



KEYSPLINT HARD® CLEAR

Ancubic Photon Mono M5 Printer Instructions



PRINTER SETTINGS	KeySplint Hard®Clear
Shrinkage Compensation	X:100.999%, Y:101.111%, Z:100.00%
Layer Height	0.1
Bottom Layer Count	5
Exposure Time	17.45
Bottom Exposure Time	28
Transition Layer Count	10
Transition Layer Type	Linear
Rest Time Before Lift	0
Rest Time After Lift	10
Rest Time After Retract	2
Bottom Lift Distance	15
Lifting Distance	15
Bottom Lift Speed	200
Lifting Speed	200
Bottom Speed Retract	150
Retract Speed	150