

CHEATSHEET

MONOCURE 3D RAPID RESIN PHROZEN SHUFFLE & XL



Introduction

Congratulations on your Phrozen Shuffle purchase! I know you will be happy with this great 3D printer, especially when using our Monocure 3D Rapid Resin. It was formulated with over 30 years of UV polymer experience and is manufactured in our own factory located in Sydney, Australia.

This Cheat Sheet will help you get the best out of your Shuffle 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 Shuffle comes with its own great slicing software. The information provided in this sheet should be enough to get you printing like a professional in no time. You can buy our resin from our [website](#) or our friendly [resellers](#).



What printer settings should I start with?

Resin Type: Monocure 3D RAPID (all colours)*

Layer Height: 50 microns

Base layers: 4 x 60 Seconds

Normal Layers: 7 Seconds

Lift Distance: 4mm

Wait after Print: 1 Second

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

When & how do I change the FEP Film?

1. The FEP film can last for a long time as long as you look after it. Be careful not to use sharp objects when getting stuck models off the film as it is very easily damaged or punctured. When you see the FEP starting to look cloudy or damaged with scratches or gouges, it's time to change it.

2. Remove the vat from the printer and turn it over. Using the correct sized screwdriver, unscrew all the visible screws around the edge of the vat. Carefully remove and dispose of the old FEP film by lifting the surrounding metal plate. Get your new FEP sheet, remove any protective film and lay flat on top of the vat. Place the metal holding plate on top of the FEP. Then start replacing the screws from the middle and then the opposite side - repeat. There is no need to pre make holes for screws. As you go, pull the film tight and only screw in halfway. Once finished, fully tighten the screws. The FEP should be tight, and make a drum-like sound when you tap lightly it with a finger. Clean off any marks with soft, lint-free cloth.

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
- ★ Keep your FEP sheet fresh
- ★ Avoid using rafts or bases
- ★ Angled Model Position
- ★ Use lots of thick supports
- ★ Clean up with [RESINAWAY](#)
- ★ Post Cure with a 405nm LED light
- ★ KISS (Keep it Simple)

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