


KEYSPLINT SOFT® CLEAR

Anycubic Photon Mono M5 Printer Instructions

PRINTER SETTINGS	 KeySplint Soft® Clear
Shrinkage Compensation	X:100.999%, Y:101.111%, Z:100.00%
Layer Height	0.1
Bottom Layer Count	5
Exposure Time	13
Bottom Exposure Time	27
Transition Layer Count	5
Transition Layer Type	Linear
Rest Time Before Lift	0
Rest Time After Lift	7
Rest Time After Retract	1
Bottom Lift Distance	Slow Lift: 2, Fast Lift: 8
Lifting Distance	Slow Lift: 3, Fast Lift: 7
Bottom Lift Speed	Slow Lift: 100, Fast Lift: 110
Lifting Speed	Slow Lift: 100, Fast Lift: 110
Bottom Speed Retract	Slow Lift: 130, Fast Lift: 130
Retract Speed	Slow Lift: 130, Fast Lift: 130