

[illegible]

Note: These are recommended values based on our experience or user feed but are not absolute. Individual factors such as temperature, leveling and others affects how resin cures, please adjust values as needed for your situation.

To learn about to find optimal exposure, please use this guide:
<https://beoool.dozuki.com/Guide/Moai++How-to-find-resin-exposure+time/4>

	Type	Color	Layer Height (um)	Moi Laser Seti	Moi 200 Laser Setting	Print Speed	Initial layer height (um)	Initial layer print spee	initial slower layr	Contributor	Notes
Peopoly	Moi Resin	Gray Blue Red	100	57-58	58	85	100	5	2	Peopoly	Recommend update to new firmware setting of pm motor speed 20 and z motor speed 6. please refer http://wiki.peopoly.net/doku.php?id=moi:firmware&s[]=firmware
Peopoly	Moi Resin	Gray Blue Red	50	57-58	58	130	100	5	2	Peopoly	Recommend update to new firmware setting of pm motor speed 20 and z motor speed 6. please refer http://wiki.peopoly.net/doku.php?id=moi:firmware&s[]=firmware
Peopoly	Moi Resin	Gray Blue Red	25	57-58	58	170	100	5	2	Peopoly	Recommend update to new firmware setting of pm motor speed 20 and z motor speed 6. please refer http://wiki.peopoly.net/doku.php?id=moi:firmware&s[]=firmware
Peopoly	Moi Resin	Black White	100	58-59	59	85	100	5	2	Peopoly	Recommend update to new firmware setting of pm motor speed 20 and z motor speed 6. please refer http://wiki.peopoly.net/doku.php?id=moi:firmware&s[]=firmware
Peopoly	Moi Resin	Black White	50	58-59	59	130	100	5	2	Peopoly	Recommend update to new firmware setting of pm motor speed 20 and z motor speed 6. please refer http://wiki.peopoly.net/doku.php?id=moi:firmware&s[]=firmware
Peopoly	Moi Resin	Black White	25	58-59	59	170	100	5	2	Peopoly	Recommend update to new firmware setting of pm motor speed 20 and z motor speed 6. please refer http://wiki.peopoly.net/doku.php?id=moi:firmware&s[]=firmware
Peopoly	Moi Resin	Clear, Neon Green	50	57	57	130	100	5	2	Peopoly	Recommend update to new firmware setting of pm motor speed 20 and z motor speed 6. please refer http://wiki.peopoly.net/doku.php?id=moi:firmware&s[]=firmware
Peopoly	Moi Resin	Clear, Neon Green	100	57	57	85	100	5	2	Peopoly	Recommend update to new firmware setting of pm motor speed 20 and z motor speed 6. please refer http://wiki.peopoly.net/doku.php?id=moi:firmware&s[]=firmware
Peopoly	Moi Resin	Clear, Neon Green	25	57	57	170	100	5	2	Peopoly	Recommend update to new firmware setting of pm motor speed 20 and z motor speed 6. please refer http://wiki.peopoly.net/doku.php?id=moi:firmware&s[]=firmware
Peopoly	Nex (HiTemp)	Flesh/Skin/Grey	100	51	51	85	100	5	2		some users print at 50, it is best to use a sharp object to remove print due to high hardness
Peopoly	Nex (HiTemp)	Flesh/Skin/Grey	50	51	51	130	100	5	2		some users print at 50, it is best to use a sharp object to remove print due to high hardness
Peopoly	Nex (HiTemp)	Flesh/Skin/Grey	25	51	51	170	100	5	2		some users print at 50, it is best to use a sharp object to remove print due to high hardness
Peopoly	Nex (HiTemp)	Clear	100	54	54	85	100	5	2		Nex Clear is slightly softer than other Nex
Peopoly	Nex (HiTemp)	Clear	50	54	54	130	100	5	2		Nex Clear is slightly softer than other Nex
Peopoly	Nex (HiTemp)	Clear	25	54	54	170	100	5	2		Nex Clear is slightly softer than other Nex
Peopoly	Tough	Clear	100	51	51-52	85	100	5	2		pm motor speed 15, z motor speed, it is print to the left side to reduce peel force. use thicker support/tips
Peopoly	Tough	Clear	50	51	51-52	130	100	5	2		pm motor speed 15, z motor speed, it is print to the left side to reduce peel force. use thicker support/tips
Peopoly	Tough	Clear	25	51	51-52	170	100	5	2		pm motor speed 15, z motor speed, it is print to the left side to reduce peel force. use thicker support/tips
Peopoly	Deft	Grey, White	100	50		85	100	5	2		use same slicing profiles as regular Moi model resin, just dial down the power
Peopoly	Neo	all colors	100	49		85	100	5	2		use same slicing profiles as regular Moi model resin, just dial down the power
Nextdent	Cr & Br		100	53		85	100	5	2	D. Lee	
Nextdent	Cr & Br		50	53		130	100	5	2	D. Lee	
Nextdent	Cr & Br		25	53		170	100	5	2	D. Lee	
Nextdent	SG		100	54		85	100	5	2	D. Lee	
Nextdent	SG		50	54		130	100	5	2	D. Lee	
Nextdent	SG		25	54		170	100	5	2	D. Lee	
Nextdent	Ortho Clear		100	49		75	100	5	2	chadfroe	
Nextdent	Ortho Clear		50	49		130	100	5	2	chadfroe	
Nextdent	Ortho Clear		25	49		170	100	5	2	chadfroe	
Nextdent	C&B MFH		100	50		90	100	5	2	chadfroe	
Nextdent	C&B MFH		50	50		130	100	5	2	chadfroe	
Nextdent	C&B MFH		25	50		170	100	5	2	chadfroe	
Moonray	SG	Transparent	100	50		85	100	5	2	David WH	
Moonray	SG	Transparent	50	50		130	100	5	2	David WH	
Moonray	SG	Transparent	25	50		170	100	5	2	David WH	
MakerJuice	Waxcat	Orange	100	59		85	100	5	2	Bobby A	Not as easy to cast cleanly
MakerJuice	Waxcat	Orange	50	59		130	100	5	2	Bobby A	Not as easy to cast cleanly
MakerJuice	Waxcat	Orange	25	59		170	100	5	2	Bobby A	Not as easy to cast cleanly
MakerJuice	G+	Blue	100	54		85	100	5	2	PaulY	very high shrinkage
MakerJuice	G+	Blue	50	54		130	100	5	2	PaulY	very high shrinkage
MakerJuice	G+	Blue	25	54		170	100	5	2	PaulY	very high shrinkage
MakerJuice	SF	Red	100	53		85	100	5	2	CCox	hard to fully cured. user reported random tiny holes may appear, very thin and suspect to pigment settling and bubbles
MakerJuice	SF	Red	50	53		130	100	5	2	CCox	hard to fully cured. user reported random tiny holes may appear, very thin and suspect to pigment settling and bubbles
MakerJuice	SF	Red	25	53		170	100	5	2	CCox	hard to fully cured. user reported random tiny holes may appear, very thin and suspect to pigment settling and bubbles
Funtodo	Snow White	White	100	54		85	100	5	2	David WH	
Funtodo	Snow White	White	50	54		130	100	5	2	David WH	
Funtodo	Snow White	White	25	54		170	100	5	2	David WH	
Funtodo	Castable	pink	100	48		150	100	5	2	Bobby A	quick damages to resin
Funtodo	Castable	pink	50	48			100	5	2	Bobby A	quick damages to resin
Funtodo	Castable	pink									
Dreve	FotoDent Model	White	100	54		85	100	5	2	David WH	
Dreve	FotoDent Model	White	50	54		130	100	5	2	David WH	
Dreve	FotoDent Model	White	25	54		170	100	5	2	David WH	
Dreve	FotoDent SG	Transparent	100	52		85	100	5	2	David WH	
Dreve	FotoDent SG	Transparent	50	52		130	100	5	2	David WH	
Dreve	FotoDent SG	Transparent	25	52		170	100	5	2	David WH	
Spot-A	HT	Yellow	100	57		85	100	5	2	William L	
Spot-A	HT	Yellow	50	57		130	100	5	2	William L	
Spot-A	HT	Yellow	25	57		170	100	5	2	William L	
Siraya Tech	Fast	Grey, White, Black, C	100	50		85	100	5	2		
Siraya Tech	Simple	all colors	100	49		85	100	5	2		
		*warning									
		photocentric tough	doesn't print well and have problem stay on the plate								
Printing Guide:											
Nex HiTemp Resin	http://wiki.peopoly.net/doku.php?id=moi:nexresin										
Tough V2 Resin	http://wiki.peopoly.net/doku.php?id=moi:toughresin										