

PRACTICAL PRINTING

A handy cheat sheet for 3D printing resin

USEFUL PRINT TESTS

1) VALIDATION MATRIX

Use this to find the perfect layer exposure time for your printer/resin combination.

Do this test

- ▶ When you first get a your 3D Printer
- ▶ Every time you use different or mix resins
- ▶ Every time you change layer height
- ▶ Every 6 months



The same amount of Pins & Voids

Download at ce-guides.com/resintests

Two halves of the infinity sign should touch perfectly with no overlapping.

Bars would fit Slots if moved down

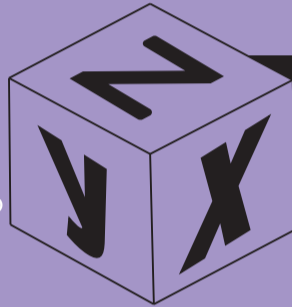
2) MAKE:ROOK MODEL TEST



If you are printing the validation matrix perfectly try to print a more detailed and three dimensional model like this Make:Rook model.

Good for testing overhangs & legibility of text from multiple angles. This little treasure will help you get the best print possible.

Download at coreelec.io/resintest



3D CALIBRATION CUBE

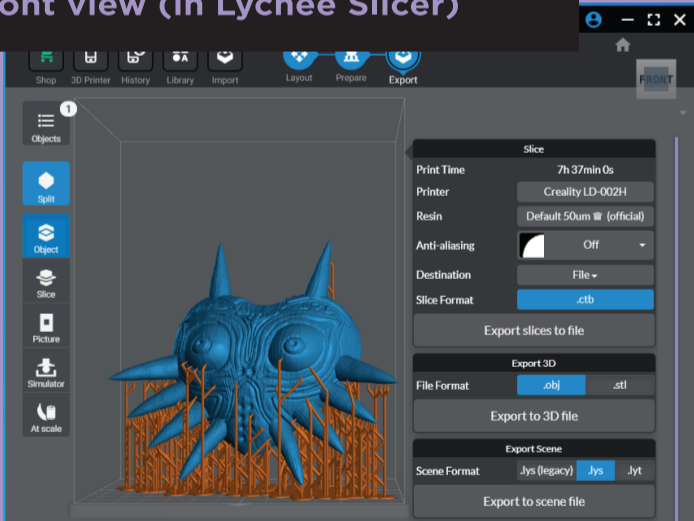
Used to test 3D filament printing & traditionally it is also a useful test for your resin printer. Use it to ensure dimension accuracy in different axis.

Download at coreelec.io/30

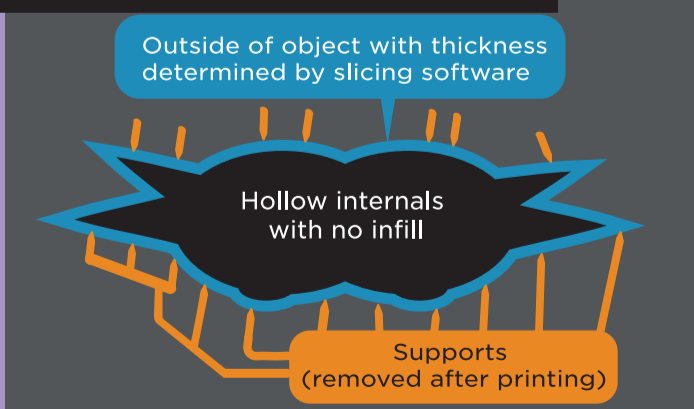
WORKFLOW Design ▶ Slice ▶ Print ▶ Wash ▶ Dry ▶ Cure

COMPUTER VIEWS

Front view (in Lychee Slicer)

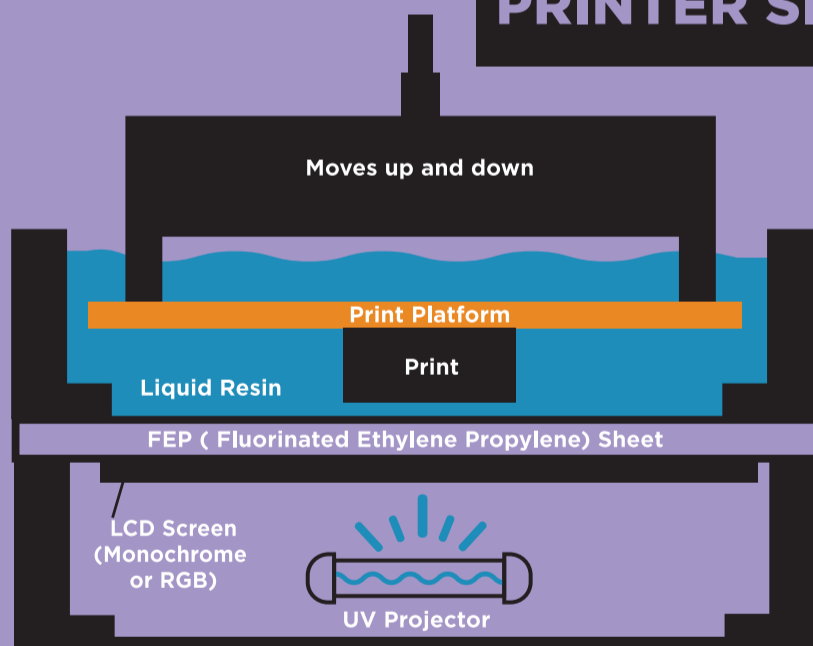


Top view (in Lychee Slicer)



Recommended outputs for fine prints are: smallest layers + Anti-aliasing of 4-8

PRINTER SIDE VIEW



This diagram will help you understand what's going on inside your printer

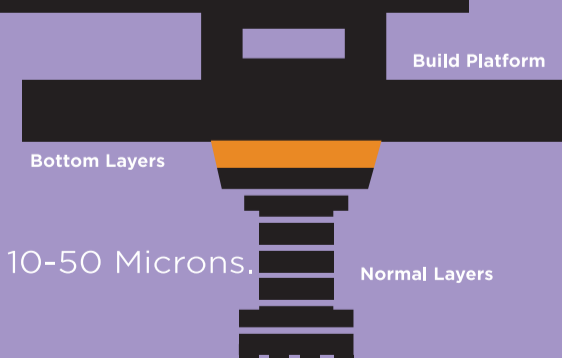
CALCULATING EXPOSURE TIME

As a general rule for normal layer exposure time you will need

- ▶ 0.5-5 Seconds (monochrome)
 - ▶ 2-20 Seconds (RGB screens)
- Average layer height will be between 10-50 Microns.

You will need 8-12 bottom layers

Bottom layer exposure times are always longer than normal layers. Our recommended time is roughly 8-12 X normal layer exposure time. (No longer than 30 Secs - higher values will overheat the resin)



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