000	mm/min
	ELEGOO SATURN 2	Waiting Mode During Printing:	Restin 🔻)	Retract Speed:	180.000	&	65.000	mm/min
20 Pering Rean for Fabrication of Crown & Bridge		Rest Time Before Lift:	0.000	s					
NOTE:		Rest Time After Lift:	0.000	s					
		Rest Time After Retract:	0.500	s					



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• Follow the settings of Prevest C&B Permanent.

		Prevest C&B Permanent							DC
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra								
	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000	+	4.000	mm
ELEGOD	ELECCO Mars 4 Ultra	Bottom Layer Count:	5		Lifting Distance:	3.000	+	4.000	mm
	ELEGOO Mais 4 Oltra	Exposure Time:	5.000	s	Bottom Retract Distance:	5,500) +	1.500	mm
-	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	5.500	+	1.500	mm
	Phrozen Sonic Mini 8K	Transition Layer Count:	8		Bottom Lift Speed:	65.000	8	180.000	mm/mi
	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻		Lifting Speed:	65.000	8	180.000	mm/mi
≈ contraction	UniFormation GKtwo	Transition Time Decrement:	5.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/mi
ር ନ୍ନB	ELEGOO SATURN 2	Waiting Mode During Printing:	Restin 🔻		Retract Speed:	180.000	&	65.000	mm/mi
20 Pirting Rest		Post Time Refore Lift:	0.000	c					

• Follow the settings of Prevest C&B Interim.

	Settings								×	<
		Prevest C&B Interim								5
	Default	Machine	Resin		Print	Gcode			Advanced	
	AnyCubic Photon Ultra								2	
4775	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000	+	4.000	mm	
	ELEGOO Mars 4 Ultra	Bottom Layer Count:	5)	Lifting Distance:	3.000] +	4.000	mm	
ELEGOD	ELEGOO Mars 4 Oltra	Exposure Time:	5.000	s	Bottom Retract Distance:	5.500] +	1.500	mm	
	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	5.500) +	1.500	mm	
	Phrozen Sonic Mini 8K	Transition Layer Count:	8)	Bottom Lift Speed:	65.000	8	180.000	mm/min	
	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻		Lifting Speed:	65.000	8	180.000	mm/min	
	UniFormation GKtwo	Transition Time Decrement:	5.000	s	Bottom Retract Speed:	180.000	8	65.000	mm/min	
	ELEGOO SATURN 2	Waiting Mode During Printing:	Restin •)	Retract Speed:	180.000	8	65.000	mm/min	
C&B		Rest Time Before Lift:	0.000	s						
3D Printing Resin for Polarization of Crivers B Risidge		Rest Time After Lift:	0.000	s						
1000 J		Rest Time After Retract:	0.500	s						



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

		Prevest Model Pro						
	Default	Machine	Resin	Print	Gcode			Advanced
	AnyCubic Photon Ultra							1
The second se	AnyCubic Photon X	Layer Height:	0.050 mm	Bottom Lift Distance:	1.500	+	4.500	mm
	FLECOO Mars 4 Ultra	Bottom Layer Count:	6	Lifting Distance:	1.500) +	4.500	mm
A REAL PROPERTY AND A REAL	ELEGOO Mars 4 Oltra	Exposure Time:	5.000 s	Bottom Retract Distance:	4.500) +	1.500	mm
a And a Some X Tarr	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000 s	Retract Distance:	4.500) +	1.500	mm
IN CON HOND AN	Phrozen Sonic Mini 8K	Transition Layer Count:	0	Bottom Lift Speed:	120.000	8	240.000	mm/mir
	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻	Lifting Speed:	120.000	8	120.000	mm/min
	UniFormation GKtwo	Light-off Delay:	0.500 s	Bottom Retract Speed:	180.000	8	360.000] mm/min
2 PREVENT Develop	ELEGOO SATURN 2			Retract Speed:	180.000	8	180.000	mm/min
	Phrozen Sonic Mini 4K UniFormation GKtwo	Transition Type: Light-off Delay:	Linear ▼ 0.500 S	Lifting Speed: Bottom Retract Speed: Retract Speed:	120.000 180.000) &) & &	120.000 360.000 180.000) mm

• Follow the settings of Prevest Model.



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• Follow the settings of Prevest Surgical Guide.

• Follow the settings of Prevest Denture.

		Prevest Denture							DCC
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra								_
	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	1.500	+	4.500	mm
те Сре ново на		Bottom Layer Count:	6)	Lifting Distance:	1.500) +	4.500	mm
	ELEGOO Mars 4 Ultra	Exposure Time:	5.000	s	Bottom Retract Distance:	4.500	+	1.500	mm
	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	4.500	+	1.500	mm
PLPREVESTOR-Put to Aurule de Santanie	Phrozen Sonic Mini 8K	Transition Layer Count:	0	Ĵ	Bottom Lift Speed:	120.000	&	240.000	mm/min
DENTURE 3D Printing Reset for DENTURE BASE	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻		Lifting Speed:	120.000	&	120.000	mm/min
	UniFormation GKtwo	Light-off Delay:	0.500	s	Bottom Retract Speed:	180.000	&	360.000	mm/min
	FLEGOO SATURN 2				Retract Speed:	180.000	&	180.000	mm/min

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• Follow the settings of Prevest Burn Out.

		Therese barn out							
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra								
	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	1.500	+	4.500	mm
	ELEGOO Mars 4 Ultra	Bottom Layer Count:	6	ļ	Lifting Distance:	1.500	+	4.500	mm
R ree D Seren		Exposure Time:	5.000	s	Bottom Retract Distance:	4.500] +	1.500	mm
ри ноно ни	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	4.500) +	1.500	mm
	Phrozen Sonic Mini 8K	Transition Layer Count:	0)	Bottom Lift Speed:	120.000	8	240.000	mm/mii
	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻		Lifting Speed:	120.000	8	120.000	mm/mir
(BATDan Fro [®]	UniFormation GKtwo	Light-off Delay:	0.500	s	Bottom Retract Speed:	180.000	8	360.000	mm/mir
	ELEGOO SATURN 2				Retract Speed:	180.000	8	180.000	mm/mir
IRN OUT	AnyCubic P. on Mono 4K								
Providence Assessed	any constant and an and and								

• Follow the settings of Prevest C&B Ceramic.

PREVEST//3D

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• Follow the settings of Prevest C&B Permanent.

	E 🔟	Prevest C&B Permanent				1			DC
	Default	Machine	Resin		Print	Gcode			Advanced
	AnyCubic Photon Ultra						_		-
	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	1.500	+	4.500	mm
	ELEGOO Mars 4 Ultra	Bottom Layer Count:	6)	Lifting Distance:	1.500] +	4.500	mm
	ELEGOO Mars 4 Oltra	Exposure Time:	5.000	s	Bottom Retract Distance:	4.500) +	1.500	mm
Эри номо-ин	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	4.500) +	1.500	mm
	Phrozen Sonic Mini 8K	Transition Layer Count:	0)	Bottom Lift Speed:	120.000	8	240.000	mm/mi
	Phrozen Sonic Mini 4K	Transition Type:	Linear 🔻		Lifting Speed:	120.000	8	120.000	mm/mi
ST Gentlan"	UniFormation GKtwo	Light-off Delay:	0.500	s	Bottom Retract Speed:	180.000	8	360.000	mm/mi
βB	ELEGOO SATURN 2				Retract Speed:	180.000	8	180.000	mm/mi
a A Bridge	AnyCubic Pon Mono 4K								

• Follow the settings of Prevest C&B Interim.

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Any cubic Photon Mono SE (0.05 – 0.1 $\mu)$

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

		Prevest Model Pro				1	t C C	
: ::	Default	Machine	Resin		Print	Gcode	Ad	dvanced
	AnyCubic Photon Ultra							-
	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift	Distance:	6.000	mm
		Bottom Layer Count:	6		Lifting Distar	nce:	6.000	mm
ANYCUBIC	ELEGOO Mars 4 Ultra	Exposure Time:	5.000	s	Bottom Retra	act Distance:	6.000	mm
	ELEGOO SATURN 8K	Bottom Exposure Time	: 50.000	s	Retract Dista	nce:	6.000	mm
	Phrozen Sonic Mini 8K	Transition Layer Count	: 0	5	Bottom Lift	Speed:	240.000	mm/min
	Phrozen Sonic Mini 4K	Transition Type:	Linear	•	Lifting Speed	d:	240.000	mm/min
	UniFormation GKtwo	Light-off Delay:	0.500	s	Bottom Retra	act Speed:	360.000	mm/min
	ELEGOO SATURN 2				Retract Spee	d:	360.000	mm/min
PREVESTORYPO	AnyCubic Pon Mono 4K							
MODEL	AnyCubic P. on Mono SE							

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

	Prevest Model			•] 🕒 💉 🖞	J C E	
Default	Machine	Resin		Print	Gcode	Ad	dvanced
AnyCubic Photon Ultra							1
AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift D	istance:	6.000	mm
FILTEOR Mary Author	Bottom Layer Count:	6		Lifting Distan	ce:	6.000	mm
ELEGOO Mars 4 Ultra	Exposure Time:	3.000	s	Bottom Retra	ct Distance:	6.000	mm
ELEGOO SATURN 8K	Bottom Exposure Tim	e: 30.0	s	Retract Distar	nce:	6.000	mm
Phrozen Sonic Mini 8K	Transition Layer Coun	nt: 0		Bottom Lift S	peed:	240.000	mm/min
Phrozen Sonic Mini 4K	Transition Type:	Linear	•	Lifting Speed	:	240.000	mm/min
UniFormation GKtwo	Light-off Delay:	0.500	s	Bottom Retra	ct Speed:	360.000	mm/min
ELEGOO SATURN 2				Retract Speed	d:	360.000	mm/min

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• Follow the settings of Prevest Surgical Guide.

	Settings							×
		Prevest Surgical Guide			•		e c	
	Default	Machine	Resin		Print	Gcode	Ad	lvanced
	AnyCubic Photon Ultra			_				
ANYCUBIC	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift D	Distance:	6.000	mm
	ELEGOO Mars 4 Ultra	Bottom Layer Count:	6		Lifting Distan	ice:	6.000	mm
		Exposure Time:	5.000	s	Bottom Retra	act Distance:	6.000	mm
	ELEGOO SATURN 8K	Bottom Exposure Tim	ne: 50.0	s	Retract Dista	nce:	6.000	mm
	Phrozen Sonic Mini 8K	Transition Layer Cour	nt: 0		Bottom Lift S	peed:	240.000	mm/min
REPERTED	Phrozen Sonic Mini 4K	Transition Type:	Linear 🗨	•	Lifting Speed	:	240.000	mm/min
SURGICAL GUIDE	UniFormation GKtwo	Light-off Delay:	0.500	s	Bottom Retra	act Speed:	360.000	mm/min
CC Proteg Rean for Factoriation of Surgical Guide	ELEGOO SATURN 2				Retract Speed	d:	360.000	mm/min
10009	AnyCubic Pon Mono 4K							
	AnyCubic Pon Mono SE							

• Follow the settings of Prevest Denture.

PREVEST//3D

• Follow the settings of Prevest Burn Out.

	Settings								×
		Prevest Burn Out						00	00
	Default	Machine	Resin			Print	Gcode	Ad	vanced
	AnyCubic Photon Ultra		~		\ \				×
ANYCUBIC	AnyCubic Photon X	Layer Height:		0.050	mm	Bottom Lift	Distance:	6.000	mm
	FLEGOO Mars 4 Ultra	Bottom Layer Count:		6	ļ	Lifting Dista	nce:	6.000	mm
		Exposure Time:		5.000	s	Bottom Reti	act Distance:	6.000	mm
	ELEGOO SATURN 8K	Bottom Exposure Tim	e:	50.000	s	Retract Dista	ance:	6.000	mm
	Phrozen Sonic Mini 8K	Transition Layer Coun	it:	0)	Bottom Lift	Speed:	240.000	mm/min
REPORT Lawrent	Phrozen Sonic Mini 4K	Transition Type:		Linear 🔻		Lifting Spee	d:	240.000	mm/min
	UniFormation GKtwo	Light-off Delay:		0.500	s	Bottom Retr	act Speed:	360.000	mm/min
SC Protog Rears for DENTAL CABITMO	ELEGOO SATURN 2					Retract Spee	ed:	360.000	mm/min
song	AnyCubic Pon Mono 4K								
	AnyCubic Pon Mono SE								

• Follow the settings of Prevest C&B Ceramic.

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• Follow the settings of Prevest C&B Permanent.

	Prevest C&B Permanent			▼) 🗄) 💉 🗇	00	
Default	Machine	Resin	F	Print	Gcode	Ac	dvanced
AnyCubic Photon Ultra							_
AnvCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distan	ice:	6.000	mm
	Bottom Layer Count:	6)	Lifting Distance:		6.000	mm
ELEGOO Mars 4 Ultra	Exposure Time:	5.000	s	Bottom Retract Di	stance:	6.000	mm
ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:		6.000	mm
Phrozen Sonic Mini 8K	Transition Layer Count:	0)	Bottom Lift Speed	:	240.000	mm/mir
Phrozen Sonic Mini 4K	Transition Type:	Linear 💌)	Lifting Speed:		240.000	mm/min
UniFormation GKtwo	Light-off Delay:	0.500	s	Bottom Retract Sp	eed:	360.000] mm/mir
FLEGOO SATURN 2				Retract Speed:		360.000	mm/min

• Follow the settings of Prevest C&B Interim.

	Settings								×
1910700	 	Prevest C&B Interim						t 0 2	
	Default	Machine	Resin			Print	Gcode	Ac	lvanced
in the second	AnyCubic Photon Ultra								2
	AnyCubic Photon X	Layer Height:		0.050	mm	Bottom Lift	Distance:	6.000	mm
ANTCOBIC	ELEGOO Mars 4 Ultra	Bottom Layer Count:		6	J	Lifting Dista	ance:	6.000	mm
		Exposure Time:		5.000	s	Bottom Ret	tract Distance:	6.000	mm
	ELEGOO SATURIN 8K	Bottom Exposure Time:	: [50.000	s	Retract Dist	tance:	6.000	mm
	Phrozen Sonic Mini 8K	Transition Layer Count:	: [0	J	Bottom Lift	Speed:	240.000	mm/min
	Phrozen Sonic Mini 4K	Transition Type:		Linear V	ļ	Lifting Spee	ed:	240.000	mm/min
C&B 32 Process Process	UniFormation GKtwo	Light-off Delay:	ļ	0.500	s	Bottom Ret	tract Speed:	360.000	mm/min
Consume A finishing Consume A finishing Consume A finishing Consumeration	ELEGOO SATURN 2					Retract Spe	ed:	360.000	mm/min
	AnyCubic Pon Mono 4K								
	AnyCubic Pon Mono SE								

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

	Settings						×
		Prevest Model Pro				CD	
	Default	Machine	Resin		Print	Advar	nced
	AnyCubic Photon Ultra		122				
a de la calendaria de la c	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	6.000	mm
PHODA F	ELEGOO Mars 4 Ultra	Bottom Layer Count:	6)	Lifting Distance:	6.000	mm
Time 1	ELEGOO Mars 4 Oltra	Exposure Time:	5.000	s	Bottom Retract Distance:	6.000	mm
	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	6.000	mm
	Phrozen Sonic Mini 8K	Light-off Delay:	1.000	s	Bottom Lift Speed:	180.000] mm/min
	Phrozen Sonic Mini 4K				Lifting Speed:	180.000] mm/min
	UniFormation GKtwo				Bottom Retract Speed:	180.000	mm/min
	ELEGOO SATURN 2				Retract Speed:	180.000] mm/min
REVESTORING®	AnyCubic Pon Mono 4K						
MODEL	AnyCubic Pon Mono SE						
3D Portop Peeso bor Pair Coulour of Thereresolution Medden	AnyCubic Photon S						

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

(■) (■)	Prevest Model			🔻 💽 🛃	t C E	
Default	Machine	Resin		Print	Adva	nced
AnyCubic Photon Ultra						
AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	6.000	mm
	Bottom Layer Count:	6]	Lifting Distance:	6.000	mm
ELEGOO Mars 4 Ultra	Exposure Time:	3.000	s	Bottom Retract Distance:	6.000	mm
ELEGOO SATURN 8K	Bottom Exposure Time:	30.0	s	Retract Distance:	6.000	mm
Phrozen Sonic Mini 8K	Light-off Delay:	1.000	s	Bottom Lift Speed:	180.000	
Phrozen Sonic Mini 4K				Lifting Speed:	180.000	mm/mir
UniFormation GKtwo				Bottom Retract Speed:	180.000	mm/mir
ELEGOO SATURN 2				Retract Speed:	180.000	mm/mir
AnyCubic Pon Mono 4K						
AnyCubic Pon Mono SE						
AnyCubic Photon S						

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

	Settings						×
		Prevest Surgical Guide	545 - 444		▼ ₽ ⊘ 1	5 C	00
	Default	Machine	Resin		Print	Advar	nced
President and a second and a se	AnyCubic Photon Ultra	Laver Height	0.050		Pottom Lift Distance:	6.000	
	AnyCubic Photon X	Layer Height.	0.050		Lifting Distance.	0.000	
	ELEGOO Mars 4 Ultra	Bottom Layer Count:	6	1	Lifting Distance:	6.000	j mm
	FLEGOO SATURN 8K	Exposure Time:	5.000	s	Bottom Retract Distance:	6.000	mm
		Bottom Exposure Time:	50.0	s	Retract Distance:	6.000	mm
	Phrozen Sonic Mini 8K	Light-off Delay:	1.000	s	Bottom Lift Speed:	180.000	mm/min
	Phrozen Sonic Mini 4K				Lifting Speed:	180.000	mm/min
SURGICAL	UniFormation GKtwo				Bottom Retract Speed:	180.000	mm/min
SD Protong Rean by Francisco Control Stangene Control	ELEGOO SATURN 2				Retract Speed:	180.000	mm/min
100fg	AnyCubic Pon Mono 4K						
	AnyCubic Pon Mono SE						
	AnyCubic Photon S						

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

	Settings						×
		Prevest Denture				I C E	
	Default	Machine	Resin		Print	Adva	nced
	AnyCubic Photon Ultra			_			_
PHODA F	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	6.000	mm
and		Bottom Layer Count:	6		Lifting Distance:	6.000	mm
	ELEGOO Mars 4 Ultra	Exposure Time:	5.000	s	Bottom Retract Distance:	6.000	mm
	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	6.000	mm
	Phrozen Sonic Mini 8K	Light-off Delay:	1.000	s	Bottom Lift Speed:	180.000	mm/min
Revestore of surger	Phrozen Sonic Mini 4K				Lifting Speed:	180.000	mm/min
DENTURE	UniFormation GKtwo				Bottom Retract Speed:	180.000	mm/min
SD Prinsing Reservice DENTLIFIE BASE	ELEGOO SATURN 2				Retract Speed:	180.000	mm/min
10000	AnyCubic Pon Mono 4K						
	AnyCubic Pon Mono SE						
	AnvCubic Photon S						

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

		Prevest Burn Out			🕒 💉 t	t C D	
	Default	Machine	Resin		Print	Adva	nced
Bart and a second s	AnyCubic Photon Ultra			2			-
-	AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	6.000	mm
	FLECOO Mars 4 Ultra	Bottom Layer Count:	6]	Lifting Distance:	6.000	mm
	ELEGOO Mars 4 Oltra	Exposure Time:	5.000	s	Bottom Retract Distance:	6.000	mm
	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	6.000	mm
	Phrozen Sonic Mini 8K	Light-off Delay:	1.000	s	Bottom Lift Speed:	180.000	mm/min
	Phrozen Sonic Mini 4K				Lifting Speed:	180.000	mm/min
	UniFormation GKtwo				Bottom Retract Speed:	180.000	mm/min
	ELEGOO SATURN 2				Retract Speed:	180.000	mm/min
	AnyCubic Pon Mono 4K						
	AnyCubic Pon Mono SE						

• Follow the settings of Prevest C&B Ceramic.

(+	団	Prevest C&B Ceramic			🕒 💉 t	I C E	
	Default	Machine	Resin		Print	Adva	nced
AnyCul	pic Photon Ultra		<u></u>	_			~
AnyC	ubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	6.000	mm
FLEGO	O Mars A Ultra	Bottom Layer Count:	6		Lifting Distance:	6.000	mm
ELEGO		Exposure Time:	5.000	s	Bottom Retract Distance:	6.000	mm
ELEGO	OO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	6.000	mm
Phroze	n Sonic Mini 8K	Light-off Delay:	1.000	s	Bottom Lift Speed:	180.000	mm/n
Phroze	n Sonic Mini 4K				Lifting Speed:	180.000	mm/n
UniFo	rmation GKtwo				Bottom Retract Speed:	180.000	mm/n
ELEG	DO SATURN 2				Retract Speed:	180.000] mm/m
AnyCubi	c Pon Mono 4K						
AnvCubi	c Pon Mono SE						

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• Follow the settings of Prevest C&B Permanent.

	Prevest C&B Permanent			🕒 🌶 🚺	t C Z	
Default	Machine	Resin		Print	Adva	nced
AnyCubic Photon Ult	1		_			2
AnyCubic Photon X	Layer Height:	0.050	mm	Bottom Lift Distance:	6.000	mm
FLECOO Mars 4 Ultr	Bottom Layer Count:	6		Lifting Distance:	6.000	mm
ELEGOO Mars 4 Ultr	Exposure Time:	5.000	s	Bottom Retract Distance:	6.000	mm
ELEGOO SATURN 8	Bottom Exposure Time:	50.000	s	Retract Distance:	6.000	mm
Phrozen Sonic Mini 8	Light-off Delay:	1.000	s	Bottom Lift Speed:	180.000	mm/min
Phrozen Sonic Mini 4				Lifting Speed:	180.000	mm/min
UniFormation GKtw				Bottom Retract Speed:	180.000	mm/min
ELEGOO SATURN 2				Retract Speed:	180.000	mm/min
AnyCubic Pon Mono	łK					
AnyCubic Pon Mono	SE					
AnyCubic Photon S						

• Follow the settings of Prevest C&B Interim.

	Settings						×	
		Prevest C&B Interim	12/ 3					
	Default	Machine	Resin		Print	Advar	nced	
PHONE +	AnyCubic Photon Ultra	Laver Height:	0.050	mm	Bottom Lift Distance:	6.000	mm	
	AnyCubic Photon X	Bottom Laver Count:	6		Lifting Distance:	6.000	mm	
	ELEGOO Mars 4 Ultra	Exposure Time:	5.000	s	Bottom Retract Distance:	6.000	mm	
	ELEGOO SATURN 8K	Bottom Exposure Time:	50.000	s	Retract Distance:	6.000	mm	
	Phrozen Sonic Mini 8K	Light-off Delay:	1.000	s	Bottom Lift Speed:	180.000		
PREVENTIONS In Statements	Phrozen Sonic Mini 4K				Lifting Speed:	180.000	mm/min	
С&В	UniFormation GKtwo				Bottom Retract Speed:	180.000	mm/min	
30 Printing Pean for Polinication of Crews & Brings	ELEGOO SATURN 2				Retract Speed:	180.000	mm/min	
1000	AnyCubic Pon Mono 4K							
	AnyCubic Pon Mono SE							
	AnyCubic Photon S							

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PREVEST//3D

Issue No. 01 Revision No. 01 Effective Date. 03/04/2024

Any cubic Photon Mono M5s $(0.05 - 0.1 \mu)$

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

	Prevest C&B Ceramic								
nyCubic Photon Ultra	Machine	Resin	Resin Print				Advanced		
AnyCubic Photon X	Laver Height:	0.050	mm	Bottom Lift Distance:	10.000	+	0.000	mm	
LEGOO Mars 4 Ultra	Bottom Layer Count:	5		Lifting Distance:	5.000) +	0.000	mm	
LEGOO SATURN 8K	Exposure Time:	10.000	s	Bottom Retract Distance:	10.000	+	0.000	mm	
hrozen Sonic Mini 8K	Bottom Exposure Time:	100.000	s	Retract Distance:	5.000) +	0.000	mm	
nrozen Sonic Mini 4K	Transition Layer Count:	0		Bottom Lift Speed:	360.000	8	0.000	mm/min	
LEGOO SATURN 2	Transition Type:	Linear v		Lifting Speed:	360.000	8	0.000	mm/min	
Cubia D. an Mana 4K	Waiting Mode During Printing:	Light 🔻		Bottom Retract Speed:	360.000	8	0.000	mm/min	
Cubic Pon Mono 4K	Light-off Delay:	0.500	s	Retract Speed:	360.000	8	0.000	mm/min	
Cubic Pon Mono SE	Bottom Light-off Delay:	5.000	s						
AnyCubic Photon S									
UniFormation GKtwo									

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Phrozen Sonic Mini 8K s ($0.05 - 0.1 \mu$)

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

Settings

E 🔟	Prevest C&B Ceramic							
ELEGOO Mars 4 Ultra	Machine	R		Advanced				
ELEGOO SATURN 8K	Layer Height:	0.050	mm	Bottom Lift Distance:	3.000	+	4.000	mm
Phrozen Sonic Mini 8K	Bottom Layer Count:	6	ĵ	Lifting Distance:	3.000) +	4.000	mm
Phrozen Sonic Mini 4K	Exposure Time:	5.000	s	Bottom Retract Distance:	5.000) +	2.000	mm
ELEGOO SATURN 2	Bottom Exposure Time:	50.0) s	Retract Distance:	5.000) +	2.000	mm
nyCubic Pon Mono 4K	Transition Layer Count:	6)	Bottom Lift Speed:	40.000	&	120.000	mm/min
nyCubic P on Mono SE	Transition Type:	Linear 🔻)	Lifting Speed:	40.000	&	120.000) mm/min
	Transition Time Decrement:	6.430	s	Bottom Retract Speed:	180.000	8	90.000] mm/min
AnyCubic Photon S	Waiting Mode During Printing:	Restin T		Retract Speed:	180.000	8	90.000	mm/min
AnyCubic Mono M5s	Rest Time Before Lift:	0.000	s			/		
myCubic P Mono X 6K	Rest Time After Lift:	0.000	s					
UniFormation GKtwo	Rest Time After Retract:	4.000	s					

Phrozen Sonic Mini 8K S

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Issue No.

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01 01 Revision No. Effective Date. 03/04/2024

Elegoo Mars 5 Ultra (0.05 – 0.1 μ)

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

Resin					Advance				
Resin Type	C&B				Bottom Light PWM	255			
Resin Name	Prevest C&B Cera	imic							
Resin Color					Light PWM	255			
Resin Density	1.100 🗘 g/ml				Picture Grayscale	255			
Resin Cost	29.990 🗘	\$ - /	Kg		Anti altarian				2
					Anti-aliasing		None		
Print					weeks were stress				
Layer Height		0.050		mm	Shrinkage Compensat	tion			
Bottom Layer Count									
Exposure Time		5.000			Tolerance Compensation	ion			
Bottom Exposure Time		50.000							
					[]				
Transition Layer Count					la la			0.200	mm
Transition Type		Linear					b -	0.100	mm
Transition Layer Interval 1	Time Difference								
Waiting Mode During Pri	nting	Resting time			Bottom Tolerance Cor	npensatio			
Rest Time Before Release		0.000							
Rest Time After Release		0.000			Print Time Compensation	tion			
Rest Time After Retract		0.500							

www.prevest3d.com **Printer Settings**

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Elegoo Mars 5 Ultra (0.05 – 0.1 μ)

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

Resin						Advance				
Resin Type	С	&B				Bottom Light PWM	255			
Resin Name	Prevest C&	.B Perma	nent			,		•		
Resin Color						Light PWM	255			
Resin Density	nsity 1.100 🗘 g/ml						255			
Resin Cost	29.990 🗘	\$		Kg	Ŧ					
						Anti-aliasing		None		
Print										
Layer Height			0.050		mm	Shrinkage Compensation	n			
Bottom Layer Count										
Exposure Time			5.000		s					
Bottom Exposure Time			50.000		s	Tolerance Compensation				
Transition Layer Count				¢		Bottom Tolerance Comm	ensation			
Transition Type			Linear				ensation			
Transition Layer Interval T	Time Difference				s	·1				
							a	-0	.200 🗘	mm
Waiting Mode During Pri	nting		Resting time				ŀ	-0	100	mm
Rest Time Before Release			0.000		s					
Rest Time After Release			0.000		s					
Rest Time After Retract			0.500		s	Print Time Compensatio	n			

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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 Type Denture Resin Name Prevest Denture Resin Color Light PWM Resin Color Light PWM Resin Color None Resin Cost 29.990 29.990 \$ / Kg Print 0.050 Layer Height 0.050 Bottom Layer Count 5 5.000 \$ Transition Layer Count 5 Transition Layer Interval Time Difference 7:50 You Linear a Waiting Mode During Printing Resting time Rest Time After Release 0.000 Setter Time After Release 0.000	Resin					Advance				
Resin Name Prevest Denture Resin Color Resin Density 1.100 g/ml Resin Cost 29.990 29.990 29.990 29.990 29.990 29.990 20.50 Resin Cost 29.990 29.990 20.50 Resin Cost 29.990 20.50 Resin Cost 29.990 20.50 Resin Cost 29.990 20.50 Resin Cost 29.990 20.50 Resin Resin Resin Resing time Rest Time After Release 0.000 set Time After Release	Resin Type	Denture				Bottom Light PWM	255	▲ ▼		
Resin Color Resin Color Resin Cost 29,990 \$ \$ / Kg Print Layer Height Layer Height Layer Count Exposure Time Sottom Layer Count Transition	Resin Name	Prevest Denture		G						
Resin Density 1.100 g/ml Picture Grayscale 255 Anti-Anti-Anti-Anti-Anti-Anti-Anti-Anti-	Resin Color					Light PWM	255			
Resin Cost 29.990 \$ • / Kg • Print Layer Height Bottom Layer Count Source Time Bottom Exposure Time Source Time Bottom Exposure Time Transition Layer Count Transition Layer Interval Time Difference 7.50 Set Time Before Release 0.000 s Rest Time After Release 0.000 s Print Time Compensation	Resin Density	1.100 🗘 g/ml				Picture Grayscale	255			
Print Layer Height Layer Count 5 Exposure Time 50.000 stotom Exposure Time 50.000 stotom Exposure Time 50.000 stotom Exposure Time 50.000 stotom Exposure Time 1 Transition Layer Count 5 Transition Layer Count 5 Transition Layer Count 5 Transition Layer Count 5 7:ansition Layer Interval Time Difference 7:50 stitime Before Release 0.000 stitime After Release 0.000 stitime After Release	Resin Cost	29.990 🗘 😫		Kg	.					
Print 0.050 ° mm Image: Subscription in the s						Anti-aliasing		None		
Layer Height 0.050 mm Bottom Layer Count 5 Exposure Time 5.000 Sottom Exposure Time 50.000 Sottom Exposure Time 50.000 Transition Layer Count 5 Transition Layer Count 5 Transition Layer Count 5 Transition Layer Count 5 Transition Layer Interval Time Difference 7.50 Set Time Before Release 0.000 set Time After Release 0.000 Print Time Compensation	Print									
Bottom Layer Count 5 Exposure Time 5.000 Bottom Exposure Time 50.000 Soloo s Transition Layer Count Transition Type Linear Transition Layer Interval Time Difference 7.50 Rest Time Before Release 0.000 Rest Time After Release 0.000 Print Time Compensation	Layer Height		0.050		mm	Shrinkage Compensat	tion			
Exposure Time 5.000 s Bottom Exposure Time 50.000 s Transition Layer Count 5 f Transition Type Linear Transition Layer Interval Time Difference 7.50 7.50 s Waiting Mode During Printing Resting time Rest Time Before Release 0.000 Set Time After Release 0.000	Bottom Layer Count									
Bottom Exposure Time 50.000 s Transition Layer Count 5 Transition Type Linear Transition Layer Interval Time Difference 7.50 Vaiting Mode During Printing Resting time Rest Time Before Release 0.000 s 0.000 s Print Time Compensation	Exposure Time		5.000	Ĵ s	5	Tolerance Compensat	ion			
Transition Layer Count 5 Transition Type Linear Transition Layer Interval Time Difference 7.50 Waiting Mode During Printing Resting time Rest Time Before Release 0.000 s 0.000 s 0.000 s 0.000	Bottom Exposure Time		50.000	С, s	5	_ ·				
Transition Layer Count 5 Transition Type Linear Transition Layer Interval Time Difference 7.50 Waiting Mode During Printing Resting time Rest Time Before Release 0.000 Rest Time After Release 0.000						Pottom Tolerance Co.				
Linear Linear Transition Layer Interval Time Difference 7.50 s Waiting Mode During Printing Resting time a Rest Time Before Release 0.000 s Rest Time After Release 0.000 s	Transition Layer Count						npensation			
Transition Layer Interval Time Difference 7.50 s Waiting Mode During Printing Resting time imm Rest Time Before Release 0.000 s Rest Time After Release 0.000 s	Transition Type		Linear			F				
Waiting Mode During Printing Resting time Rest Time Before Release 0.000 S Rest Time After Release 0.000 S Print Time Compensation	Transition Layer Interval 1	Time Difference		¢ s	5		i	a -0.	200	mm
Waiting Mode During Printing Resting time • b -0.100 mm Rest Time Before Release 0.000 s •<						a (↔) ↔				
Rest Time Before Release 0.000 s ii Rest Time After Release 0.000 s Print Time Compensation	Waiting Mode During Pri	nting	Resting time				ł	o -0.	100	mm
Rest Time After Release 0.000 s	Rest Time Before Release		0.000	¢ s	5	i/				
	Rest Time After Release		0.000	÷ s	5	Print Time Compensa	tion			
Rest Time After Retract 0.500 🗘 s	Rest Time After Retract		0.500	¢ s	5					