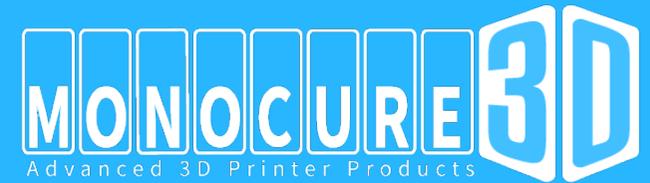


# CHEATSHEET

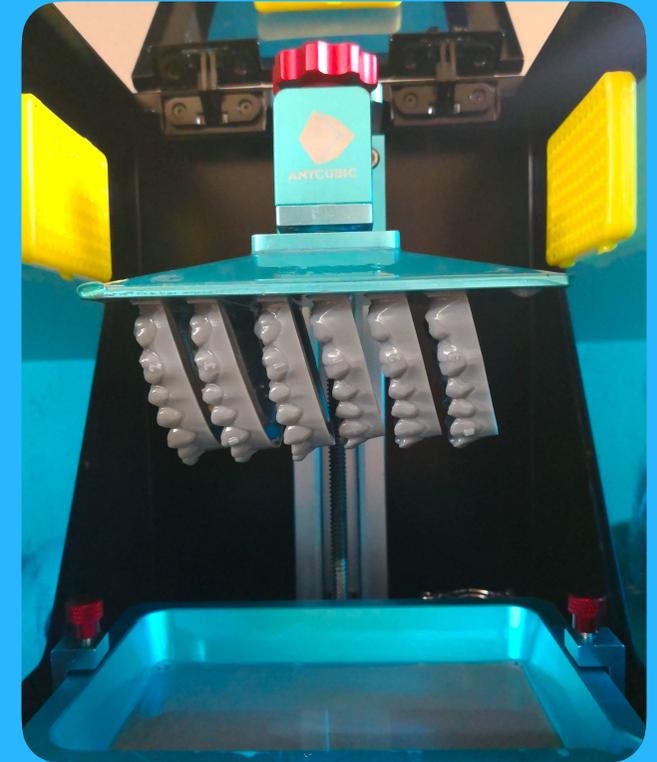
## MONOCURE 3D ANYCUBIC PHOTON



### Introduction

Congratulations on your AnyCubic Photon purchase! I know you will be happy with this well designed LED printer, especially when using our Monocure 3D Rapid Resin! This Cheat Sheet will help you get the best out of your Photon when using our advanced Rapid Resin System. Our different Rapid colours will print more or less the same, with only occasional minor setting adjustments needed.

The information provided should be enough to get you printing like a PRO in no time. All our products can be purchased directly from our [website](#) or our friendly [resellers](#).



### What printer settings should I start with?

Resin Type: Monocure RAPID (all colours)

Layer thickness: 0.05 (mm)

Normal exposure time: 11 seconds\*

Off Time: 6.5 seconds

Bottom Exposure Time: 60 seconds

Bottom Layers: 4

\* These settings are a guide only as your environment & printer can change the way the resin reacts when cured.

### Should I sand the build plate?

The Anycubic Photon comes with a painted powder-coated aluminium build plate as standard.

The blue painted surface doesn't give the resin the best chance of adhesion onto the build plate. This is especially the case with any pigmented resins. To help with this, you may choose to remove the paint to expose the bare aluminium. This is best done by using masking tape to stick a piece of 240 grit sandpaper to a completely flat surface (Glass is perfect), then rub your build plate back and forth until all the paint is removed. Using an electric sander is not recommended as it could make the build plate surface uneven and potentially not completely flat. I understand your reluctance to sand the build plate. It's just so frustrating that Anycubic decided to paint it!

### How should I handle the resin?

- \* Shake the bottle well before every use.
- \* Store the resin in a dark cool place.
- \* Clean parts and spills with [RESINAWAY](#) or IPA.
- \* Filter Resin back into the bottle when not printing.
- \* Post-cure using a 405nm light to avoid yellowing.

### Important things to remember!

- ★ Home printer correctly
- ★ Avoid using rafts or bases
- ★ Use an Angled Model Position
- ★ Use lots of thick supports
- ★ Sand your build plate (See left)
- ★ KISS (Keep it Simple)

Having Problems? Have you downloaded our [Calibration Models](#) yet? Please contact us on our website for [technical support](#).