


KEYSPLINT HARD®

Anycubic Photon Mono M5 Printer Instructions

| PRINTER SETTINGS |  KeySplint Hard® |
|-------------------------|---|
| Shrinkage Compensation | X:100.999%, Y:101.111%, Z:100.00% |
| Layer Height | 0.1 |
| Bottom Layer Count | 5 |
| Exposure Time | 15.25 |
| Bottom Exposure Time | 20 |
| Transition Layer Count | 10 |
| Transition Layer Type | Linear |
| Rest Time Before Lift | 0 |
| Rest Time After Lift | 6 |
| Rest Time After Retract | 4 |
| Bottom Lift Distance | 15 |
| Lifting Distance | 8 |
| Bottom Lift Speed | 100 |
| Lifting Speed | 100 |
| Bottom Speed Retract | 150 |
| Retract Speed | 150 |