



KEYMODEL ULTRA™

Phrozen Sonic XL 4k Printer Instructions



KeyModel Ultra™ Ivory 100µm

PRINTER SETTINGS

Thickness (mm)	0.1
Down Speed	Not to exceed 250
Delay (ms)	1-2 seconds
Burn in Layers	6
Burn in Exposure	37000
Burn in Height	8-10
Burn in Up Speed	400
Normal Exposure	4750
Normal Height	7-10
Normal Up Speed	60-80