


KEYSPLINT SOFT®

Anycubic Photon Mono M5 Printer Instructions

| PRINTER SETTINGS |  KeySplint Soft® |
|-------------------------|-------------------------------------------------------------------------------------------------------|
| Shrinkage Compensation | X:100.999%, Y:101.111%, Z:100.00% |
| Layer Height | 0.1 |
| Bottom Layer Count | 5 |
| Exposure Time | 13 |
| Bottom Exposure Time | 27 |
| Transition Layer Count | 5 |
| Transition Layer Type | Linear |
| Rest Time Before Lift | 0 |
| Rest Time After Lift | 7 |
| Rest Time After Retract | 1 |
| Bottom Lift Distance | Slow Lift: 2, Fast Lift: 8 |
| Lifting Distance | Slow Lift: 3, Fast Lift: 7 |
| Bottom Lift Speed | Slow Lift: 100, Fast Lift: 110 |
| Lifting Speed | Slow Lift: 100, Fast Lift: 110 |
| Bottom Speed Retract | Slow Lift: 130, Fast Lift: 130 |
| Retract Speed | Slow Lift: 130, Fast Lift: 130 |