

RANSOM & RANDOLPH

R&R® 3D Model Resin Equipment Settings

3D Printer Settings

R&R 3D model resins are compatible with DLP and LCD 3D printers. Every 3D printer, model resin, and 3D model differs, so to achieve the best quality print, you may need to adjust settings in your slicer software. This customization ensures that your printer is optimized for R&R's model resins, meeting the specific requirements for your print. For best results, follow the settings provided in this document. Always refer to the 3D printer manufacturer's instructions during operation.

Curing Unit Settings

For best results, use the settings in this document to cure your dental model produced with R&R's model resins. Be sure to follow the curing unit manufacturer's instructions during operation.



As the conditions or methods of use are beyond our control, we do not assume any responsibility and expressly disclaim any liability for any use of this product. Information contained herein is believed to be true and accurate but all statements or suggestions are made without warranty, expressed or implied, regarding accuracy of the information, the hazards connected with the use of the material or the results to be obtained from the use thereof. Compliance with all applicable federal, state, and local regulations remains the responsibility of the user. All potential liability related to the sale and use of this product is limited to the cost of the particular goods sold in their respective transactions.



3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Issue Date: November 20, 2024

Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

TABLE OF CONTENTS

EQUIPMENT COMPATIBILITY.....	3
3D PRINTER SETTINGS (BY MANUFACTURER)	
Ackuretta.....	4
Anycubic.....	5
Asiga.....	6-11
Elegoo.....	12
Phrozen.....	13-16
Shining 3D.....	17
CURING UNIT SETTINGS (BY MANUFACTURER)	
Ackuretta.....	18
Asiga.....	18
Voco GmbH.....	18



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN EQUIPMENT COMPATIBILITY

- *Compatible*
- *Not Yet Compatible*

	R&R 3D Model Standard™ resin		R&R 3D Model Elite™ resin	
	Beige	Gray	Beige	Gray

ACKURETTA

SOL 3D printer	●	●	●	●
Curie™ curing unit	●	●	●	●

ASIGA

Max 3D printer	●	●	●	●
Max 2 3D printer	●	●	●	●
Max X 3D printer	●	●	●	●
Ultra 3D printer	●	●	●	●
PRO 4K 3D printer	●	●	●	●
PRO 4K XL 3D printer	●	●	●	●
All other Asiga 3D printers	●	●	●	●
Flash® Curve curing unit	●	●	●	●

ANYCUBIC

Photon Mono 4K 3D printer	●	●	●	●
---------------------------	---	---	---	---

ELEGOO

Saturn 2 8K 3D printer	●	●	●	●
------------------------	---	---	---	---

phrozen

Sonic Mini 4K 3D printer	○	○	●	●
Sonic Mini 8K 3D printer	●	●	●	●
Sonic Mighty 4K 3D printer	●	●	○	○

SHINING 3D

AccuFab-L4K 3D printer	●	●	●	●
------------------------	---	---	---	---

VOCO

Otoflash curing unit	●	●	●	●
----------------------	---	---	---	---



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
 800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
 www.ransom-randolph.com



Ransom & Randolph GmbH
 Leipziger Straße 40 | 04571 Rötha Germany
 +49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



Ackuretta SOL

Manufacturer
Ackuretta

Slicing Software
Alpha AI V5.1.1

Compatibility
R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

Layer Height
50µm/0.05 mm
100µm/0.1 mm
150µm/0.15 mm

Uploading Files

Ransom & Randolph's 3D model resins are compatible with the Ackuretta slicing software (Alpha AI version V5.1.1). Please ensure your software is up to date to the latest version.

Printing a Model

1. Open the Alpha AI slicing software.
2. Select the appropriate printer (Ackuretta SOL), brand (Ransom & Randolph) & relevant resin material's name.
3. Make the necessary changes found in the Printer Settings below.
4. Follow the printer manufacturer's instructions during operations. For more information, visit ackuretta.com.

Note: If your printer has been in use for an extended period, it is possible that the light intensity may have reduced. If you experience failures, increase the layer curing time by 10 to 15% over the normal curing time (Example: If the curing time for the 50µm/0.05mm layer is 2.2 seconds, increase the time to 2.4 or 2.5 seconds).

Printer Settings

R&R 3D Model Standard Resin

Layer Thickness	0.07 mm	Scaling Ratio	
Illumination	2.10 seconds	X	1.00442
Adjustment	0.0 seconds	Y	1.00533
Base Adjustment	0.0 seconds	Z	1.01391

R&R 3D Model Elite Resin

Layer Thickness	0.07 mm	Scaling Ratio	
Illumination	2.60 seconds	X	1.00692
Adjustment	0.0 seconds	Y	1.00503
Base Adjustment	0.0 seconds	Z	1.01762



RANSOM & RANDOLPH

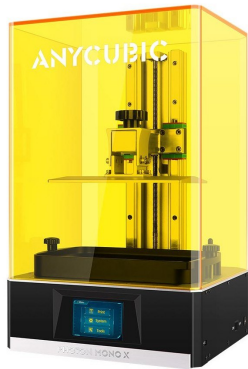
3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



Photon Mono 4K

Manufacturer

Anycubic

Slicing Software

Photon Workshop V2.2.16

Compatibility

R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

Layer Height

50µm/0.05 mm

Uploading Files

Ransom & Randolph's 3D model resins are compatible with the Anycubic slicing software (Photon Workshop V2.2.16). Please ensure your software is up to date to the latest version.

Printing a Model

1. Open the Photon Workshop slicing software.
2. Select the appropriate printer (Photon Mono 4K), brand (Ransom & Randolph) & the relevant resin material's name.
3. Make the necessary changes found in the Printer Settings below.
4. Follow the printer manufacturer's instructions during operations. For more information, visit www.anycubic.com.

Printer Settings

1. Make the following changes under the "Slice Parameter" tab in the Machine & Resin Settings:
 - Normal Exposure Time(s): Change to 3.200



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



Max

Manufacturer

Asiga

Slicing Software

Composer V 2.0

Compatibility

R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

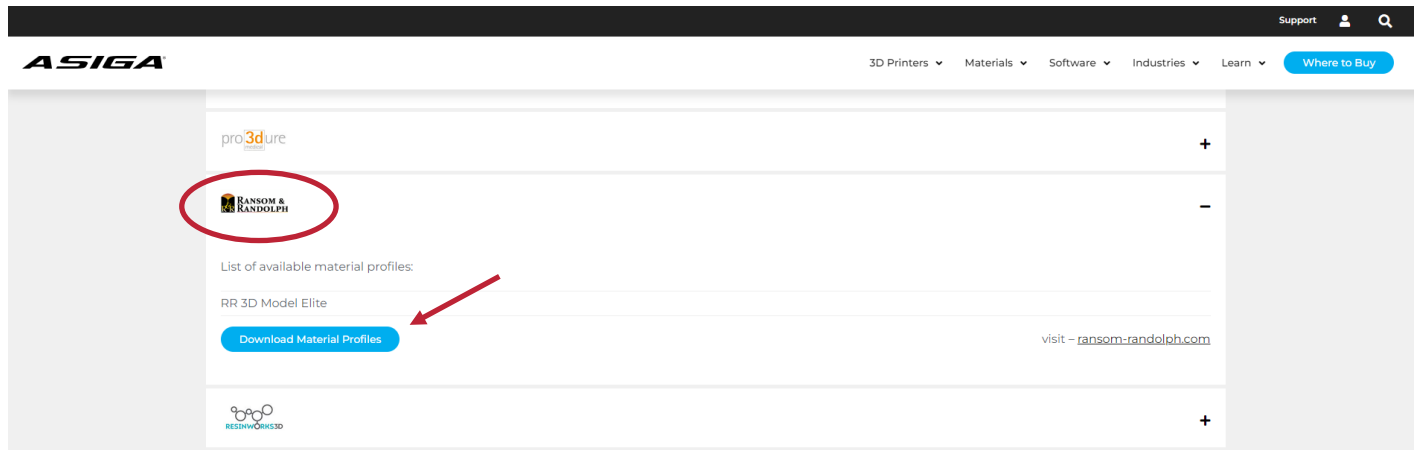
Layer Height

50µm/0.05 mm
100µm/0.1 mm
150µm/0.15 mm

Uploading Files

Ransom & Randolph's 3D model resins are validated in the Asiga slicing software (Composer V 2.0). Please ensure your software is up to date to the latest version. To access the corresponding file, please follow the directions below.

1. Visit Asiga's official website at asiga.com.
2. Click "Materials" in the home page ribbon.
3. Choose "Open Material Library"
4. Choose "Explore Open Material Library"
5. Scroll through the list of vendors to find "Ransom & Randolph"



6. Download the .ini file to your computer.
7. Import the .ini file into the Asiga composer software (check for latest version of software).

Printing a Model

1. Open the Composer slicing software.
2. Import the validated files into the Asiga composer software.
3. Follow the printer manufacturer's instructions during operations. For more information, visit asiga.com.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



Max 2

Manufacturer

Asiga

Slicing Software

Composer V 2.0

Compatibility

R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

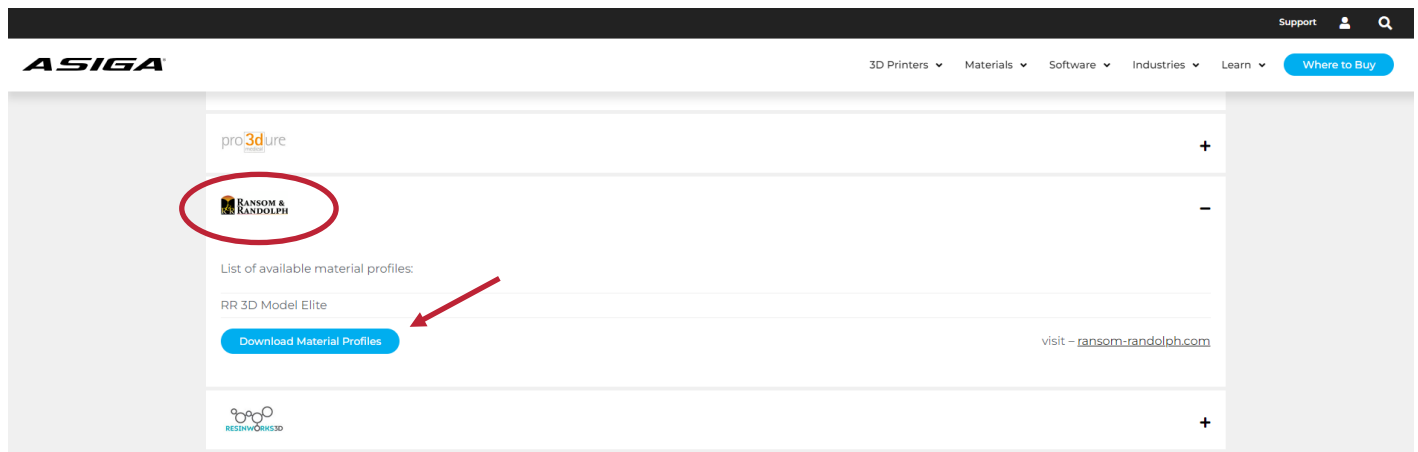
Layer Height

50µm/0.05 mm
100µm/0.1 mm
150µm/0.15 mm

Uploading Files

Ransom & Randolph's 3D model resins are validated in the Asiga slicing software (Composer V 2.0). Please ensure your software is up to date to the latest version. To access the corresponding file, please follow the directions below.

1. Visit Asiga's official website at asiga.com.
2. Click "Materials" in the home page ribbon.
3. Choose "Open Material Library"
4. Choose "Explore Open Material Library"
5. Scroll through the list of vendors to find "Ransom & Randolph"



6. Download the .ini file to your computer.
7. Import the .ini file into the Asiga composer software (check for latest version of software).

Printing a Model

1. Open the Composer slicing software.
2. Import the validated files into the Asiga composer software.
3. Follow the printer manufacturer's instructions during operations. For more information, visit asiga.com.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



Max X

Manufacturer

Asiga

Slicing Software

Composer V 2.0

Compatibility

R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

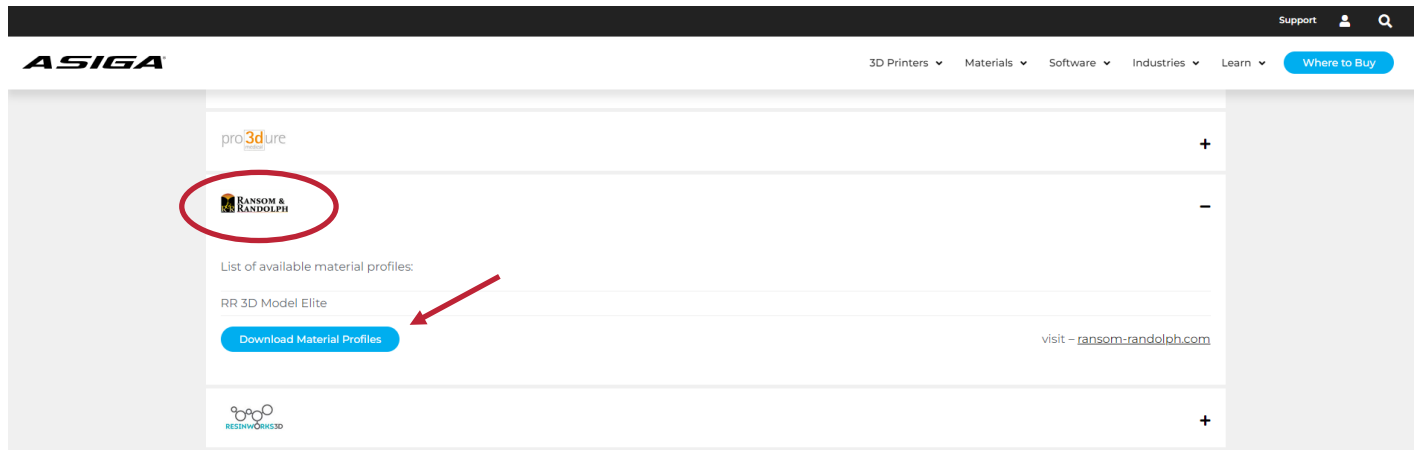
Layer Height

50µm/0.05 mm
100µm/0.1 mm
150µm/0.15 mm

Uploading Files

Ransom & Randolph's 3D model resins are validated in the Asiga slicing software (Composer V 2.0). Please ensure your software is up to date to the latest version. To access the corresponding file, please follow the directions below.

1. Visit Asiga's official website at asiga.com.
2. Click "Materials" in the home page ribbon.
3. Choose "Open Material Library"
4. Choose "Explore Open Material Library"
5. Scroll through the list of vendors to find "Ransom & Randolph"



6. Download the .ini file to your computer.
7. Import the .ini file into the Asiga composer software (check for latest version of software).

Printing a Model

1. Open the Composer slicing software.
2. Import the validated files into the Asiga composer software.
3. Follow the printer manufacturer's instructions during operations. For more information, visit asiga.com.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



Ultra

Manufacturer

Asiga

Slicing Software

Composer V 2.0

Compatibility

R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

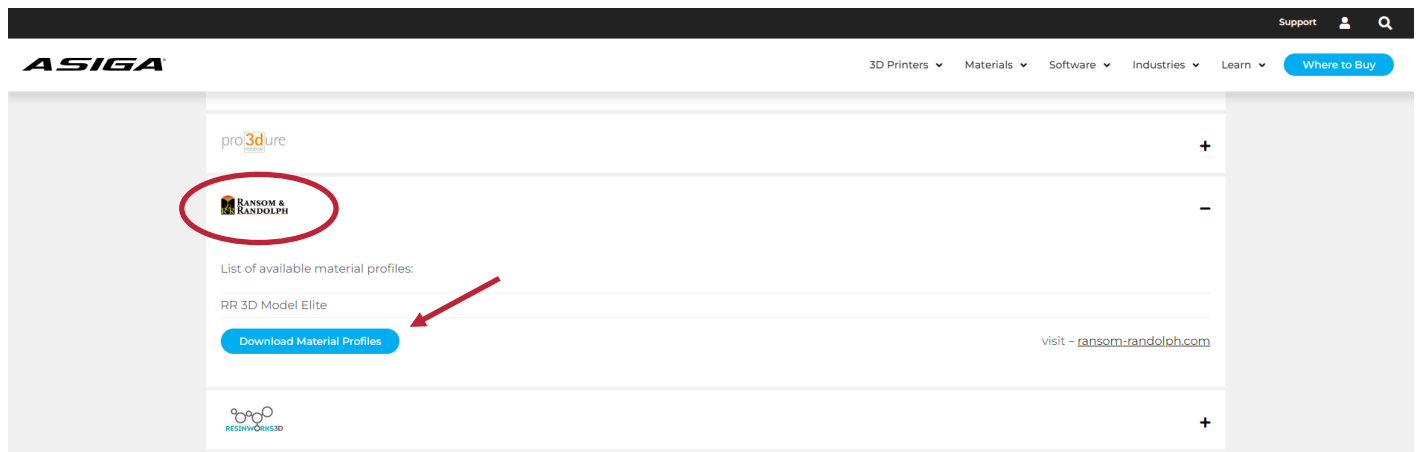
Layer Height

50µm/0.05 mm
100µm/0.1 mm
150µm/0.15 mm

Uploading Files

Ransom & Randolph's 3D model resins are validated in the Asiga slicing software (Composer V 2.0). Please ensure your software is up to date to the latest version. To access the corresponding file, please follow the directions below.

1. Visit Asiga's official website at asiga.com.
2. Click "Materials" in the home page ribbon.
3. Choose "Open Material Library"
4. Choose "Explore Open Material Library"
5. Scroll through the list of vendors to find "Ransom & Randolph"



6. Download the .ini file to your computer.
7. Import the .ini file into the Asiga composer software (check for latest version of software).

Printing a Model

1. Open the Composer slicing software.
2. Import the validated files into the Asiga composer software.
3. Follow the printer manufacturer's instructions during operations. For more information, visit asiga.com.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



PRO 4K

Manufacturer

Asiga

Slicing Software

Composer V 2.0

Compatibility

R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

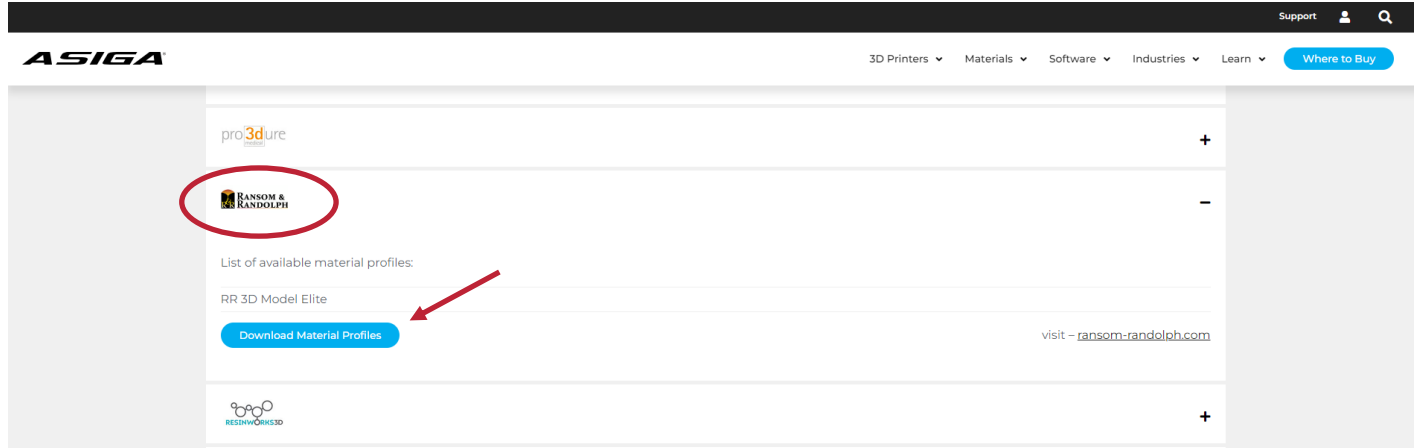
Layer Height

50µm/0.05 mm
100µm/0.1 mm
150µm/0.15 mm

Uploading Files

Ransom & Randolph's 3D model resins are validated in the Asiga slicing software (Composer V 2.0). Please ensure your software is up to date to the latest version. To access the corresponding file, please follow the directions below.

1. Visit Asiga's official website at asiga.com.
2. Click "Materials" in the home page ribbon.
3. Choose "Open Material Library"
4. Choose "Explore Open Material Library"
5. Scroll through the list of vendors to find "Ransom & Randolph"



6. Download the .ini file to your computer.
7. Import the .ini file into the Asiga composer software (check for latest version of software).

Printing a Model

1. Open the Composer slicing software.
2. Import the validated files into the Asiga composer software.
3. Follow the printer manufacturer's instructions during operations. For more information, visit asiga.com.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



PRO 4K XL

Manufacturer

Asiga

Slicing Software

Composer V 2.0

Compatibility

R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

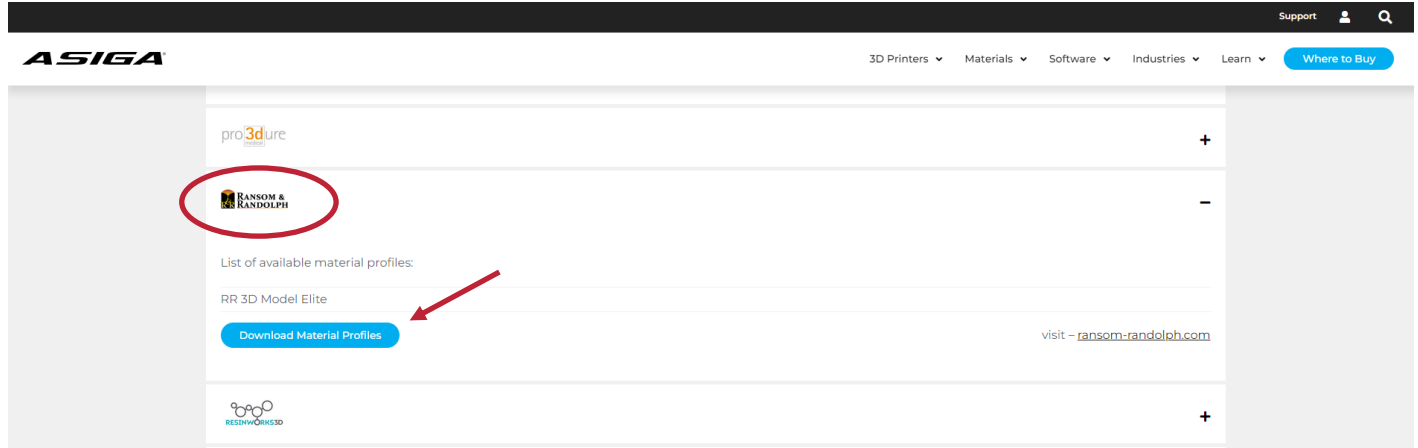
Layer Height

50µm/0.05 mm
100µm/0.1 mm
150µm/0.15 mm

Uploading Files

Ransom & Randolph's 3D model resins are validated in the Asiga slicing software (Composer V 2.0). Please ensure your software is up to date to the latest version. To access the corresponding file, please follow the directions below.

1. Visit Asiga's official website at asiga.com.
2. Click "Materials" in the home page ribbon.
3. Choose "Open Material Library"
4. Choose "Explore Open Material Library"
5. Scroll through the list of vendors to find "Ransom & Randolph"



6. Download the .ini file to your computer.
7. Import the .ini file into the Asiga composer software (check for latest version of software).

Printing a Model

1. Open the Composer slicing software.
2. Import the validated files into the Asiga composer software.
3. Follow the printer manufacturer's instructions during operations. For more information, visit asiga.com.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



Saturn 2

Manufacturer
Elegoo

Slicing Software
Chitubox V1.9.6

Compatibility
R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

Layer Height
50µm/0.05 mm

Uploading Files

Ransom & Randolph's 3D model resins are compatible with the Elegoo slicing software (Chitubox V1.9.6). Please ensure your software is up to date to the latest version.

Printing a Model

1. Open the Chitubox slicing software.
2. Select the appropriate printer (Saturn 2), brand (Ransom & Randolph) & the relevant resin material's name.
3. Make the necessary changes found in the Printer Settings below.
4. Follow the printer manufacturer's instructions during operations. For more information, visit elegoo.com.

Printer Settings

1. Make the following changes under the "Print" settings:
 - Exposure Time: Change to 5.500 s

The screenshot shows the 'Print' settings tab in Chitubox. The 'Exposure Time' is set to 5.500 s and is highlighted with a red box. Other settings include Layer Height (0.050 mm), Bottom Layer Count (6), Bottom Exposure Time (40.000 s), Transition Layer Count (6), Transition Type (Linear), Transition Layer Interval Time Difference (4.93 s), Waiting Mode During Printing (Resting time), Rest Time Before Lift (0.000 s), Rest Time After Lift (0.000 s), and Rest Time After Retract (1.000 s). The 'Advance' section shows Bottom Light PWM set to 255. The 'Bottom Layer' diagram shows a blue layer being printed, and the 'Normal Layer' diagram shows a grey layer being printed.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



Sonic Mini 4K

Manufacturer
Phrozen

Compatibility
R&R 3D Model Elite™ resin

Slicing Software
Chitubox V1.9.6

Layer Height
50µm/0.05 mm

Uploading Files

Ransom & Randolph's 3D model resins are compatible with the Phrozen slicing software (Chitubox V1.9.6). Please ensure your software is up to date to the latest version.

Printing a Model

1. Open the Chitubox slicing software.
2. Select the appropriate printer (Phrozen Sonic Mini 4K), brand (Ransom & Randolph) & the relevant resin material's name.
3. Make the necessary changes found in the Printer Settings below.
4. Follow the printer manufacturer's instructions during operations. For more information, visit phrozen3d.com.

Printer Settings

1. Make the following changes under the "Print" settings:
 - Exposure Time: Change to 5.500 s

The screenshot shows the 'Slice Settings' window in Chitubox software. The 'Print' tab is active, and the 'Exposure Time' is highlighted with a red box and set to 5.500 s. Other settings include Layer Height (0.050 mm), Bottom Layer Count (6), Bottom Exposure Time (40.000 s), Transition Layer Count (6), Transition Type (Linear), Transition Layer Interval Time Difference (4.93 s), Waiting Mode During Printing (Resting time), Rest Time Before Lift (0.000 s), Rest Time After Lift (9.000 s), and Rest Time After Retract (9.000 s). The 'Advance' section shows Bottom Light PWM set to 255. A diagram at the bottom illustrates the 'Bottom Layer' and 'Normal Layer' printing processes.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



Sonic Mini 8K

Manufacturer
Phrozen

Slicing Software
Chitubox V1.9.6

Compatibility
R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

Layer Height
50µm/0.05 mm

Uploading Files

Ransom & Randolph's 3D model resins are compatible with the Phrozen slicing software (Chitubox V1.9.6). Please ensure your software is up to date to the latest version.

Printing a Model

1. Open the Chitubox slicing software.
2. Select the appropriate printer (Sonic Mini 8K), brand (Ransom & Randolph) & the relevant resin material's name.
3. Make the necessary changes found in the Printer Settings below.
4. Follow the printer manufacturer's instructions during operations. For more information, visit phrozen3d.com.

Printer Settings

1. Make the following changes under the "Print" settings:
 - Exposure Time: Change to 4.500 s

The screenshot shows the 'Slice Settings' window in Chitubox. The 'Print' tab is selected. The printer 'Phrozen Sonic Mini 8K' is chosen. The 'Exposure Time' is set to 4.500 s and is highlighted with a red box. Other settings include Layer Height (0.050 mm), Bottom Layer Count (6), Bottom Exposure Time (40.000 s), Transition Layer Count (6), Transition Type (Linear), Transition Layer Interval Time Difference (5.07 s), Waiting Mode During Printing (Resting time), Rest Time Before Lift (0.000 s), Rest Time After Lift (0.000 s), and Rest Time After Retract (1.000 s). The 'Advance' section shows Bottom Light PWM set to 255. The 'Apply' button is visible at the bottom right.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



Sonic Mighty 4K

Manufacturer
Phrozen

Slicing Software
Chitubox V1.9.6

Compatibility
R&R 3D Model Standard™ resin

Layer Height
50µm/0.05 mm

Uploading Files

Ransom & Randolph's 3D model resins are compatible with the Phrozen slicing software (Chitubox V1.9.6). Please ensure your software is up to date to the latest version.

Printing a Model

1. Open the Chitubox slicing software.
2. Select the appropriate printer (Phrozen Sonic Mighty 4K), brand (Ransom & Randolph) & the relevant resin material's name (50µm/0.05 mm).
3. Make the necessary setting changes found in the Printer Settings below.
4. Follow the printer manufacturer's instructions during operations. For more information, visit phrozen3d.com.

Printer Settings

1. Make the following changes under the "Print" settings:
 - Exposure Time: Change to 4.500 s

Slice Settings

Machine Resin **Print** Advance

Print

Layer Height	0.050	mm
Bottom Layer Count	6	
Exposure Time	4.500	s
Bottom Exposure Time	40.000	s
Transition Layer Count	6	
Transition Type	Linear	
Transition Layer Interval Time Difference	5.07	s
Waiting Mode During Printing	Resting time	
Rest Time Before Lift	0.000	s
Rest Time After Lift	12.000	s
Rest Time After Retract	12.000	s

Advance

Bottom Light PWM 255 / -

Bottom Lift Distance	5.000	+ 0.000	mm
Lifting Distance	5.000	+ 0.000	mm
Bottom Retract Distance	5.000	+ 0.000	mm
Retract Distance	5.000	+ 0.000	mm
Bottom Lift Speed	60.000	+ 0.000	mm/min
Lifting Speed	60.000	+ 0.000	mm/min
Bottom Retract Speed	120.000	+ 0.000	mm/min
Retract Speed	120.000	+ 0.000	mm/min

Bottom Layer Normal Layer

Apply Cancel



RANSOM & RANDOLPH

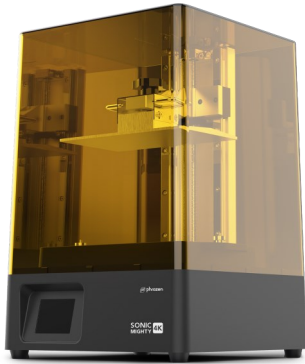
3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



Sonic Mighty 4K

Manufacturer
Phrozen

Slicing Software
Chitubox V1.9.6

Compatibility
R&R 3D Model Standard™ resin

Layer Height
100µm/0.1 mm

Uploading Files

Ransom & Randolph's 3D model resins are compatible with the Phrozen slicing software (Chitubox V1.9.6). Please ensure your software is up to date to the latest version.

Printing a Model

1. Open the Chitubox slicing software.
2. Select the appropriate printer (Phrozen Sonic Mighty 4K), brand (Ransom & Randolph) & the relevant resin material's name (100µm/0.1 mm).
3. Make the necessary setting changes found in the Printer Settings below.
4. Follow the printer manufacturer's instructions during operations. For more information, visit phrozen3d.com.

Printer Settings

1. Make the following changes under the "Print" settings:
 - Exposure Time: Change to 6.700 s

Slice Settings

Machine Resin **Print** Advance

Print

Layer Height	0.100	mm
Bottom Layer Count	6	
Exposure Time	6.700	s
Bottom Exposure Time	40.000	s
Transition Layer Count	6	
Transition Type	Linear	
Transition Layer Interval Time Difference	4.76	s
Waiting Mode During Printing	Resting time	
Rest Time Before Lift	0.000	s
Rest Time After Lift	12.000	s
Rest Time After Retract	12.000	s

Advance

Bottom Light PWM 255 / -

Bottom Lift Distance 5.000 + 0.000 mm
Lifting Distance 5.000 + 0.000 mm
Bottom Retract Distance 5.000 + 0.000 mm
Retract Distance 5.000 + 0.000 mm
Bottom Lift Speed 60.000 + 0.000 mm/min
Lifting Speed 60.000 + 0.000 mm/min
Bottom Retract Speed 120.000 + 0.000 mm/min
Retract Speed 120.000 + 0.000 mm/min

Bottom Layer Normal Layer

Apply Cancel



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™

R&R® 3D MODEL RESIN PRINTER SETTINGS



AccuFab-L4K

Manufacturer

Shining 3D

Slicing Software

Accuware V 3.1.8.35

Compatibility

R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

Layer Height

50µm/0.05 mm
100µm/0.1 mm

Uploading Files

Ransom & Randolph's 3D model resins are compatible with the Shining 3D slicing software (Accuware V 3.1.8.35). Please ensure your software is up to date to the latest version.

Printing a Model

1. Open the Accuware slicing software.
2. Select the appropriate printer (AccuFab-L4K), brand (Ransom & Randolph) & the relevant resin material's name from the drop-down menu. The material name will depend on the layer height desired.
 - Layer Height: 50µm/0.05 mm: “[Shining 3D]0.05”
 - Layer Height: 100µm/0.1 mm: “[Shining 3D]0.1”
3. Make the necessary changes found in the Printer Settings below.
4. Follow the printer manufacturer's instructions during operations. For more information, visit shining3ddental.com.

Printer Settings

Layer Height: 50µm/0.05 mm

1. Select the material name “[Shining 3D]0.05” from the drop-down menu.
2. Make the following changes under the “General Layer” settings column:
 - Fill Exposure Time (s): Change from 3.60 to 4.00
 - Boundary Exposure Time (s): Change from 3.60 to 4.00
 - Slow Return Speed on Z-axis (mm/min): Change from 90 to 72

Layer Height: 100µm/0.1 mm

1. Select the material name “[Shining 3D]0.1” from the drop-down menu.
2. Make the following changes under the “General Layer” settings column:
 - Fill Exposure Time (s): Change from 4.60 to 5.10
 - Boundary Exposure Time (s): Change from 4.60 to 5.10
 - Slow Return Speed on Z-axis (mm/min): Change from 90 to 72



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



R&R® 3D MODEL RESIN CURING UNIT SETTINGS



Curie™ curing unit

Manufacturer
Ackuretta

Compatibility
R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

Curing Instructions

1. Customize the curing parameters to the following:
 - High-power flashing system
 - 10 minutes
2. Follow the printer manufacturer's instructions during operations. For more information, visit ackuretta.com.



Flash® Curve curing unit

Manufacturer
Asiga

Compatibility
R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

Curing Instructions

1. Customize the curing parameters to the following:
 - Low-power flashing system
 - 30 minutes
2. Follow the printer manufacturer's instructions during operations. For more information, visit asiga.com.



OtoFlash UV curing unit

Manufacturer
VOCO GmbH

Compatibility
R&R 3D Model Standard™ resin
R&R 3D Model Elite™ resin

Curing Instructions

1. Customize the curing parameters to the following:
 - 2,000 flashes each side
2. Follow the printer manufacturer's instructions during operations. For more information, visit voco.dental.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™