



KEYMODEL ULTRA™

Phrozen Sonic Mini 4k Printer Instructions

*These settings only apply to
Chitobox V1.9.1 or higher



KeyModel Ultra™

PRINTER SETTINGS

PRINTER SETTINGS	KeyModel Ultra™
Machine Size Scaling	X: 133.25 Y: 74.9531
Layer Height	0.1
Bottom Layer Count	6
Transition Layer Count	8
Exposure Time	5
Bottom Exposure Time	60
Light Off Delay*	2
Bottom Light Off Delay*	2
Bottom Lift Distance	5
Lifting Distance	5
Bottom Lift Speed	250
Lifting Speed	60-80
Retract Speed	150