



KEYORTHO IBT™

Phrozen Sonic Mini 4k Printer Instructions

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



KeyOrtho IBT™

PRINTER SETTINGS

PRINTER SETTINGS	KeyOrtho IBT™
Machine Size Scaling	X: 134.000 Y: 75.000
Layer Height	0.1
Bottom Layer Count	3
Transition Layer Count	8
Exposure Time	17
Bottom Exposure Time	20
Light Off Delay*	5.5
Bottom Light Off Delay*	3
Bottom Lift Distance	15
Lifting Distance	15
Bottom Lift Speed	100
Lifting Speed	100
Retract Speed	50