

3D Printing Parameters														
Part Number	Name	Resin Used	Printer Used	Layer Height	Bottom Layer Count	Exposure Time	Bottom Exposure Time	Light-off Delay	Bottom Light-off Delay	Bottom Lift distance (mm)	Lifting Distance (mm)	Bottom Lift Speed (mm/min)	Lifting Speed (mm/min)	Retract Speed (mm/min)
Part 1.1	Knob	Anycubic Black Resin	Elegoo Saturn	0.05	8	1.5	50	0.5	0.5	6	6	180	180	240
Part 2	Oxymeter	Anycubic Grey Resin	Anycubic Mono X and Elegoo Saturn	0.05	8	1.5	50	0.5	0.5	6	6	180	180	240
Part 3	Inner Flow Gauge	Anycubic Clear Resin	Anycibic Mono X	0.05	8	2	50	0.5	0.5	6	6	180	180	240
Part 4	Indicator	Anycubic Black Resin	Elegoo Saturn	0.05	8	1.5	50	0.5	0.5	6	6	180	180	240

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