How to add new resin

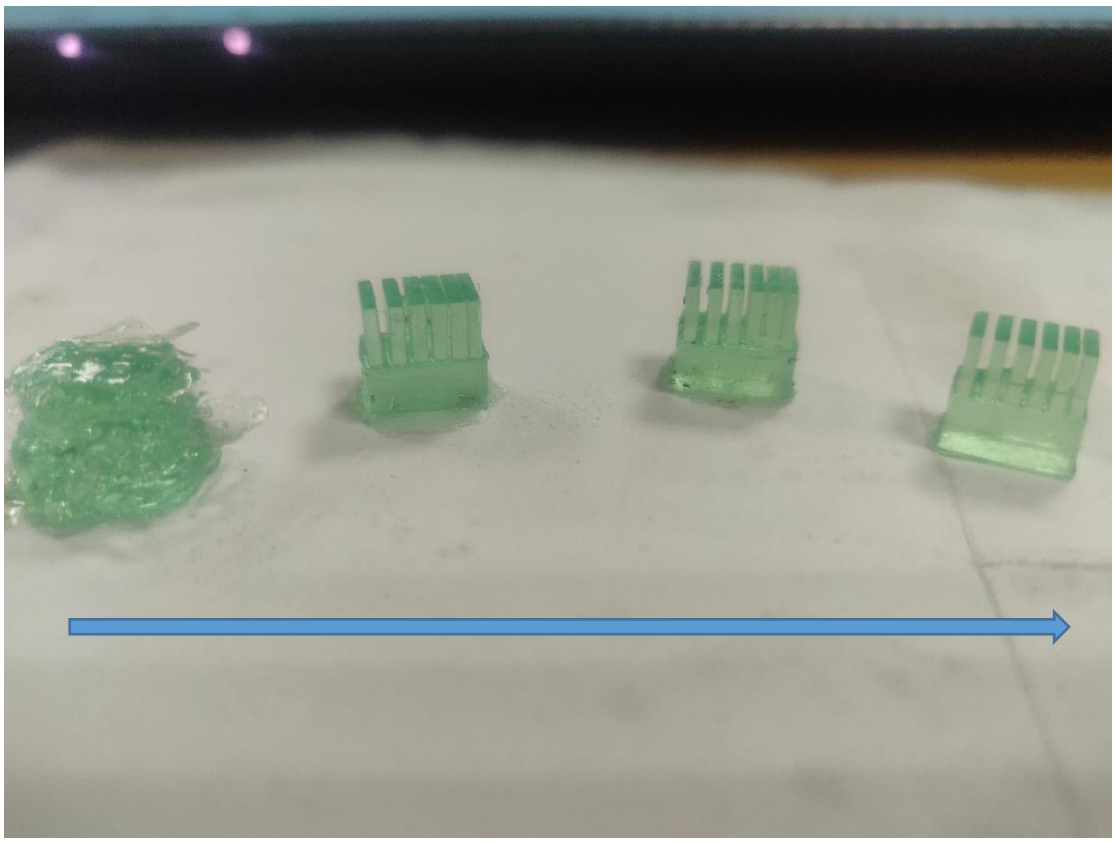
The parameters of our own SLA resin are about 118/118/220. (**Wall exposure/ Fill exoisure/ First layer exposure).**

You can fine-tune the parameters according to the different model you want to print.)

We recommend using this tiny model to adjust the parameters so that the amount of resin used is small and the adjustment can be made quickly.

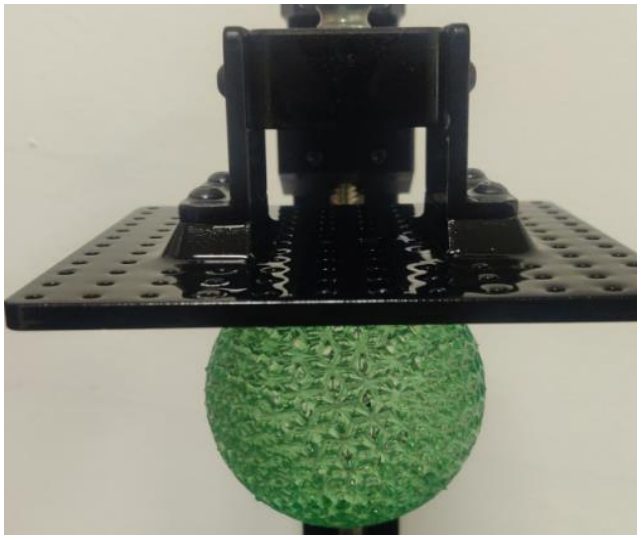
https://solidpre-1251753108.cos.na-siliconvalley.myqcloud.com/Cracktest.stl

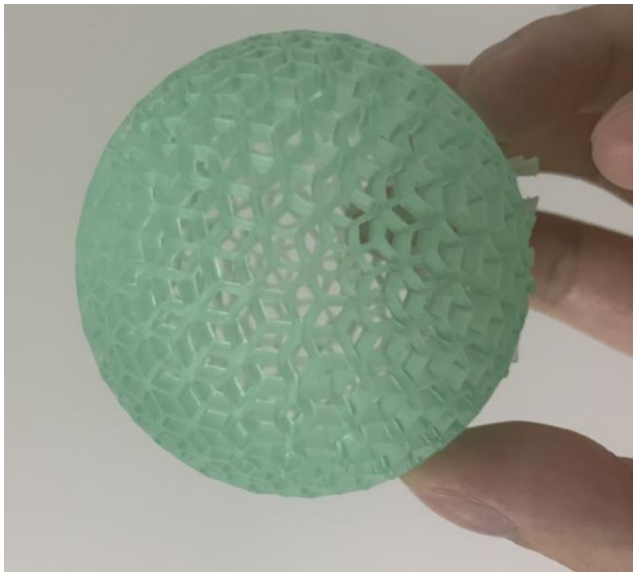
This is a picture of me adjusting the new LCD resin.

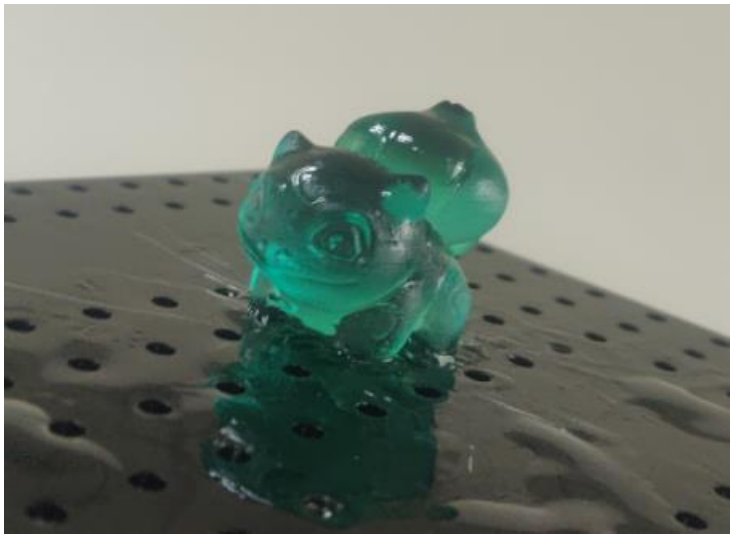


As shown in the figure, we gradually adjust the parameters of this model until it can appear 4-5 gaps. 10/10/10->7/7/7->6/7/7->4/6/7

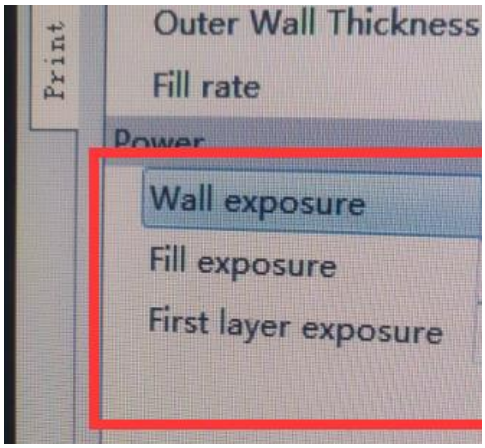
You can fine-tune the parameters according to the model you want to print.







In the latest version of slicing software,



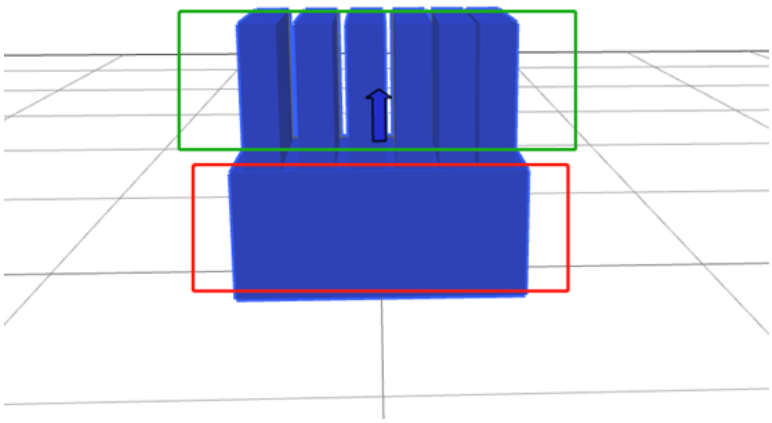
(Adjustable range from 0 to 255.)

（1）**Wall exposure** mainly affects the surface accuracy of the generated model.The larger the number, the stronger the surface, but the less accurate the surface.If the number is too large, it can create meaningless skin folds.

（2）**Fill exoisure** mainly affects the hardness of the generated model, but if the number is too large, the overall accuracy will be affected.

（3）**First layer exposure** mainly affects the viscosity of the mobile platform.As the value increases, the probability of the bottom layer of the model falling off decreases, but if the value is too large, an additional layer is printed.

If the print is not successful.



Reason 1: if the whole model is not formed and falls off in the resin tank, please increase the first layer exposure.If there is excess ground layer around the first layer, reduce the first layer exposure.

Reason 2: if the model part with red ring is not successfully printed, please add the fill exoisure.Reduce the fill exoisure if there is no meaningful growth in the red circle.

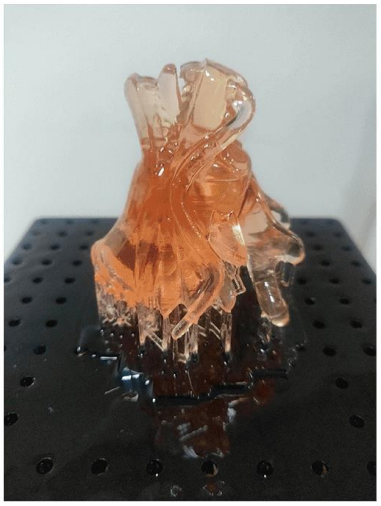
Reason 3: if the green circle part is not printed successfully, please adjust the wall exposure until 4 thin cracks appear.This value is the approximate parameter of the resin used.

Reason 4: If the model is printed many times, it cannot adhere to the printing platform.You need to clean up the printing residue in the platform and the material tank, and calibrate the platform again.It is important to make sure that the mobile platform fits tightly to the bottom.

As long as it was 405NM resin, we made sure we were compatible with SLA and LCD.

In the latest version of slicing software, the parameter adjustment range suitable for LCD resin is 0-20.

Dapted to a variety of 405NM resins (SLA&LCD)



If you have any questions, please email us.

Thank you very much for your support.

Best Regards

SolidMaker Team