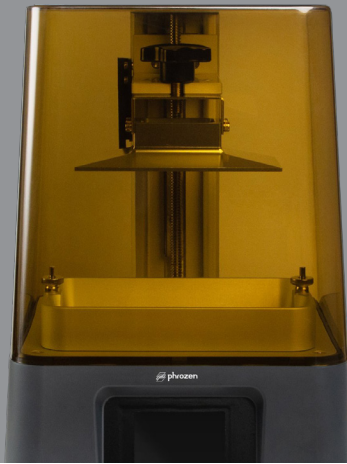




KEYCAST®

# Phrozen Sonic Mini 4k Printer Instructions

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

## PRINTER SETTINGS



KeyCast®

|                         |                      |
|-------------------------|----------------------|
| Machine Size Scaling    | X: 131.767 Y: 73.750 |
| Layer Height            | 0.05                 |
| Bottom Layer Count      | 10                   |
| Transition Layer Count  | 10                   |
| Exposure Time           | 10                   |
| Bottom Exposure Time    | 42                   |
| Light Off Delay*        | 2                    |
| Bottom Light Off Delay* | 1.5                  |
| Bottom Lift Distance    | 6                    |
| Lifting Distance        | 5                    |
| Bottom Lift Speed       | 150                  |
| Lifting Speed           | 100                  |
| Bottom Retract Speed    | 150                  |
| Retract Speed           | 150                  |