



KEYCAST®

# Phrozen Sonic Mini 4k Printer Instructions

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



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## PRINTER SETTINGS

PRINTER SETTINGS	KeyCast®
Machine Size Scaling	X: 131.767 Y: 73.750
Layer Height	0.05
Bottom Layer Count	10
Transition Layer Count	10
Exposure Time	10
Bottom Exposure Time	42
Light Off Delay*	2
Bottom Light Off Delay*	1.5
Bottom Lift Distance	6
Lifting Distance	5
Bottom Lift Speed	150
Lifting Speed	100
Bottom Retract Speed	150
Retract Speed	150