

Anycubic High Clear Resin

Recommended Printing Parameters

Printer Model	Layer Thickness	Exposure Time	Light-Off Time	Bottom Exposure Time	Bottom Layer	Anti-Aliasing Level	Z Lift Distance	Z Lift Speed	Z Retract Speed
Photon Mono M7 Pro	0.05mm	4s	2s	25s	4	1	8mm	6mm/s	6mm/s
Photon Mono M5s Pro (Normal printing mode)	0.05mm	4s	0.5s	35s	5	1	8mm	6mm/s	6mm/s
Photon Mono M5s Pro (Fast printing mode)	0.1mm	4.5s	0.5s	35s	5	1	5mm	20mm/s	20mm/s
Photon Mono M5s (Normal printing mode)	0.05mm	5s	0.5s	35s	5	1	8mm	6mm/s	6mm/s
Photon Mono M5s (Fast printing mode)	0.1mm	6s	0.5s	40s	4	1	5mm	20mm/s	20mm/s
Photon Mono M5	0.05mm	5s	0.5s	35s	5	1	8mm	6mm/s	6mm/s

Photon M3 Max	0.05mm	4.5s	2.5s	30s	6	1	10mm	2mm/s	3mm/s
Photon Mono X 6Ks	0.05mm	4s	0.5s	20s	5	1	8mm	2mm/s	3mm/s
Photon Mono X2	0.05mm	4s	0.5s	25s	5	1	8mm	2mm/s	3mm/s
Photon Mono 2	0.05mm	4.5s	1s	25s	5	1	6mm	4mm/s	6mm/s
Photon D2	0.05mm	4.5s	1s	35s	4	4	5mm	2mm/s	2mm/s
Photon M3 Plus	0.05mm	4s	0.5s	28s	4	1	6mm	6mm/s	6mm/s
Photon M3	0.05mm	4s	0.5s	25s	4	1	6mm	3mm/s	4mm/s
Photon M3 Premium	0.05mm	4s	0.5s	25s	3	1	8mm	6mm/s	6mm/s
Photon Ultra	/	/	/	/	/	/	/	/	/
Photon Mono X	0.05mm	4s	0.5s	28s	4	1	8mm	2mm/s	3mm/s

Photon Mono 4K	0.05mm	4s	0.5s	40s	6	1	6mm	4mm/s	6mm/s
Photon Mono X 6K	0.05mm	4s	0.5s	28s	6	1	8mm	2mm/s	3mm/s
Photon Mono SQ	/	/	/	/	/	/	/	/	/
Photon Mono SE	/	/	/	/	/	/	/	/	/
Photon Mono	0.05mm	4s	0.5s	40s	6	1	6mm	4mm/s	6mm/s
Photon S	0.05mm	12s	1s	60s	6	1	6mm	3mm/s	3mm/s