

Druckparameter für Creality Resin 3D-Drucker

Quelle: [Creality Resin 3D Printers Settings - Creality AU Blog](#)

PLA-basiertes Resin							
Drucker-Modell	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000 \pm 10%	4500 \pm 10%	3500 \pm 10%	3300 \pm 10%	4000 \pm 10%	3200 \pm 10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	20s	20s	50s	60s	60s	70s	30s
Exposure time	2.5s	2.8s	2.5s	2.8s	2.8s	3.2s	2.4s
Turn off delay	1s	1s	1s	2s	2s	2s	0s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	3mm/s	3mm/s	1mm/s	5mm/s	5mm/s	5mm/s	60mm/min
Retract speed	3mm/s	3mm/s	1mm/s	5mm/s	5mm/s	5mm/s	150mm/min
Standart Resin fest							
Drucker-Modell	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000 \pm 10%	4500 \pm 10%	3500 \pm 10%	3300 \pm 10%	4000 \pm 10%	3200 \pm 10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	20s	20s	40s	40s	40s	50s	30s
Exposure time	2.3s	2.5s	2.8s	3s	3s	3.2s	3s
Turn off delay	1s	1s	1s	2s	2s	2s	0s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	3mm/s	3mm/s	3mm/s	5mm/s	5mm/s	5mm/s	60mm/min
Retract speed	3mm/s	3mm/s	3mm/s	5mm/s	5mm/s	5mm/s	150mm/min
Standart Resin PLUS fest							
Empfohlene Einstellungen	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000 \pm 10%	4500 \pm 10%	3500 \pm 10%	3300 \pm 10%	4000 \pm 10%	3200 \pm 10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	20s	20s	50s	60s	60s	70s	30s
Exposure time	2.5s	2.8s	2.5s	2.8s	2.8s	3.2s	2.4s
Turn off delay	1s	1s	1s	2s	2s	2s	0s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	3mm/s	3mm/s	1mm/s	5mm/s	5mm/s	5mm/s	60mm/min
Retract speed	3mm/s	3mm/s	1mm/s	5mm/s	5mm/s	5mm/s	150mm/min
Geruchsarmes Resin							
Empfohlene Einstellungen	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000 \pm 10%	4500 \pm 10%	3500 \pm 10%	3300 \pm 10%	4000 \pm 10%	3200 \pm 10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	20s	20s	40s	40s	40s	50s	30s
Exposure time	2.5s	2.8s	2.8s	3s	3s	3.2s	3s
Turn off delay	1s	1s	1s	2s	2s	2s	0s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	3mm/s	3mm/s	3mm/s	5mm/s	5mm/s	5mm/s	60mm/min
Retract speed	3mm/s	3mm/s	3mm/s	5mm/s	5mm/s	5mm/s	150mm/min

Wasserlösliches Resin							
Empfohlene Einstellungen	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000±10%	4500±10%	3500±10%	3300±10%	4000±10%	3200±10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	20s	20s	40s	40s	40s	50s	30s
Exposure time	3.2s	3s	2.8s	3s	3s	3.2s	3s
Turn off delay	1s	1s	1s	2s	2s	2s	0s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	3mm/s	3mm/s	3mm/s	5mm/s	5mm/s	5mm/s	60mm/min
Retract speed	3mm/s	3mm/s	3mm/s	5mm/s	5mm/s	5mm/s	150mm/min
Wasserlösliches Resin PLUS							
Empfohlene Einstellungen	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000±10%	4500±10%	3500±10%	3300±10%	4000±10%	3200±10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	20s	20s	40s	50s	50s	50s	40s
Exposure time	2.5s	2s	2.5s	2.5s	2.5s	3s	2s
Turn off delay	1s	1s	1s	2s	2s	2s	0s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	3mm/s	3mm/s	3mm/s	5mm/s	5mm/s	5mm/s	60mm/min
Retract speed	3mm/s	3mm/s	3mm/s	5mm/s	5mm/s	5mm/s	150mm/min
(Zahn-)Medizinisches Modell-Resin							
Empfohlene Einstellungen	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000±10%	4500±10%	3500±10%	3300±10%	4000±10%	3200±10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	20s	20s	30s	40s	40s	50s	30s
Exposure time	2.3s	2.5s	2.5s	2.8s	2.8s	3.2s	2.4s
Turn off delay	1s	1s	3s	3s	3s	3s	3s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	1mm/s	1mm/s	1mm/s	5mm/s	5mm/s	5mm/s	60mm/min
Retract speed	3mm/s	3mm/s	1mm/s	5mm/s	5mm/s	5mm/s	150mm/min
Resin für Schmuck							
Empfohlene Einstellungen	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000±10%	4500±10%	3500±10%	3300±10%	4000±10%	3200±10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	65s	60s	65s	65s	65s	60s	50s
Exposure time	5.5s	5s	5.5s	5.5s	5.5s	5s	4s
Turn off delay	5s	5s	5s	5s	5s	5s	5s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	1mm/s	1mm/s	1mm/s	1mm/s	1mm/s	1mm/s	50mm/min
Retract speed	1mm/s	1mm/s	5mm/s	1mm/s	1mm/s	1mm/s	150mm/min

(Zahn-)Medizinisches Resin							
Empfohlene Einstellungen	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000±10%	4500±10%	3500±10%	3300±10%	4000±10%	3200±10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	65s	60s	60s	65s	65s	60s	50s
Exposure time	5.5s	5s	6.5s	5.5s	5.5s	5s	4s
Turn off delay	5s	5s	5s	5s	5s	5s	5s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	1mm/s	1mm/s	1mm/s	1mm/s	1mm/s	1mm/s	50mm/min
Retract speed	1mm/s	1mm/s	1mm/s	1mm/s	1mm/s	1mm/s	150mm/min
Hochtemperatur Resin							
Empfohlene Einstellungen	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000±10%	4500±10%	3500±10%	3300±10%	4000±10%	3200±10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	50s	50s	50s	50s	50s	50s	30s
Exposure time	3.2s	2.8s	2.5s	2.8s	2.8s	3.2s	2.4s
Turn off delay	5s	5s	5s	5s	5s	5s	5s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	5mm/s	5mm/s	3mm/s	5mm/s	5mm/s	5mm/s	60mm/min
Retract speed	5mm/s	5mm/s	3mm/s	5mm/s	5mm/s	5mm/s	150mm/min
ABS-ähnliches Resin							
Empfohlene Einstellungen	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000±10%	4500±10%	3500±10%	3300±10%	4000±10%	3200±10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	20s	20s	40s	40s	40s	50s	30s
Exposure time	2.5s	2.8s	3s	3s	3s	3.2s	3s
Turn off delay	1s	1s	3s	2s	2s	2s	2s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	3mm/s	3mm/s	3mm/s	1mm/s	1mm/s	1mm/s	50mm/min
Retract speed	3mm/s	3mm/s	3mm/s	1mm/s	1mm/s	1mm/s	150mm/min
Hochstabiles Resin							
Empfohlene Einstellungen	HALOT-ONE PRO 3K	HALOT-ONE PLUS 4K	HALOT-MAX 4K	HALOT-LITE 4K	HALOT-SKY 6K	HALOT-ONE 3K	LD-006 4K
Lichtintensität in ($\mu\text{W}/\text{cm}^2$):	5000±10%	4500±10%	3500±10%	3300±10%	4000±10%	3200±10%	o.A.
Layer thickness	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm	0.05mm
Initial exposure	40s	40s	50s	60s	60s	50s	30s
Exposure time	3.2s	2.8s	3.2s	2.8s	2.8s	3.2s	2.4s
Turn off delay	1s	1s	3s	3s	3s	3s	3s
Rising height	7mm	7mm	7mm	7mm	7mm	7mm	5mm
Motor speed	1mm/s	1mm/s	1mm/s	1mm/s	1mm/s	1mm/s	50mm/min
Retract speed	3mm/s	3mm/s	1mm/s	1mm/s	1mm/s	1mm/s	150mm/min

Tips:

1. Wenn Sie andere Drucker Modelle verwenden, beziehen Sie sich auf die Tabelle für die Druckparameter von Druckern mit ähnlichen oder identischen Lichtintensitäten.
2. Die Belichtungszeit von transparentem Resin ist etwas länger als bei anderen Farbhärten derselben Harzart.