HARZ Labs
MATERIALS FOR 3D PRINTING

Loading profiles into the slicer

Abstract

Loading profiles into Chitubox

The Chitubox slicer supports a large number of different printers and works with profiles in .cfg format. You can download profiles for printers that are compatible with Chitubox on our website in the «Support» section by clicking on the purple button «Download settings file».

Picture 1. Downloading the profile from website.

After downloading the profile and selecting the desired printer type in the slicer, open «Settings», then find the «Import Profile» button. After that, select the downloaded profile in .cfg format in the opened window.

Picture 2-3. Profile import process.

HARZ Labs
MATERIALS FOR 3D PRINTING

After importing the profile, you can click on the triangle next to the resin name and a drop-down list with all available settings will open.
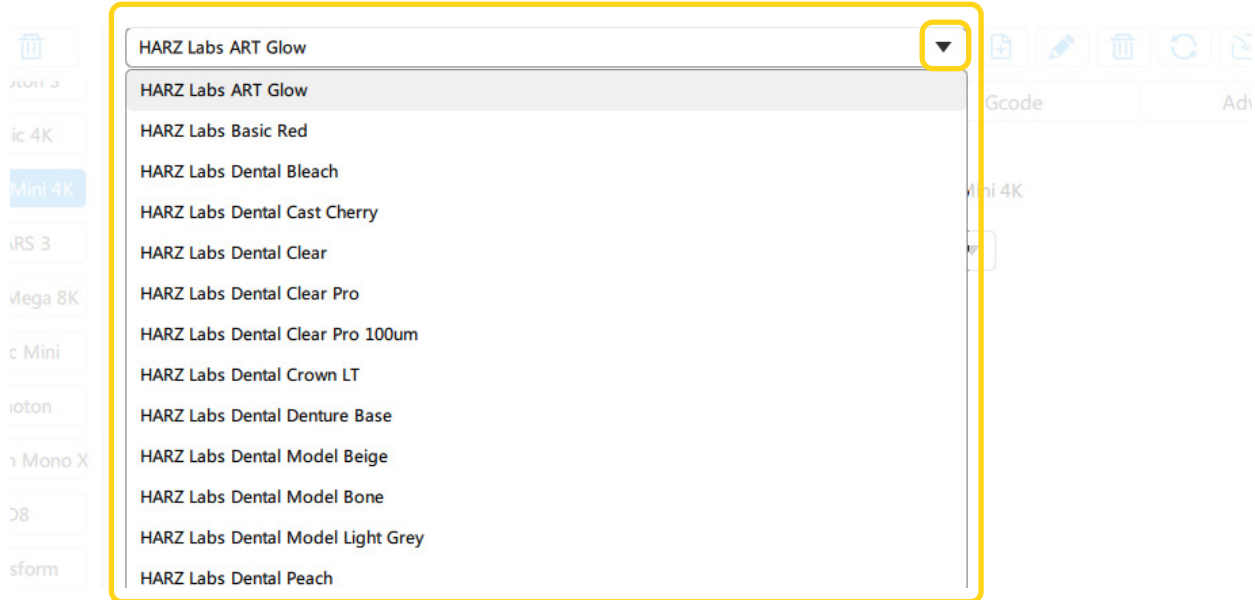
Picture 4. List of imported settings.

Transferring settings to Chitubox manually

In addition to importing profile, you can manually transfer settings to the Chitubox slicer from the table available on the website. The table with the settings can be found in the Support section by selecting your model from the list of printers.

Picture 5-6. List of printers from the «Support» section and the table with settings.

To manually transfer the settings to the Chitubox slicer, you need to open the «Settings» tab of the slicer. Next, in the settings tab click «Add new profile» button.

Picture 7-8. The process of adding a new profile.

In the settings list, you will see a duplicated profile with a symbol «*» at the end of its name. You can rename it by clicking «Change profile name». And then, in the window on the left, enter the name you like. We recommend to name the profiles according to the name of the resin and the thickness of the layer, in order to simplify the search in the future.

Picture 9. Profile name change icon.

After you have changed the profile name, you can transfer the settings from the table. You can do it according to the following scheme of matching the name of the parameters from the table on the site and the Chitubox slicer.

Name on the website of parameter	Name of parameter in the Chitubox slicer
50, 100, 200 µm *	Layer Height
Bottom Layer Count, pcs	Bottom Layer Count
Exposure time 50µm, sec	Exposure Time
Bottom Exposure Time 50µm, sec	Bottom Exposure Time
Light-off Delay, sec **	Light-off Delay
Lifting distance, mm	Bottom Lift Distance / Lifting Distance
Lifting speed, mm/min ***	Bottom Lift Speed / Lifting speed
Retract Speed, mm/min ****	Bottom Retract Speed / Retract Speed

Table 1. Transferring values from the website to the Chitubox slicer.

* «Layer Height».

Select above the table with three buttons («50μm», «100μm», «200μm»).

Resin	Bottom Layer Count, pcs	Exposure time 50μm, sec	Bottom Exposure Time 50μm, sec	Light-off Delay, sec	Lifting distance, mm	Lifting speed, mm/min	Retract Speed, mm/min
Basic Red	2	4	40	5	5	60	60
Dental Bleach	2	4.3	40	6	5	180	180

<div align="center">Picture 10. Selecting the layer height on the site.</div>

**«Pause at bottom position».

Corresponds to the «Light-off Delay» parameter in the slicer. Alternatively, you can change the «Waiting Mode During Printing» parameter to «Resting Time», in which case the «Pause at bottom position» parameter will correspond to the «Rest Time After Retract» parameter in the slicer. (This applies to the Phrozen company printers).

***«Lifting distance».

Corresponds to the parameter «Bottom Lift Distance» and «Lifting Distance» in the slicer (only the first column should be filled in).
Duplicated parameters
The parameters are set separately for bottom and normal layers.

**** «Retract Speed».

These are the «Bottom Retract Speed» and «Retract Speed» parameters (this parameter can be set 1.5 times higher than the «Lift Speed».

You can use these parameters (both the downloaded file and the manually transferred settings from the table) as a starting point. To calibrate the printer accurately, print our exposure test and use our user manual (Support - Print - How to use the HARZ Labs test?).

Loading profiles into Lychee

The Lychee slicer also has a large list of printers, and you can upload configurations of settings to it. This slicer accepts many profile formats, including .lyr and .cfg. You can download profiles for printers that are compatible with Lychee on our website in the «Support» section by clicking on the purple «Download settings file» button.

Picture 11. Downloading the profile from website.

After downloading the profile, you need to open the settings in the slicer by clicking on the «3D Printer» button.

Picture 12. The «3D Printer» button in the Lychee slicer.

After selecting the desired printer, you need to go below to the «Resin - Printing Settings» tab and at the bottom click «Add New Resin». Then, at the bottom, «Import from File», then «Add files» and select the downloaded profile.
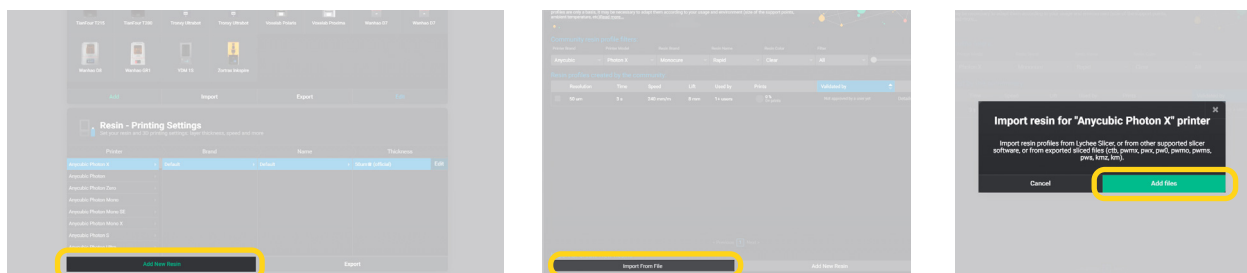
Picture 13-15. Profile loading process.

HARZ Labs
MATERIALS FOR 3D PRINTING

After loading, in the window that opens, you can select from the list for which resins you want to load the settings. Then click on the «Import» button at the bottom. As a result, the loaded profiles will appear in the «Resin - Printing Settings» tab.
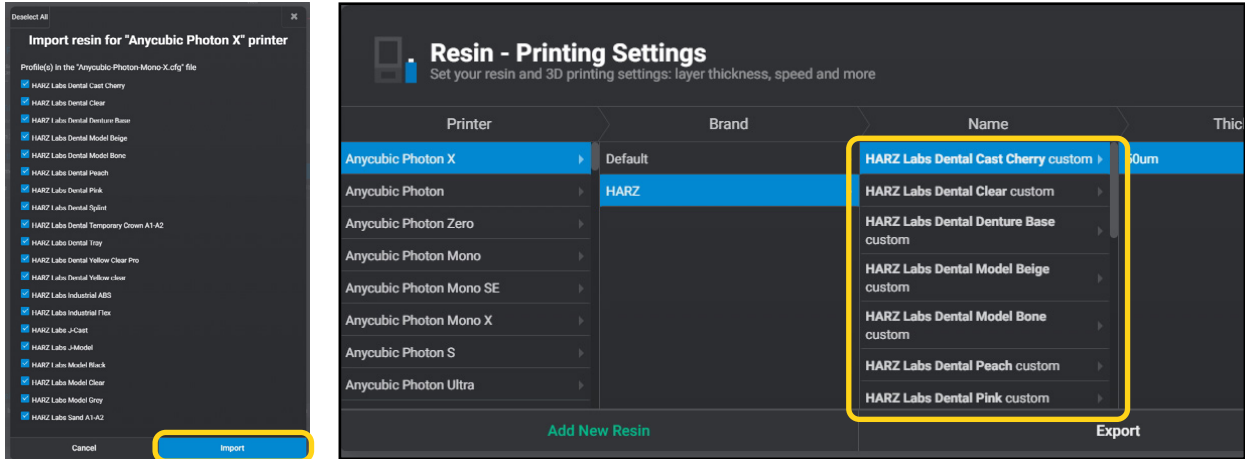
Picture 16-17. The final stage of loading.

Transferring settings to Lychee manually

In addition to uploading profiles, you can also manually transfer settings to Lychee from the table available on the website. The settings table can be found in the «Support» section by selecting the printer you have from the list of printers.

Picture 18-19. List of printers from the «Support» section and the table with settings.

To manually transfer the settings to the Lychee slicer, click on the «3D Printer» button in the slicer.

Picture 20. The «3D Printer» button in the Lychee slicer.

After selecting the desired printer, you should go below to the «Resin - Printing Settings» tab and at the bottom click on the «Add New Resin» button. Next, in the window that appears, you should fill in all the necessary fields according to the following scheme of matching the names of the parameters on the website and from the Lychee slicer.
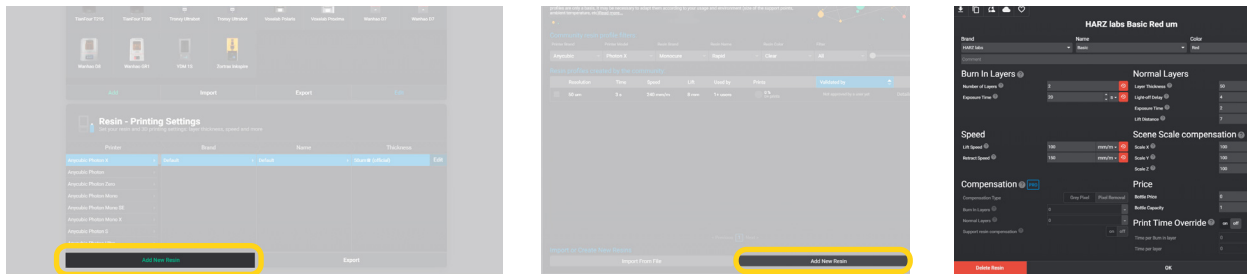
Picture 21-23. The process of transferring settings manually.

Name on the website of parameter	Name of parameter in the Lychee slicer
50, 100, 200 μm *	Layer Thickness
Resin	Brad/Name/Color
Bottom Layer Count, pcs	Number of Layers (Burn In Layers)
Exposure time 50μm, sec	Exposure Time (Normal Layers)
Bottom Exposure Time 50μm, sec	Exposure Time (Burn In Layers)
Light-off Delay, sec	Light-off-Delay (Normal Layers)
Lifting distance, mm	Lift Distance (Normal Layers)
Lifting speed, mm/min	Lift Speed (Speed)
Retract Speed, mm/min	Retract Speed (Speed)

Table 2. Transferring values from the website to the Lychee slicer.

* «Layer Height»

Select above the table with three buttons («50μm», «100μm», «200μm»).

Picture 24. Selecting the layer height on the website.

After entering all the settings, press the «OK» button and the settings appear in the settings list.
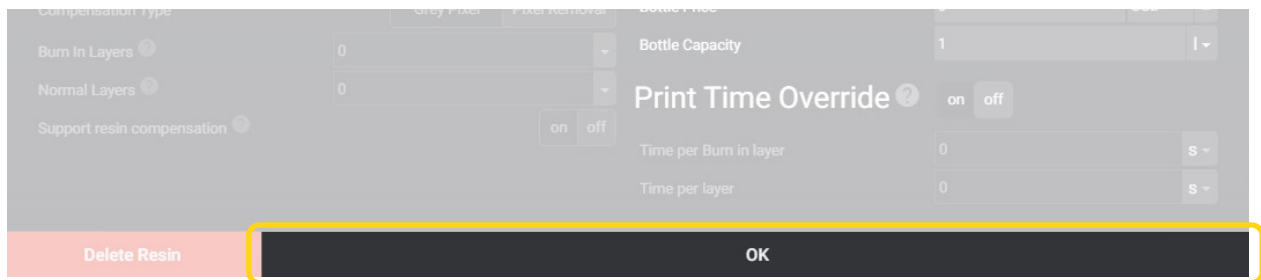
Picture 25. Confirmation of selection.

You can use these parameters (both the downloaded file and the manually transferred settings from the table) as a starting point. To calibrate the printer accurately, print our calibration test and use our user manual (Support - Print - How to use the HARZ Labs test?).

Transferring settings to Formware 3D manually

You can manually transfer settings to the Formware 3D slicer from the table available on the website. The settings table can be found in the «Support» section by selecting the printer you have from the list of printers.

Picture 26. List of printers from the «Support» section and the table with settings.

To transfer settings to Formware 3D slicer manually, choose «File» - «Configuration» menu. In the window that appears, find the icon with a plus sign and click on it. A new «50 Micron» will be added to the list of profiles, click it twice with the left mouse button.

Picture 27. Creating a profile.

У вас откроется меню редактирования профиля. Рекомендуем сразу задать название в соответствующем поле. Далее, вносить настройки предстоит во вкладках «Layer Thickness» и «Movement & exposure».
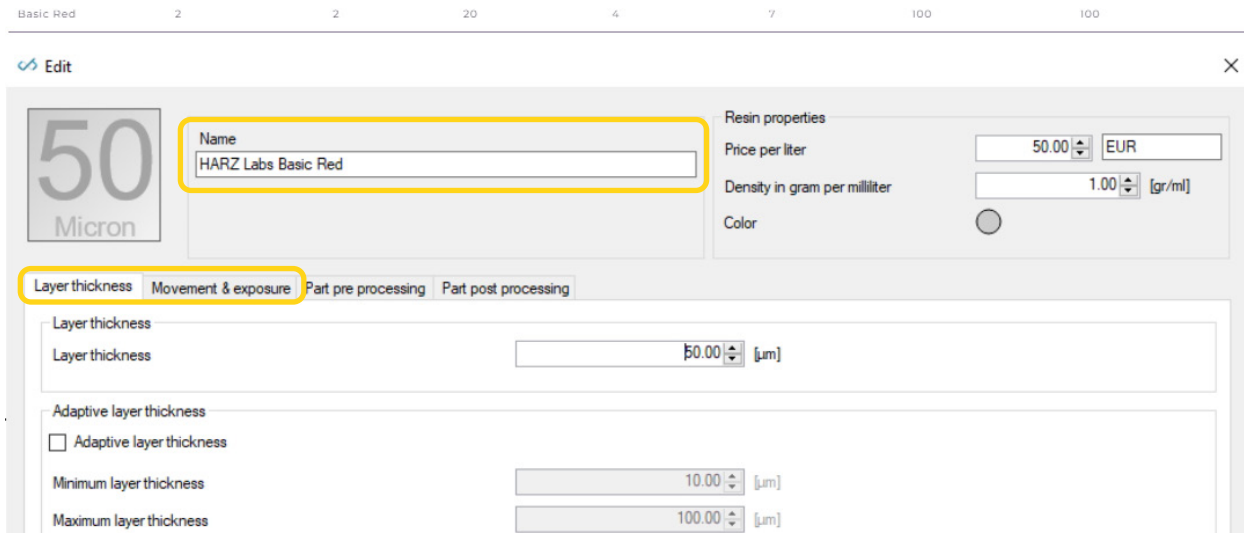
Picture 28. Editing parameters.

In the tab «Layer Thickness» you have to enter a value only for the parameter «Layer Thickness», and then go to the tab «Movement & exposure» and enter the other parameters there. Note that in this slicer, the time parameters are presented in milliseconds (1s = 1000ms).

Name on the website of parameter	Name of parameter in the Formware 3D slicer
50, 100, 200 μm *	Layer Thickness
Resin	Name
Bottom Layer Count, pcs	Bottom layers
Exposure time 50μm, sec	Exposure time
Bottom Exposure Time 50μm, sec	Exposure bottom layers
Light-off Delay, sec	Rest time after retract / off time
Lifting distance, mm	Z Lift Distance / Z Lift Distance Bottom
Lifting speed, mm/min	Z Lift Speed (peel) / Z Bottom Speed (peel)
Retract Speed, mm/min	Z Retract Speed (back in resin) / Z Retract Speed Bottom (back in resin)

Table 3. Transferring values from the website to the Formware 3D slicer.

* «Layer Height»

Select above the table with three buttons («50μm», «100μm», «200μm»).

Picture 29. Selecting the layer height on the website.

After entering all the settings, press the «OK» button. You can use these parameters as a starting point. To calibrate the printer accurately, print our calibration test and use our user manual (Support - Print - How to use the HARZ Labs test?).

Transferring settings to the HALOT BOX and PIOCREAT BOX manually

You can manually transfer the settings to the HALOT BOX and PIOCREAT BOX slicers from the table available on the website under «Support». Select the printer that you have from the list.

Picture 30. List of printers from the «Support» section and the table with settings.

Select your printer in the slicer, add any model, and click the «Slice» tab. In this tab, on the side menu under «Basic Options», click on the drop-down list with the profiles and click on «Add» button.
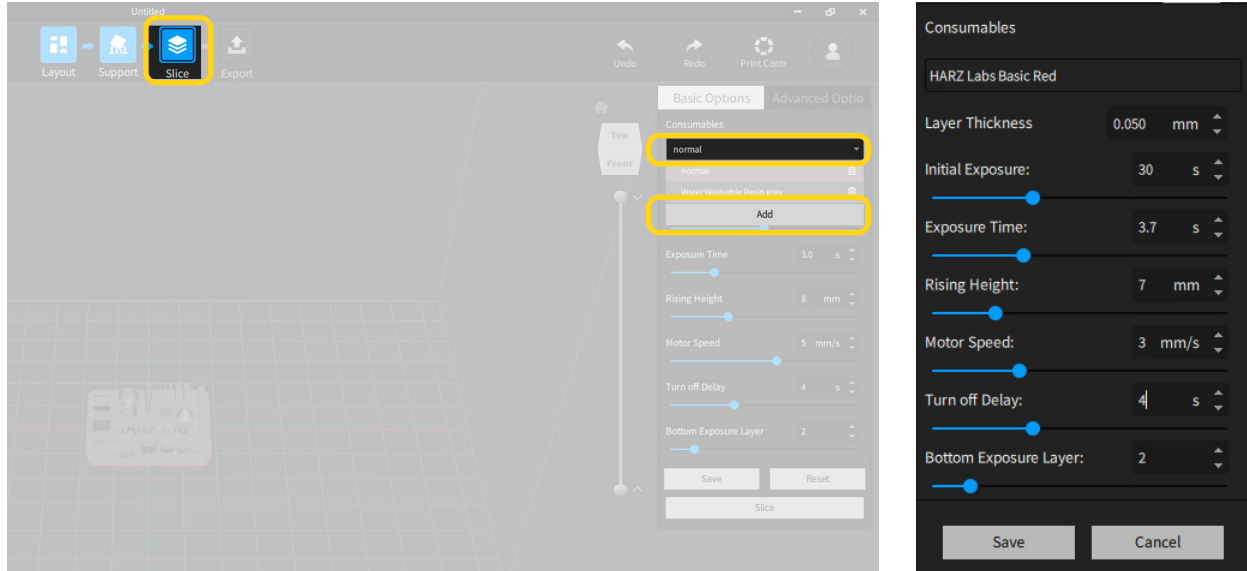
Picture 31. The window for entering values.

Next, in the window that opens, you must enter the name of the material and fill in all the required fields on the scheme below the correspondence of the parameters from the table on the site and in the slicers.

Name on the website of parameter	Name of parameter in the HALOT BOX and PIOCREAT BOX slicers
50, 100, 200 μm *	Layer Thickness
Bottom Layer Count, pcs	Bottom Exposure layers
Exposure time 50μm, sec	Exposure time
Bottom Exposure Time 50μm, sec	Initial Exposure
Light-off Delay, sec	Turn off Delay
Lifting distance, mm	Rising Height
Lifting speed, mm/min **	Motor Speed
Retract Speed, mm/min ***	Motor Speed

Table 4. Transferring values from the website to the HALOT BOX and PIOCREAT BOX slicers.

* «Layer Height»
Select above the table with three buttons («50µm», «100µm», «200µm»).

Picture 32. Selecting the layer height on the website.

** «Lifting speed»
Pay attention that the speed in the slicer and the speed in the table are differs in dimension (1 mm/s = 60 mm/min).

*** «Retract speed»
Pay attention that the speed in the slicer and the speed in the table are differs in dimension (1 mm/s = 60 mm/min).

After you press the «Save» button, the settings will appear in the list of profiles.
In the same way, you can transfer the settings to the printer screen.
You can use these parameters as a starting point. To calibrate the printer accurately, print our calibration test and use our user manual (Support - Print - How to use the HARZ Labs test?).

Transferring settings to the Phrozen OS web interface

Some of the Phrozen printers have a built-in web interface where you can adjust print settings. Such printers need to be connected to a computer via the local network and the settings need to be changed via a browser.

The settings in the Phrozen OS web interface can be manually transferred from the table available on the website. The settings table can be found in the «Support» section by selecting the printer you have from the list of printers.

Picture 33. List of printers from the «Support» section and the table with settings.

To transfer the settings to the Phrozen OS web interface manually, you need to connect to the web interface and go to the «Profile» tab. Pay attention that in the Phrozen OS web interface, the time parameters are presented in millisecond dimensions (1s = 1000ms).
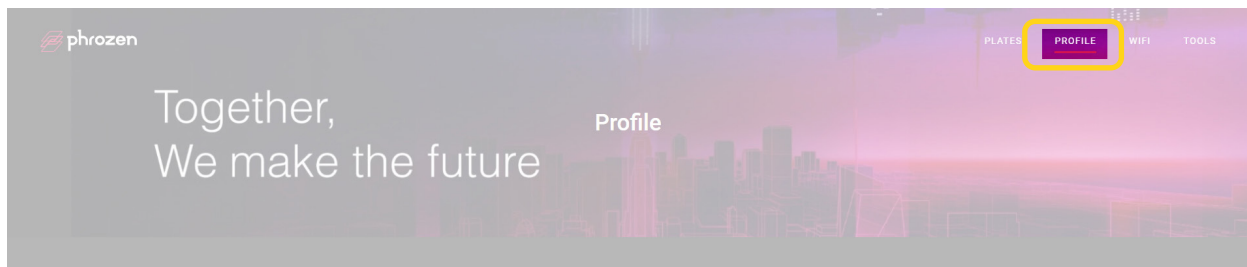
Picture 34. The "Profile" tab.

Next, in the window that opens, you need to fill in all the necessary fields. You can do it according to the following scheme of matching the names of the parameters from the table on the website and from the web interface of the Phrozen OS.
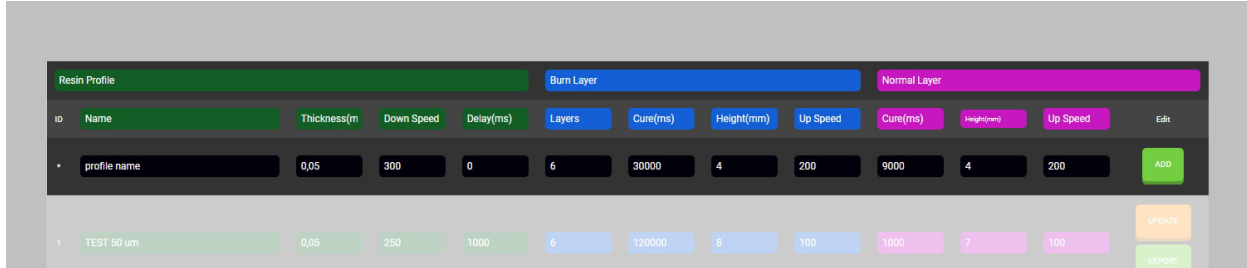
Picture 35. Entering values.

Name on the website of parameter	Name of parameter in the Phrozen OS
50, 100, 200 µm *	Thickness (Resin Profile)
Resin	Name (Resin Profile)
Bottom Layer Count, pcs	Layers (Burn Layer)
Exposure time 50µm, sec	Cure (ms) (Normal Layer)
Bottom Exposure Time 50µm, sec	Cure (ms) (Burn Layer)
Light-off Delay, sec	Delay (ms) (Resin Profile)
Lifting distance, mm	Height (mm) (Burn Layer / Normal Layer)
Lifting speed, mm/min	Up Speed (Burn Layer / Normal Layer)
Retract Speed, mm/min	Down Speed

Table 5. Transferring values from the website to the Formware 3D slicer.

*«Layer Height»
Select above the table with three buttons («50µm», «100µm», «200µm»).

Picture 36. Selecting the layer height on the website.

After entering all the settings, press the green «Add» button, and profile will appear in the list below.

You can use these parameters as a starting point. To calibrate the printer accurately, print our calibration test and use our user manual (Support - Print - How to use the HARZ Labs test?)

Loading profiles in Asiga Composer

The Asiga Max UV 385 printer is controlled by its own slicer - Asiga Composer. This slicer uses its own configuration file format «.ini». You can download the profiles for this printer from our website. To do this, go to the «Support» section and find the Asiga MAX UV 385 at the bottom of the printers list.

PRINT SETTINGS

Anet N4	Anycubic Photon	Anycubic Photon Mono	Anycubic Photon Mono 4K	Anycubic Photon Mono SE	Anycubic Photon Mono X
Anycubic Photon Mono X 6K	Anycubic Photon S	Anycubic Photon Ultra	Anycubic Photon Zero	Creality Halot Max	Creality Halot One
Creality Halot One Plus	Creality Halot One Pro	Creality Halot Sky	Creality LD-002R	Elegoo Mars	Elegoo Mars 2 Pro
ELEGOO Mars 3	Elegoo Mars C	Elegoo Saturn	Elegoo Saturn 2 8k	EPAX X1	EPAX X10
EPAX X133	EPAX X156 4K	FlashForge Hunter	Hardlight Sirius	Hardlight Sirius black light	Hardlight Sirius XL 8.9-4M
Hardlight SIRIUS XL Black 8,9" 4K	Hardlight SIRIUS XL Black light 8,9" 4K	Kelant Orbeat S400	Longer Orange 10	Longer Orange 30	Longer Orange 40
Longer Orange 4K	Monoprice Mini	Peopoly Phenom	Peopoly Phenom L	Peopoly Phenom Noir	Phrozen Shuffle 2018
Phrozen Shuffle 2019	Phrozen Shuffle 4k	Phrozen Shuffle Lite	Phrozen Shuffle XL 2018	Phrozen Shuffle XL 2019	Phrozen Sonic
Phrozen Sonic 4K	Phrozen Sonic Mega 8K	Phrozen Sonic Mighty 4K	Phrozen Sonic Mighty 8K	Phrozen Sonic Mini	Phrozen Sonic Mini 4K
Phrozen Sonic Mini 8K	Phrozen Sonic XL 4K	Phrozen Transform	Pionext DJ89	Prusa SL1	QIDI S-box
SainSmart Kumitsu KL9	SparkMaker	SparkMakerFHD	Tronxy Ultrabot	UNIZ SLASH 2	UNIZ SLASH DJ2
UNIZ SLASH PLUS	UNIZ SLASH PRO	UNIZ zSLTV-15	UNIZ zSLTV-23	Wanhao D7	Wanhao D8
Wanhao Gadoso GR1					
Nextdent 5100	Formlabs Form2	Asiga MAX UV 385	Shining Accufab D1S	Shining Accufab L4D	

Picture 37. List of printers from the «Support» section.

Next, click the purple «Download Archive» button. The downloaded archive must be unzipped into any folder that is convenient for you.

ACADEMY
PRINTING PREFERENCES
OUR PRODUCTS
POST-PROCESSING
PRINT
MATERIAL OVERVIEW
PURCHASE

PRINT SETTINGS FOR ASIGA MAX UV 385

If you have questions about how to load profiles into a slicer, use guide. To accurately calibrate your printer, use our calibration test, which you can learn more about in our test guide.

Download archive

Picture 38. "Download archive" button.

To load profiles, open the slicer and in the printer selection window, click on the gear icon next to the name of the print profile, and then hover over the «Import» icon and click «Composer». Then a dialog box will open in which you can select the desired file.
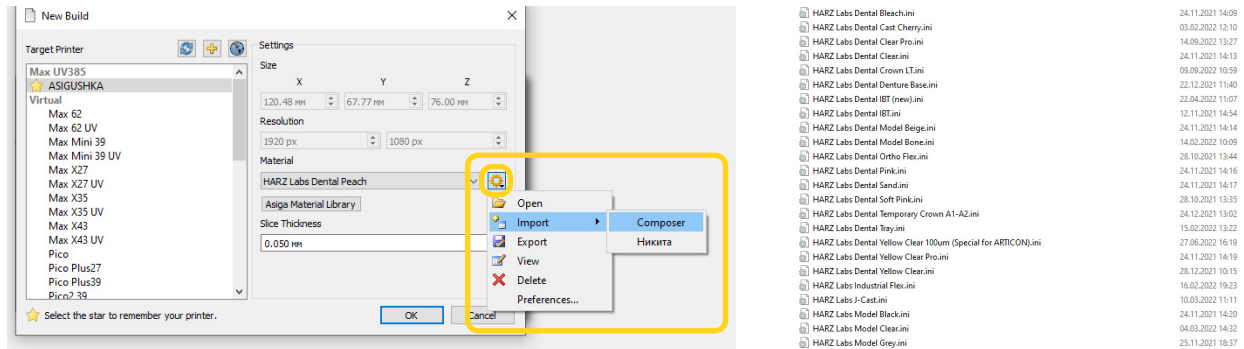
Picture 39. Importing a profile into the slicer.

After selecting the file, a window, which confirming that the profile has been uploaded will appear on the screen. You need to click on «Ok». Now the profile is loaded into the printer, you can select it from the drop-down list by clicking on the triangle icon next to the name.
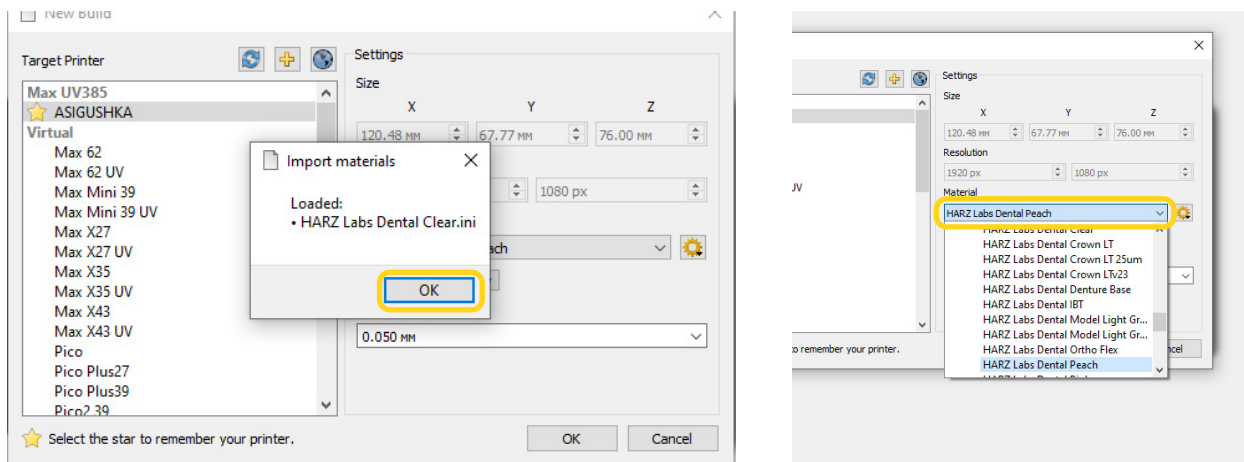
Picture 40. Selecting a profile.

You can use these parameters as a starting point. To calibrate the printer accurately, print our calibration test and use our user manual (Support - Print - How to use the HARZ Labs test?)

Loading profiles into Accuware

Shining printers use their own slicer into which you can upload setup profiles. You can download profiles for Shining printers from our website.

To do this you need to go to the «Support» section and find Shining printers in the list of printers.

|					
ELEGOO Mars 3	Elegoo Mars C	Elegoo Saturn	Elegoo Saturn 2 8k	EPAX X1	EPAX X10
EPAX X133	EPAX X156 4K	FlashForge Hunter	Hardlight Sirius	Hardlight Sirius black light	Hardlight Sirius XL 8.9-4M
Hardlight SIRIUS XL Black 8,9" 4K	Hardlight SIRIUS XL Black light 8,9" 4K	Kelant Orbeat S400	Longer Orange 10	Longer Orange 30	Longer Orange 40
Longer Orange 4K	Monoprice Mini	Peopoly Phenom	Peopoly Phenom L	Peopoly Phenom Noir	Phrozen Shuffle 2018
Phrozen Shuffle 2019	Phrozen Shuffle 4k	Phrozen Shuffle Lite	Phrozen Shuffle XL 2018	Phrozen Shuffle XL 2019	Phrozen Sonic
Phrozen Sonic 4K	Phrozen Sonic Mega 8K	Phrozen Sonic Mighty 4K	Phrozen Sonic Mighty 8K	Phrozen Sonic Mini	Phrozen Sonic Mini 4K
Phrozen Sonic Mini 8K	Phrozen Sonic XL 4K	Phrozen Transform	Pionext DJ89	Prusa SL1	QIDI S-box
SainSmart Kumitsu KL9	SparkMaker	SparkMakerFHD	Tronxy Ultrabot	UNIZ SLASH 2	UNIZ SLASH DJ2
UNIZ SLASH PLUS	UNIZ SLASH PRO	UNIZ zSLTV-15	UNIZ zSLTV-23	Wanhao D7	Wanhao D8
Wanhao Gadoso GR1					
Nextdent 5100	Formlabs Form2	Asiga MAX UV 385	Shining Accufab D1S	Shining Accufab L4D	

Picture 41. List of printers from the «Support» section.

Next, click the purple «Download Archive» button. The downloaded archive must be unzipped into any folder that is convenient for you.
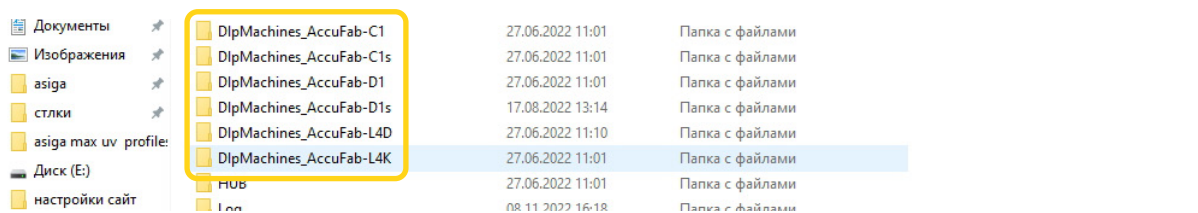

ACADEMY
PRINTING PREFERENCES
OUR PRODUCTS
POST-PROCESSING
PRINT
MATERIAL OVERVIEW
PURCHASE
SHIPPING

PRINT SETTINGS FOR SHINING ACCUFAB D1S

If you have questions about how to load profiles into a slicer, use guide. To accurately calibrate your printer, use our calibration test, which you can learn more about in our test guide.

Download archive

Picture 42. "Download archive" button.

To download the profiles, open the folder with the unzipped profiles and copy all the profiles in it. Next, go to the folder «My Documents» and find the folder «3DDlpDocuments3» and enter it. Here you need to go into the folder with the name of your printer.

| Документы | DlpMachines_AccuFab-C1 | 27.06.2022 11:01 | Папка с файлами |
Изображения	DlpMachines_AccuFab-C1s	27.06.2022 11:01	Папка с файлами
asiga	DlpMachines_AccuFab-D1	27.06.2022 11:01	Папка с файлами
стлки	DlpMachines_AccuFab-D1s	17.08.2022 13:14	Папка с файлами
asiga max uv profile:	DlpMachines_AccuFab-L4D	27.06.2022 11:10	Папка с файлами
Диск (E:)	DlpMachines_AccuFab-L4K	27.06.2022 11:01	Папка с файлами
настройки сайт	HUB	27.06.2022 11:01	Папка с файлами
	Log	08.11.2022 16:18	Папка с файлами

Picture 43. Folder with printer name.

Here you will find another folder called «Material». Paste the previously copied settings profiles into it.
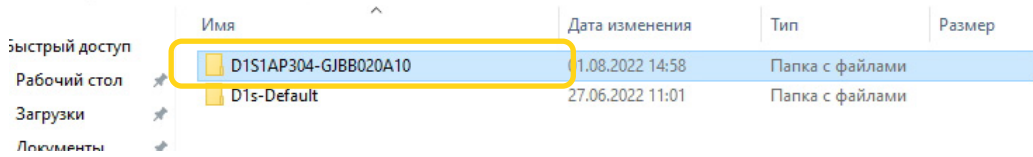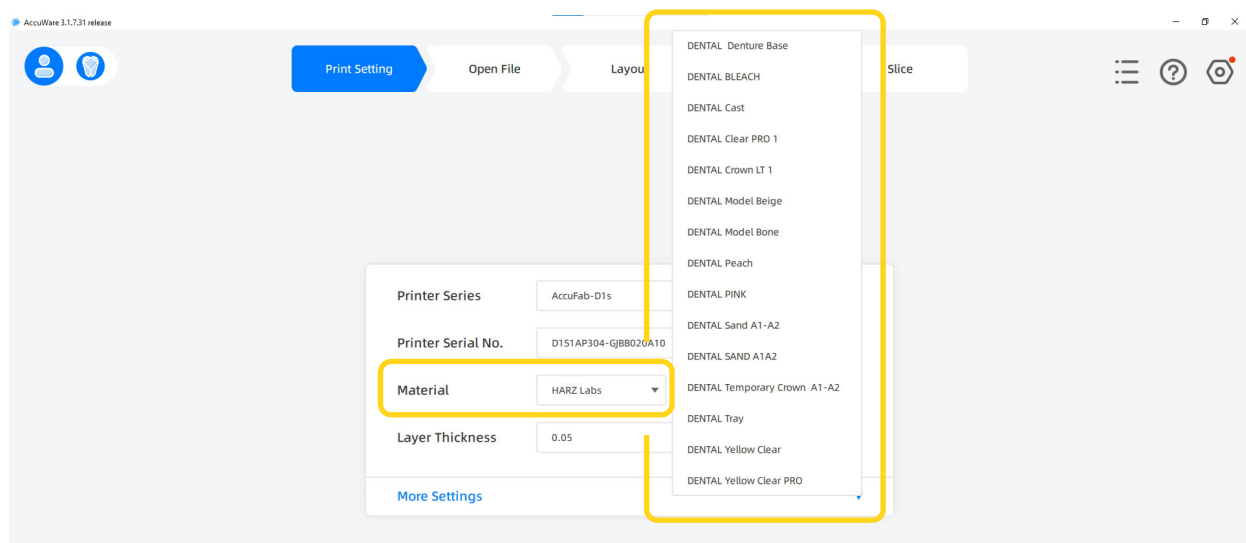

Picture 44. Printer serial number folder.

Here you will find another folder called «Material». Paste the previously copied settings profiles into it.
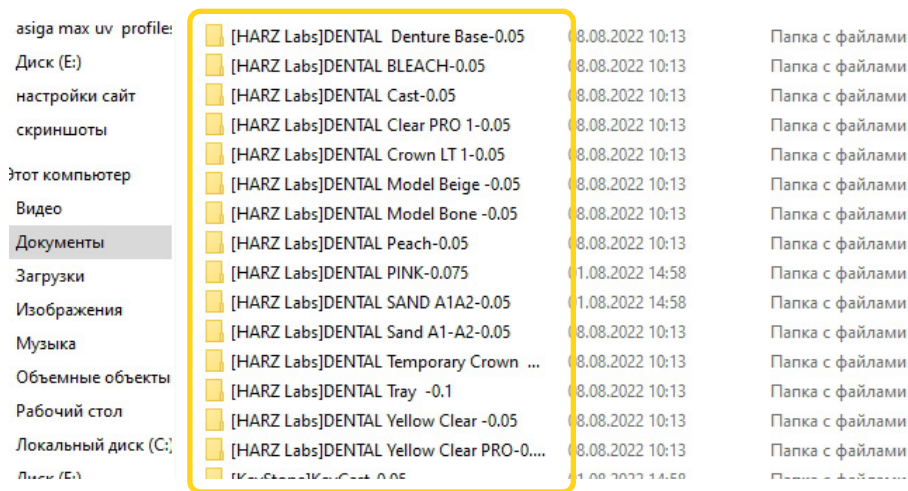
Picture 45. Transferring profiles to the «Materials» folder.

It remains to select the desired printing mode in the slicer and print a calibration test to check the settings.


Picture 46. Profiles in the slicer.

You can use these parameters as a starting point. To calibrate the printer accurately, print our calibration test and use our user manual (Support - Print - How to use the HARZ Labs test?)

Getting access to Engineer Mode

Initially the slicer Accuware is closed and you can't make adjustments to the resin parameters. In order to get access to changing parameters, the first thing you need to do is register an account on the official Accufab website and open Engineer Mode.

Open the Accuware slicer and log in to your registered account. To do this, press the profile button in the upper left corner of the slicer and follow the instructions. If you don't have an account yet, select «Online registration» in the form that appears and follow the instructions. Or you can register your account at the following link: https://www.shining3d.com/solutions/accufab-d1/
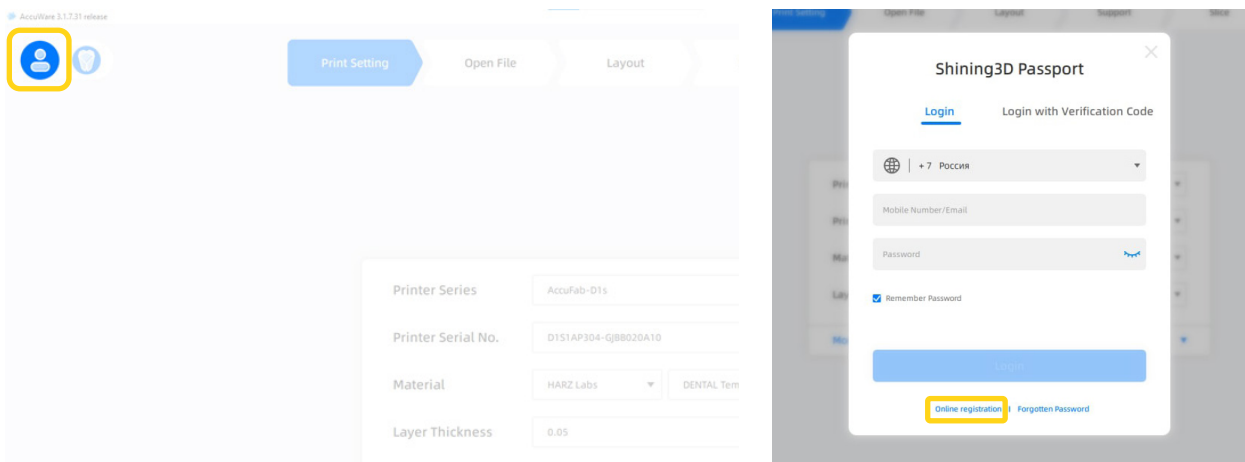

Picture 47-48. Signing in to your account.

After logging in, activate Engineer Mode by clicking the «Activate» button. Next, in the window that opens, enter the profiles for which you want to open the settings (example: HARZLabs-Dental Clear) and click «Submit».
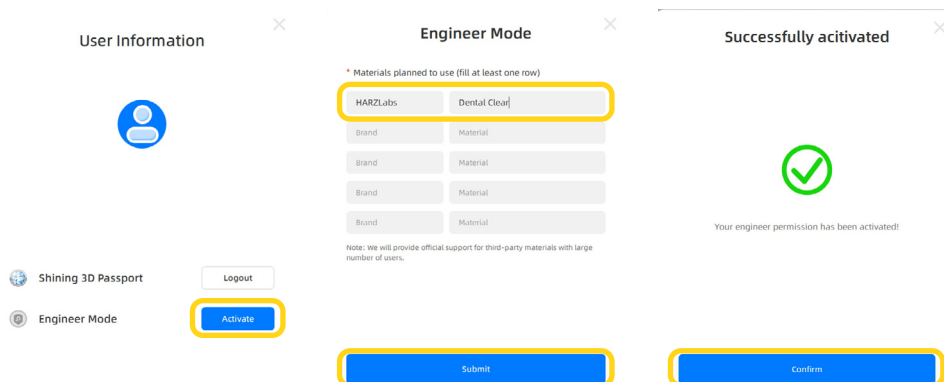
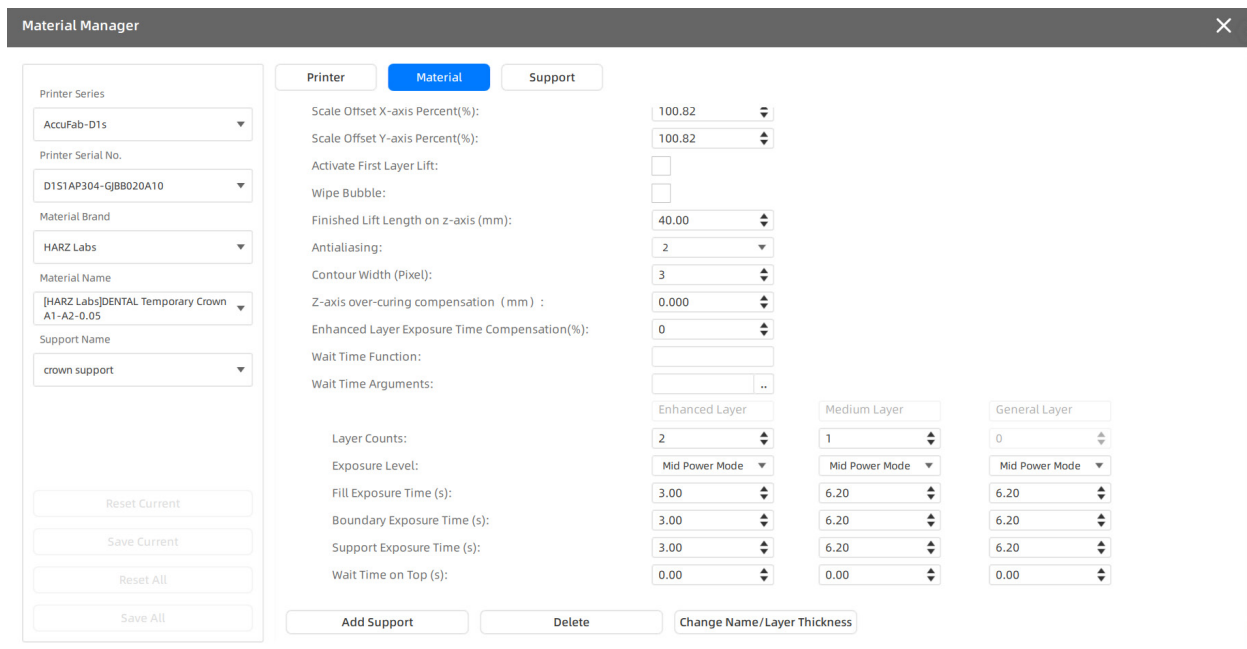Picture 49-51. Activating Engineer Mode.

Once Engineer Mode is activated, we can open the «Material Manager» and change the settings in the profile we want. In order to do this, you need to press the gear button in the upper right corner of the slicer, and click on the «Material Manager» menu.
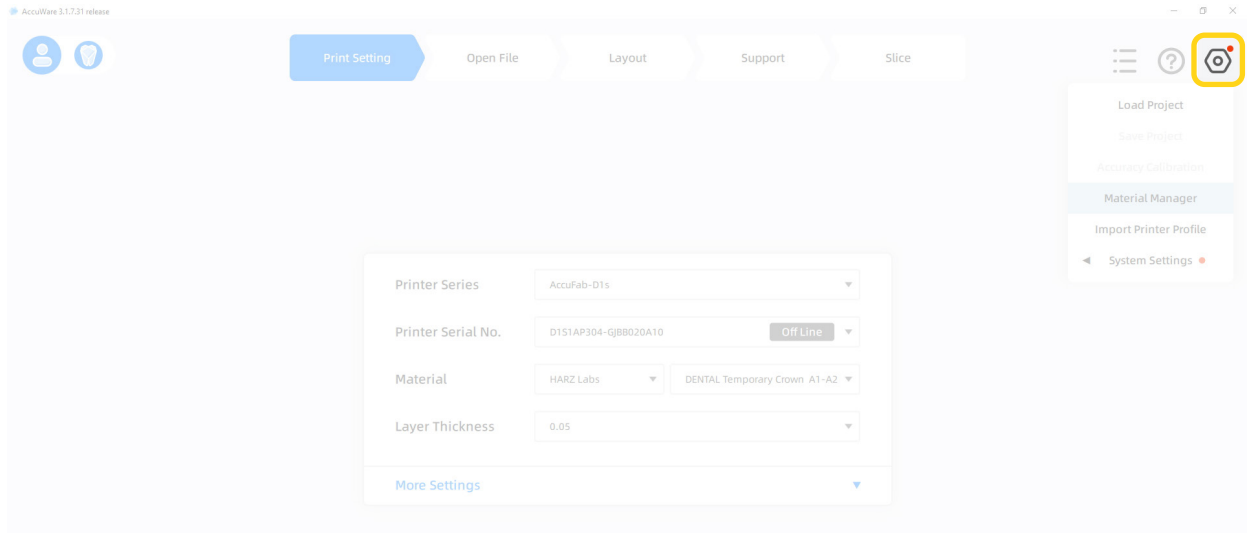
Picture 52. Entering the «Material Manager» menu.

This menu allows you to make adjustments to the profile settings depending on your needs and preferences.

Picture 53. The «Material Manager» menu, with «Engineer Mode» activated.

HARZ Labs

MATERIALS FOR 3D PRINTING

harzlabs.com
support@harzlabs.com