

Phrozen - Sonic mini 8K

3D Printing Workflow: Ultracur3D® RG 9400 B FR

Technology: LCD

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm ²)	Exposure Time (s)
100	1,75	8

	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	60
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	1
Holding Temp. (°C)	150
Holding Time (h)	3
Ramp down (°C / min)	1