



Phrozen - Sonic mini 4K

3D Printing Workflow: Ultracur3D® ST 7500 G

Technology: LCD

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	1,5	9

WASH CYCLE 1

WASH CYCLE 2

Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D® Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30 Temperature (°C) 40

POST CURING

Model	Phrozen Cure
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	90
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.