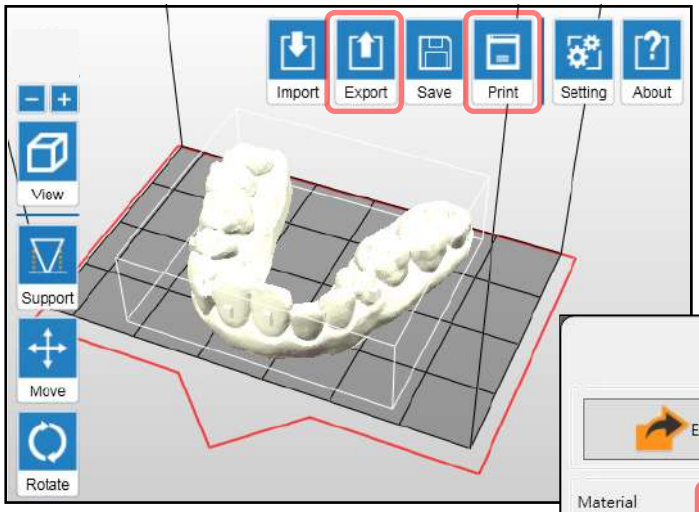
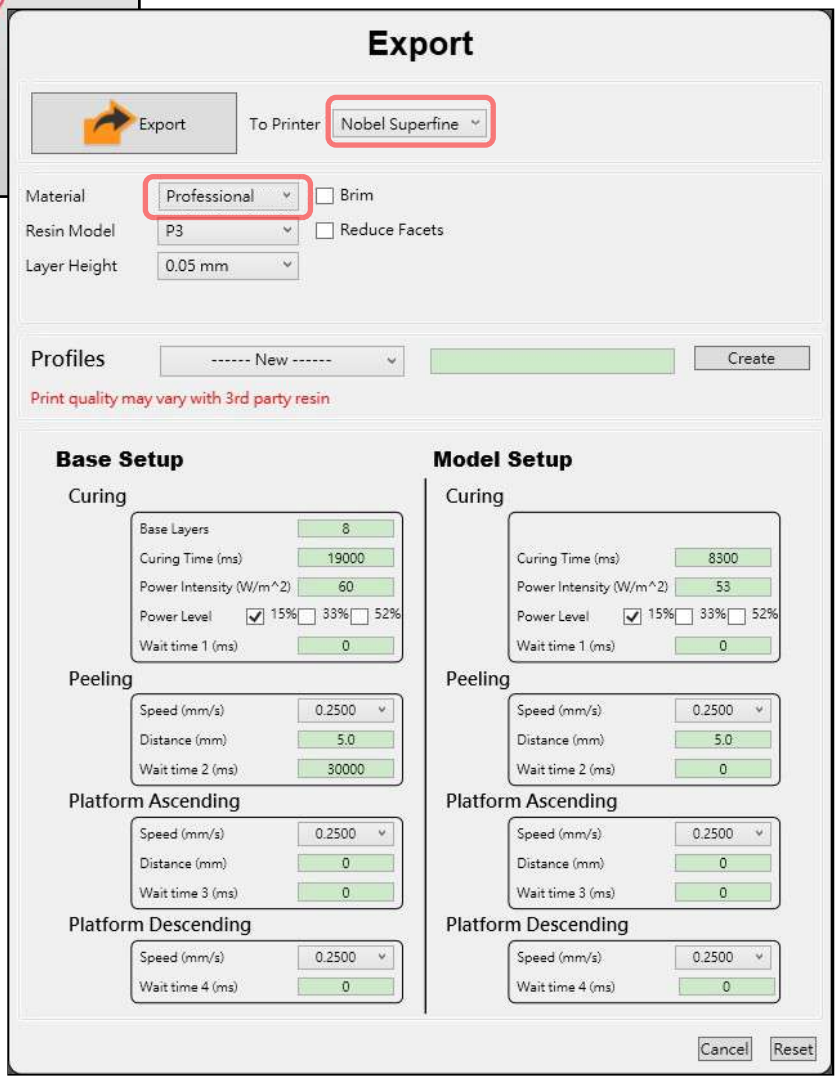
ENGLISH

3rd Party Resin Setup

To go to 3rd party resin setup:

1. Install XYZware_Nobel with the bundled USB drive and update the software and firmware. (Software version 1.1.35.6 and firmware version 1.6.7.1 or above are required.)
2. Connect the printer to PC, and launch the XYZware_Nobel.
3. Select “Export” or “Print” and select “Professional” from the list of material.





4. Set up the printing parameters. See next page for the description on each item.

Profiles

Use this section to record your settings.

- **To create new profile:**
  Select “New”, input a preferred name in the column and click on “Create”.
- **To load existing profile:**
  Select the profile from the dropdown list.

Base Setup / Model Setup

Printing parameters can be assigned differently for the base layers and the rest layers (refered as “Model”).

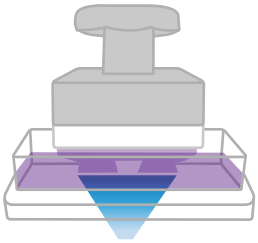
Generally, you may need more layers at the base (Base Layers) and longer curing duration for the bottom layers for better adhesion.

For larger objects, more base layers may be required for better adhension to the platform.

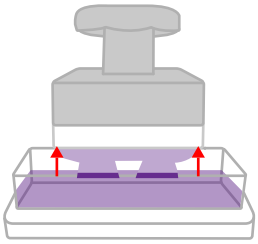
Printing Process

Curing

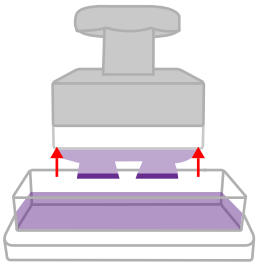
LED module lights up.



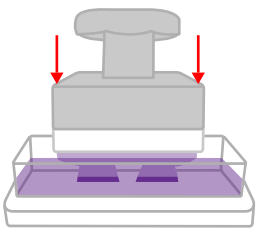
Peeling



Platform Ascending



Platform Descending



Adjustable Parameters

The LED module lights up, based on the settings in the section of "Curing":

- Curing Time

  The item controls the duration for projecting LED light at the bottom of the tank.

  Range: 50 - 65535 ms

- Power Intensity

  The item controls the power intensity of the UV light.

  Range: 53-100mW

- Power Level

  The item controls the level of the Power Intensity. To cure at full power, select all 3 items.

  Option: 15%, 33%, 52% (You may select more the one option to trigger other power level.)

The LED light goes out after curing the whole layer and wait.

- Wait Time 1

  The printer pauses and waits for the specified time until the resin is completely polymerized.

  Range: 0 - 65535 ms

The platform moves up to peel the cured layer off from the tank and wait.

- Speed

  The print platform moves up based on the specified speed. Slower ascending speed may be required for resins of lower stiffness after being cured.

- Distance

  Longer ascending distance may be required for resins of higher viscosity. In general, longer distance for peeling and platform acsending (in the next stage) will result in better print quality.

  Range: 0.1 - 25 mm (One decimal place allowed.)

- Wait Time 2

  The printer pauses and waits for the specified time until the resin has stopped flowing.

  Range: 0 - 65535 ms

The platform moves further up and wait. Allow more distance between the platform and the tank surface will lead to better print quality at the detailed features.

- Speed

  The print platform moves up based on the specified speed. Faster movement at this stage may compensate the time delay for peeling.

- Distance

  The print platform moves up based on the specified distance.

  Range: 0 - 24.9 mm (One decimal place allowed; total ascending distance of the platform, including the setting for peeling, should be no more than 25mm.)

- Wait Time 3

  The printer pauses and waits for the specified time until the resin has stopped flowing.

  Range: 0 - 65535 ms

The platform moves down and wait before curing the next layer.

- Speed

  The platform moves down based on the specified speed. Slower descending speed also helps on cooling down the resin.

- Wait Time 4

  The printer pauses and waits for the specified time until the resin is cooled down.

  Range: 0 - 65535 ms