

Lodden 3D Printer Resin Liquid Manual

Printing Setting

NO.	材料类型 Resin Type	层高 Layer Height(m m)	底层数 Bottom Layer Count	曝光时间 Exposure Time/s	底部曝光 时间 Bottom Exposure Time/s	过渡图层 数 Transition Layer Count	灭灯延时 Light-off Delay	提升距离 Lifting Distance /mm	回程距离 Retract Distance /mm	抬升速度 -mm/min Lifting Speed	回程速度 mm/min Retract Speed
1	Model Resin(Water Washable Clean)	0.05	3	3.4	25	8	1	8	8	150	240
2	Model Resin(IPA Clean)	0.05	3	3.6	25	8	1	8	8	150	240
3	Ortho Model Resin(IPA Clean)	0.05	5	3	25	\	\	6	8	100	150
4	Ortho Model Resin(Water Washable Clean)	0.05	5	3	25	\	\	6	8	90	150
5	High Precision Planting Model Gray	0.05	3	3.1	30	8	1	8	8	120	180
6	High Precision Planting Model Yellow	0.05	3	4.0	35	8	1	8	8	120	180
7	Temporary Restoration Resin	0.05	3	4.5	35	10	1.5	8	8	90	150
8	Permanent Crowns Resin(20% Ceramics)	0.05	3	4.0	40	10	2	8	8	60	120
9	Permanent Crowns Resin(55% Ceramics)	0.05	3	4.6	45	10	3	8	8	45	90
10	Fixed Hybrid Dentures Resin	0.05	3	4.6	45	10	3	8	8	45	90
11	Gingiva Mask Resin	0.5	5	5.5	25	\	\	6	8	90	150
12	Denture Base Resin	0.05	3	4.0	30	10	1.5	8	8	120	180
13	Flexible Denture Base Resin	0.05	3	5.0	40	10	1.5	8	8	120	180
14	Surgical guide Resin	0.05	3	3.0	20	8	1	8	8	120	180
15	Hard Splint Resin	0.1	3	5.5	50	8	1.5	8	8	90	120
16	Soft Splint Resin	0.1	3	5.5	50	8	1.5	8	8	90	120
17	4D Clear Aligners Resin	0.1	3	7.5	50	10	2	8	8	60	120
18	IBT Resin	0.05	3	4.5	35	8	1.5	8	8	90	120
19	D-Cast Resin	0.05	3	5.0	40	10	1	8	8	120	180
20	Tray Resin	0.5	5	5	25	\	\	6	8	90	150

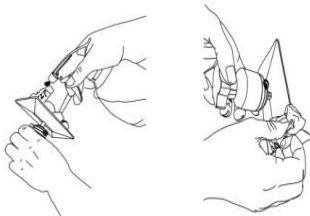
Resin Type	Rinse	Rough/Fine cleaning time/min	Curing method	Recommended curing energy	Curing time /min	Remarks
Model resin	IPA/Water	2+3	Double-sided curing	10-20mw/cm ²	6	
Ortho Model Resin	IPA/Water	2+3	Double-sided curing	10-20mw/cm ²	3	
High Precision Planting Model	IPA	2+3	Double-sided curing	10-100mw/cm ²	4	
				100-200mw/cm ²	3	
Temporary Restoration	IPA	3+3	Double-sided curing	10-50mw/cm ²	5	Curing is recommended at 45 °C
Permanent Crowns 20%	IPA	2+2	Double-sided curing	10-50mw/cm ²	5	Curing is recommended at 45 °C
Permanent Crowns 55%	Use a toothbrush or bristle brush dipped in IPA to clean	No residual resin on the surface	Double-sided curing	10-50mw/cm ²	5	Curing is recommended at 45 °C
Fixed Hybrid Dentures	Use a toothbrush or bristle brush dipped in IPA to clean	No residual resin on the surface	Double-sided curing	10-50mw/cm ²	5	
Gingiva Mask Resin	IPA	2+3	Double-sided curing	10-20mw/cm ²	10-15s (The unit of measurement is seconds.)	It is recommended to cure in water
Denture Base Resin	IPA	3+3	Double-sided curing	10-50mw/cm ²	5	Curing is recommended at 45 °C
Flexible Denture Base	IPA	3+3	Double-sided curing	10-50mw/cm ²	2-5	Curing is recommended at 45 °C
Surgical Guide	IPA	2+2	Single-sided curing	10-30mw/cm ²	2	Curing is recommended at 45 °C
Hard splint	IPA	3+3	Single-sided curing	50-100mw/cm ²	60	
				100-300mw/cm ²	20-30	
Soft Splint	IPA	3+3	Single-sided curing	50-100mw/cm ²	60	
				100-300mw/cm ²	20-30	
4D Clear Aligner Resin	IPA	4+3	Single-sided curing	100-200mw/cm ²	60	
				200-500mw/cm ²	20-30	
IBT	IPA	3+3	Single-sided curing	50-100mw/cm ²	60	
				100-300mw/cm ²	20-30	
D-Cast	IPA	2+1	/	/	/	
Tray Resin	IPA	2+2	Double-sided curing	10-20mw/cm ²	3-5	It is recommended to cure in water

Curing time may vary slightly depending on machine model (curing intensity)

Cleaning and Post-curing



1. Take off the printing platform from the printer.



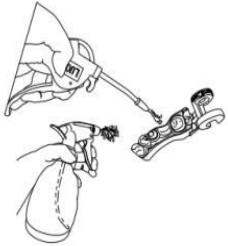
2. Spray isopropanol (alcohol > 95%) to clean away residue resin on the prints, wipe off the resin with tissue on the platform.



Spray alcohol again then dry it, repeat a few times still no resin on surface.



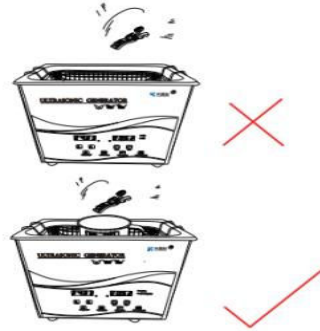
Carefully take off the prints from platform with scraper



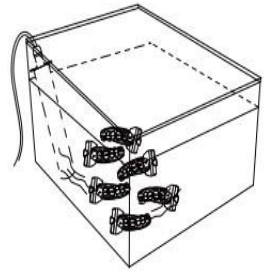
Repeat step 3.



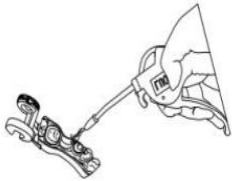
Place the workpiece into a container with alcohol, the alcohol should fully



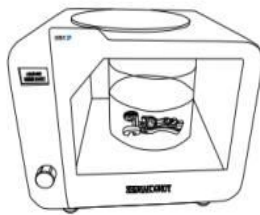
Put the container into ultrasonic machine, clean for 1-2 mins.



If no ultrasonic cleaner, try to use an ultrasonic rod, Clean for 5-10 mins.



Take out the prints and dry immediately with an air gun or blower.



Suggest to do post curing in water, curing time depends on the light power of the curing box, (Curing time 30-60s, curing both sides).