



KEYMODEL ULTRA™

# Phrozen Sonic Mini 4k Printer Instructions

\*These settings only apply to  
Chitobox V1.9.1 or higher



KeyModel Ultra™

## PRINTER SETTINGS

PRINTER SETTINGS	KeyModel Ultra™
Machine Size Scaling	X: 133.25 Y: 74.9531
Layer Height	0.05
Bottom Layer Count	6
Transition Layer Count	15
Exposure Time	3.5
Bottom Exposure Time	30
Light Off Delay*	2
Bottom Light Off Delay*	2
Bottom Lift Distance	5
Lifting Distance	5
Bottom Lift Speed	250
Lifting Speed	250
Retract Speed	100