

Phrozen - Sonic mini 8K

3D Printing Workflow: Ultracur3D® DM 4505 N

Technology: LCD

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	1.8	8

WASH CYCLE 1

WASH CYCLE 2

Agitation Method	Rotor / Propeller	Rotor / Propeller
Cleaner	Ethanol	Ethanol
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	60
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.