



KEYSPLINT HARD® CLEAR

Anycubic Photon Mono M5 Printer Instructions



PRINTER SETTINGS	KeySplint Hard®Clear
Shrinkage Compensation	X:100.999%, Y:101.111%, Z:100.00%
Layer Height	0.1
Bottom Layer Count	5
Exposure Time	17.45
Bottom Exposure Time	28
Transition Layer Count	10
Transition Layer Type	Linear
Rest Time Before Lift	0
Rest Time After Lift	4
Rest Time After Retract	0.5
Bottom Lift Distance	45
Lifting Distance	45
Bottom Lift Speed	300
Lifting Speed	300
Bottom Speed Retract	175
Retract Speed	175