



# 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	Dymax ECE 2000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	10
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.