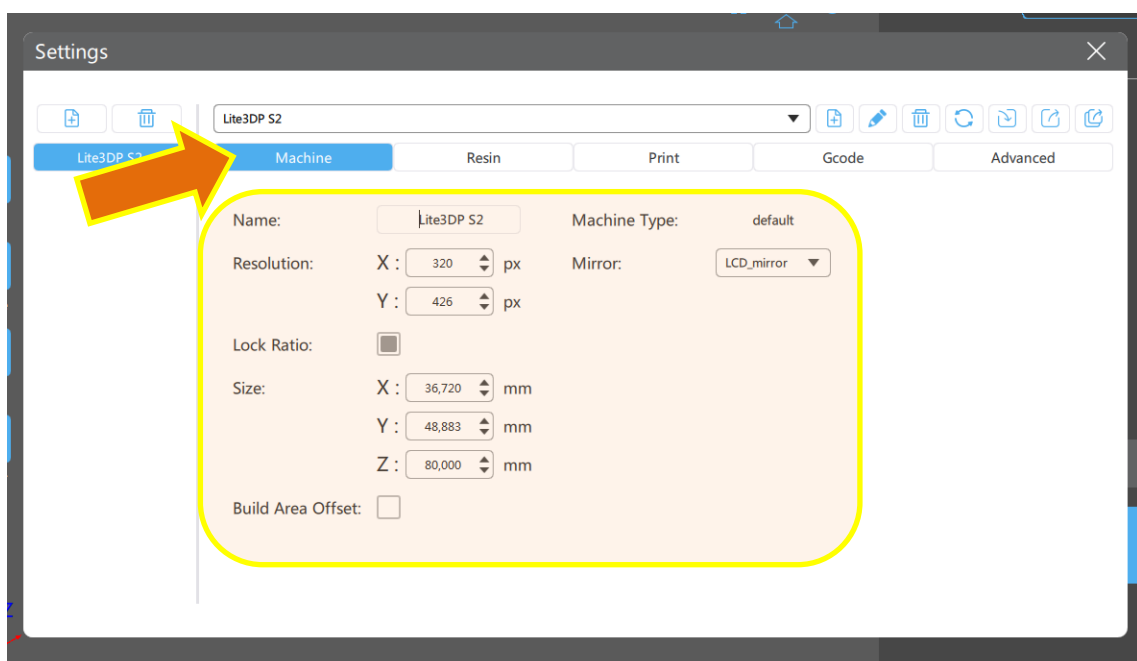
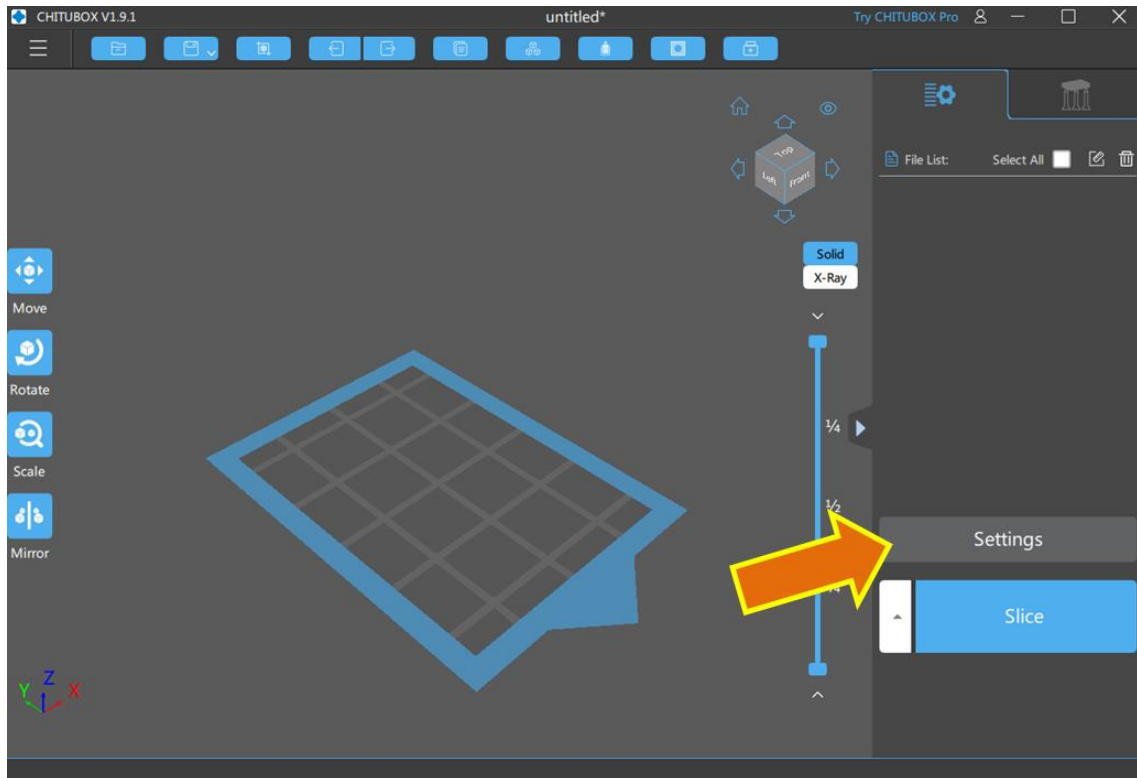


Lite3DP Gen 2

Slicer configuration

1. CHITUBOX

1) Once downloaded and installed, Lite3DP must be configured from the "settings" button (this is done only once, since the parameters are saved):



Machine tab values:

Resolution:

X: 320

Y: 426

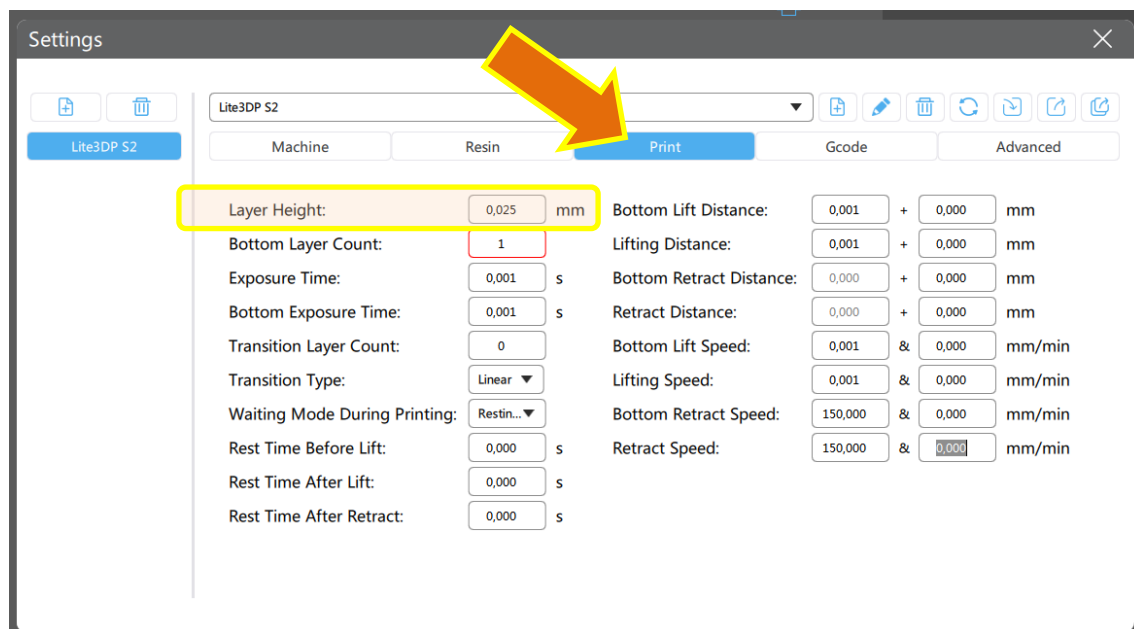
Size:

X: 36,720

Y: 48,883

Z: 80

Print tab value:



Only the **Layer Height** value should be changed, the other parameters will not affect the print job.

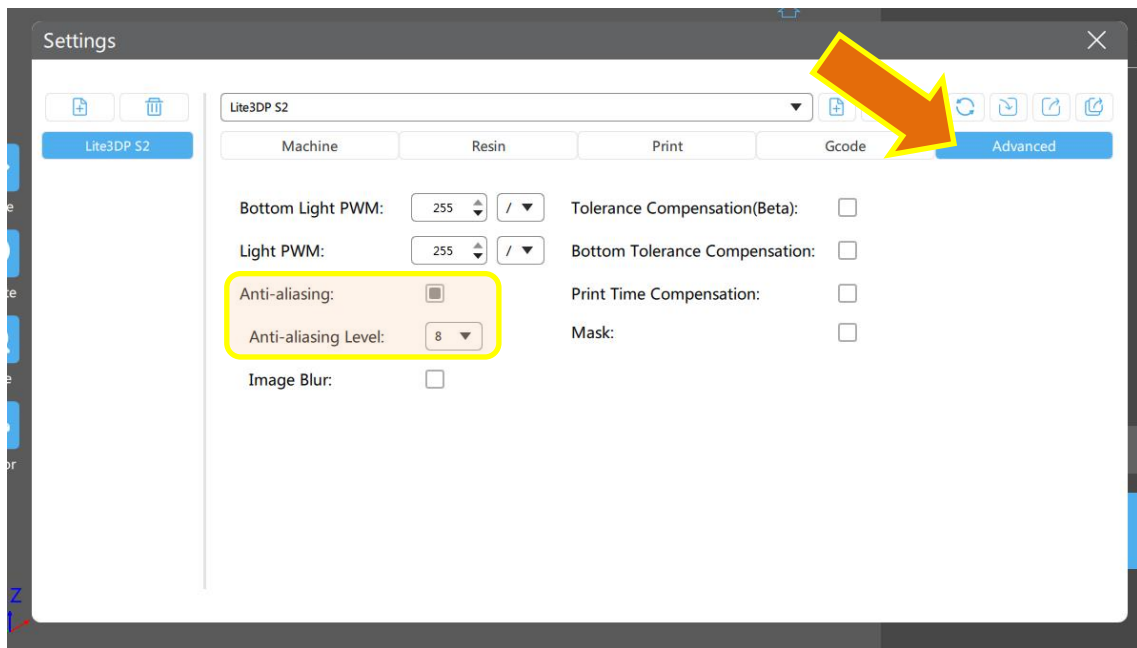
Files will always be processed with **Layer Height = 0.025 mm**.

(Lite3DP will allow you to select two other layer heights 0.05 and 0.1mm, which it will achieve by skipping images of the sections and of course moving a higher height).

Advanced tab:

Check "Anti-aliasing". **Anti-aliasing level = 8**.

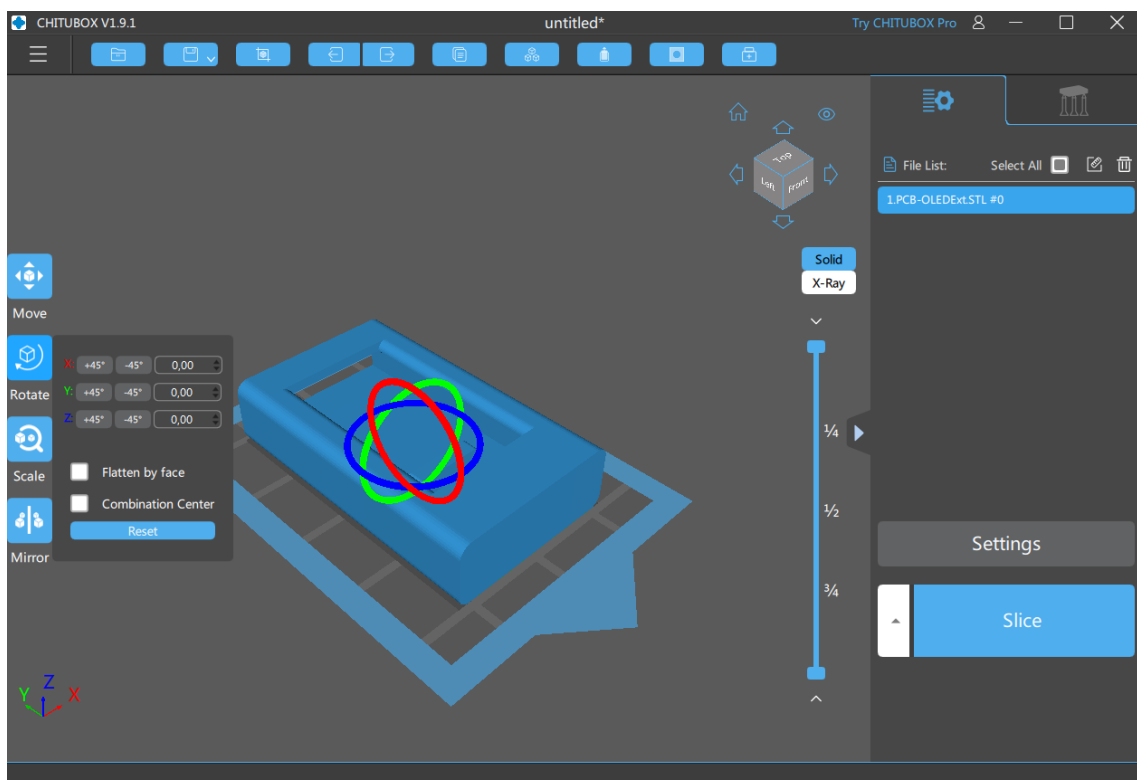
This is it, and you will not need to modify these settings again.



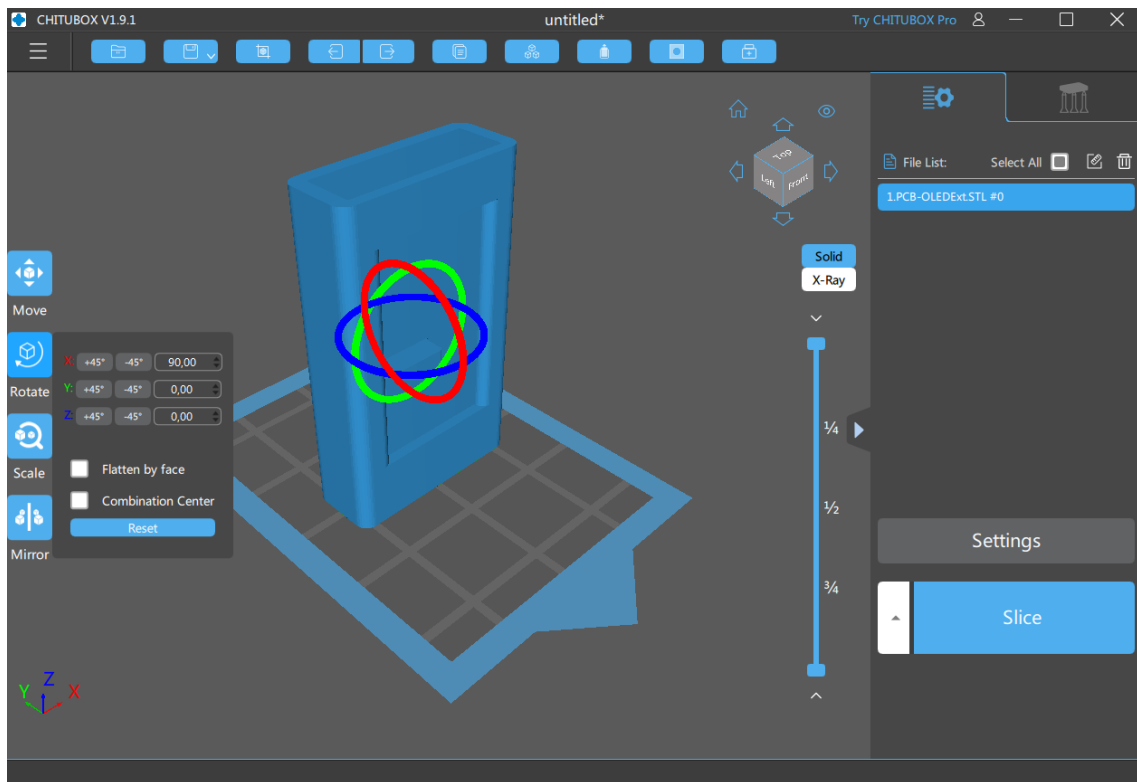
II)

To process a 3D model (STL or OBJ format), you will need to open it and position it (and scale it, if necessary) on the build platform. The rectangle in the software represents the underside of the build platform, where the part will adhere to when printed.

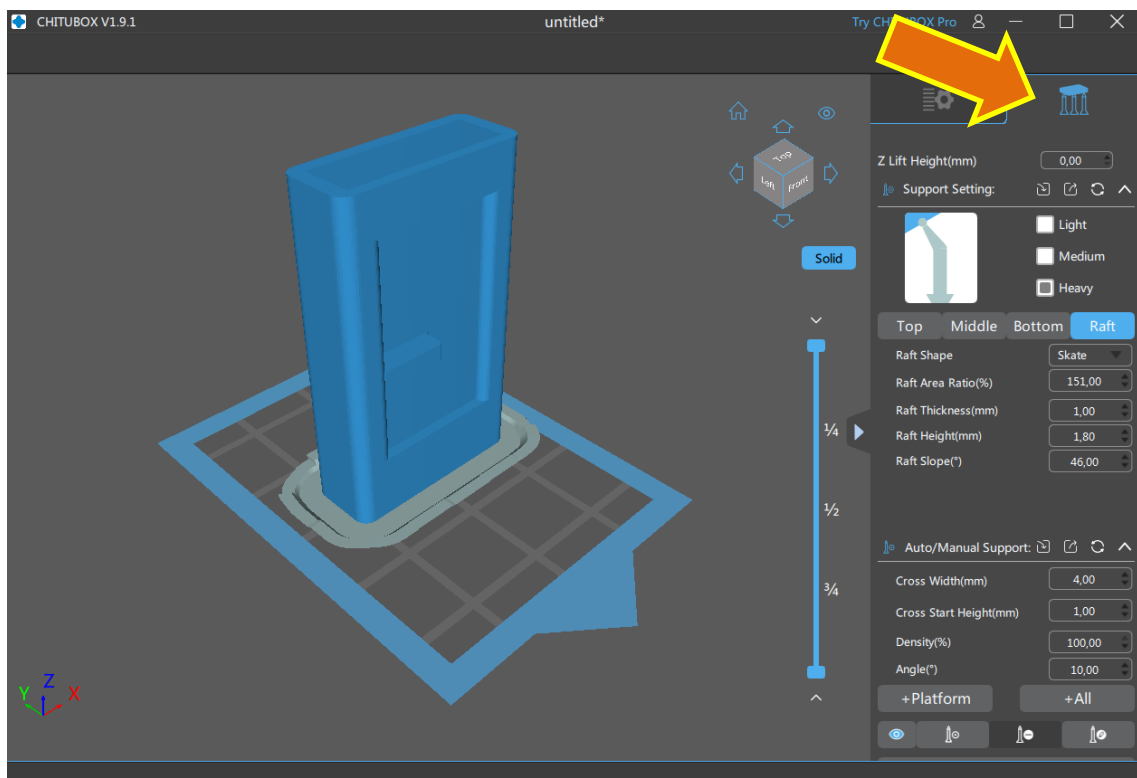
A large flat face will be necessary to achieve good adhesion of the part to the build platform. If the part has a flat face, you can use it, for example:



Here the part is rotated so that the flat face is attached to the platform:



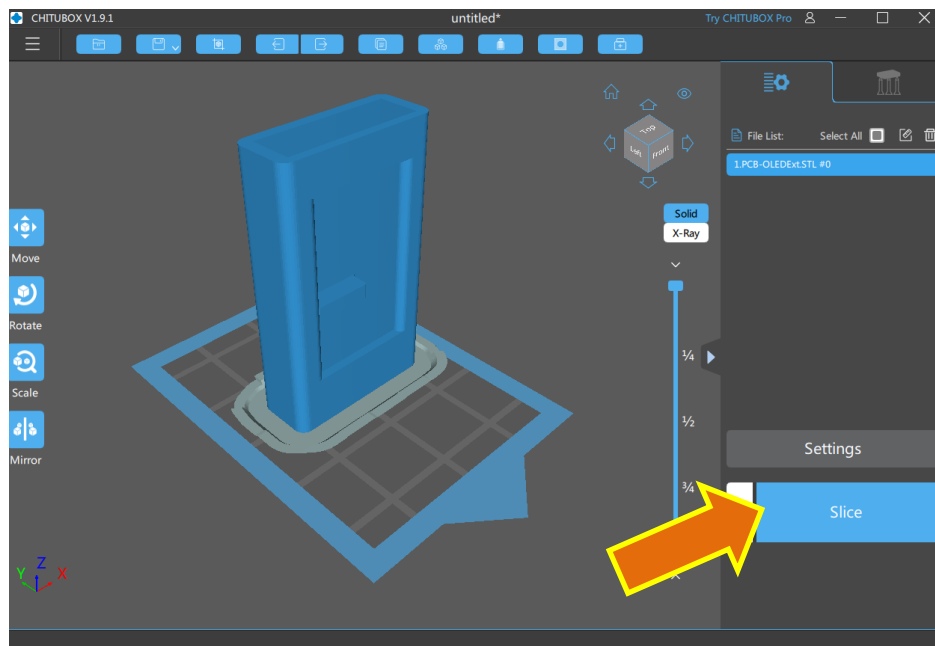
From the support structures tab, you can also add a "raft", which adds a flat surface to the bottom of the part to improve adhesion.



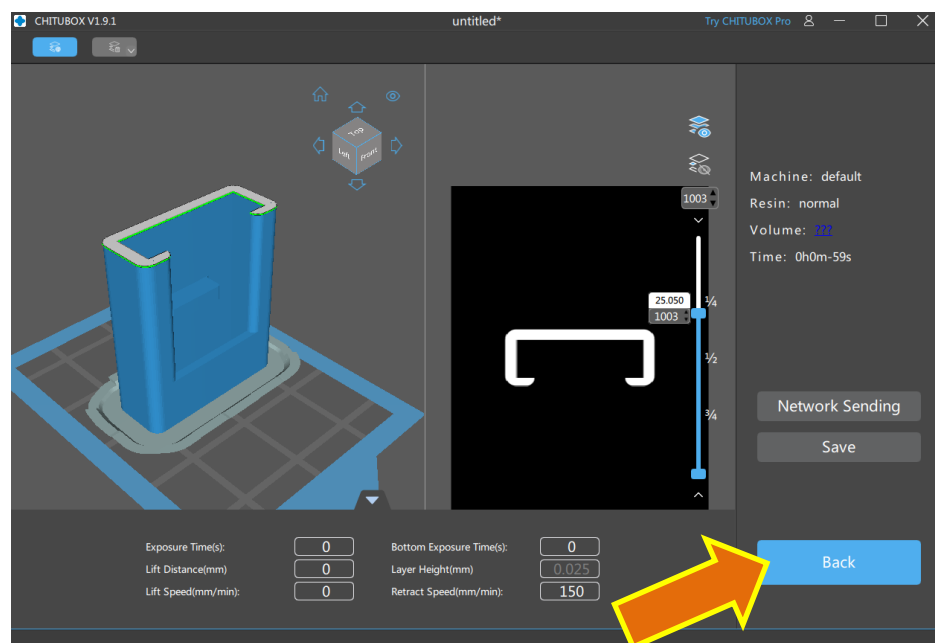
For complex models, where parts of it remain hanging, support structures must also be added in this same tab. For the first test prints, it is convenient to use simple parts with flat faces, to later increase the complexity.

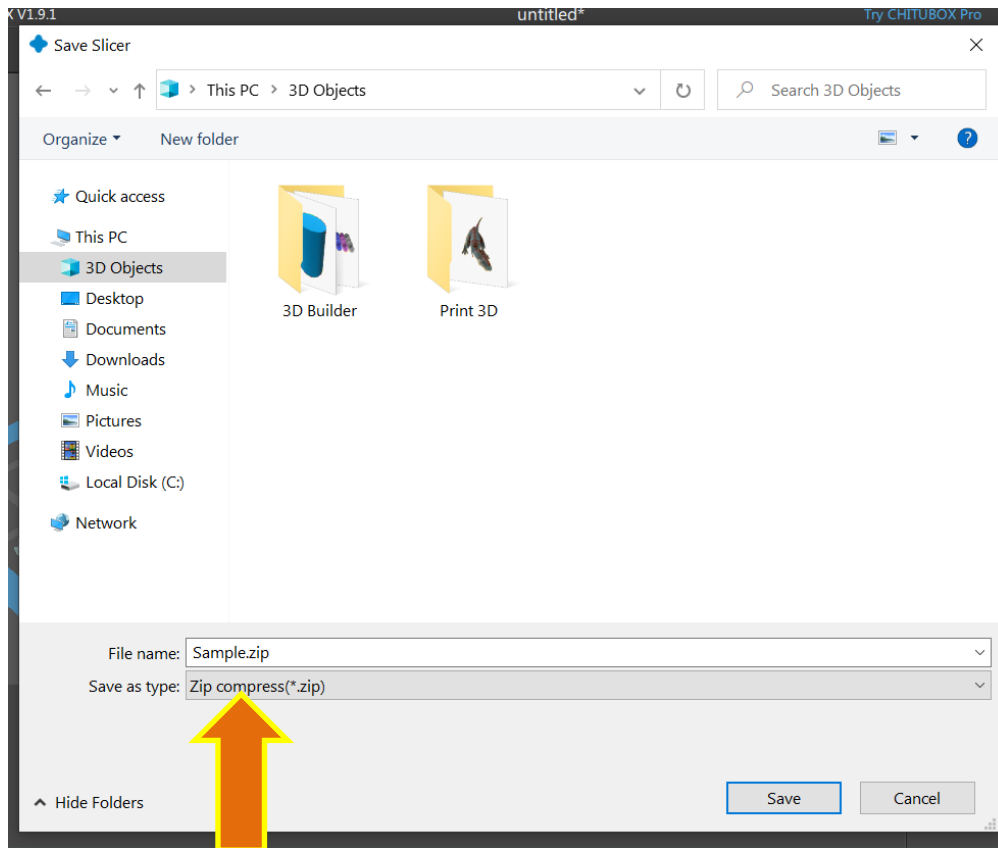
About support structures and full functionality of Chitubox, a lot of literature can be found on the internet, it is the same as any MSLA machine.

Once the support structure is ready, we press the "Slice" button, which will generate the sections of the part (parallel to the plane of the build platform), with a spacing of 0.025 mm between them (due to the configured value of Layer Height).



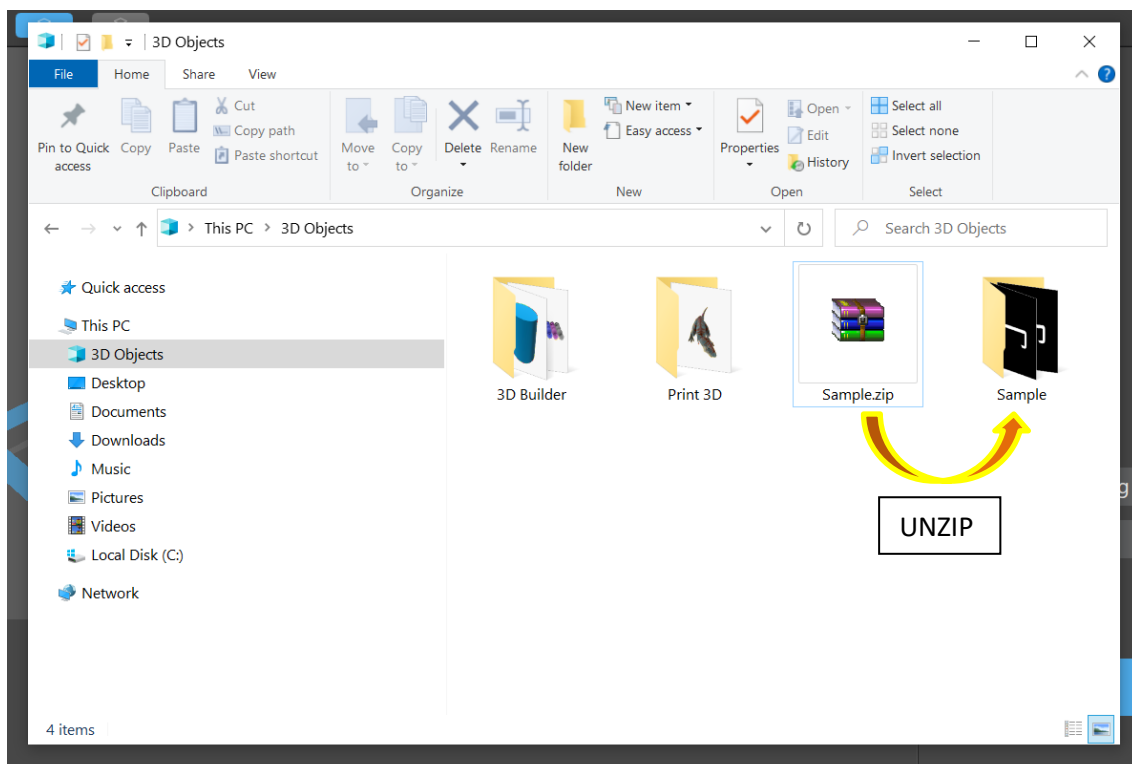
Here you can see and review the images of all the sections of the piece, also called "layers". If everything is fine, we press "Save" and choose the "**Zip**" format.

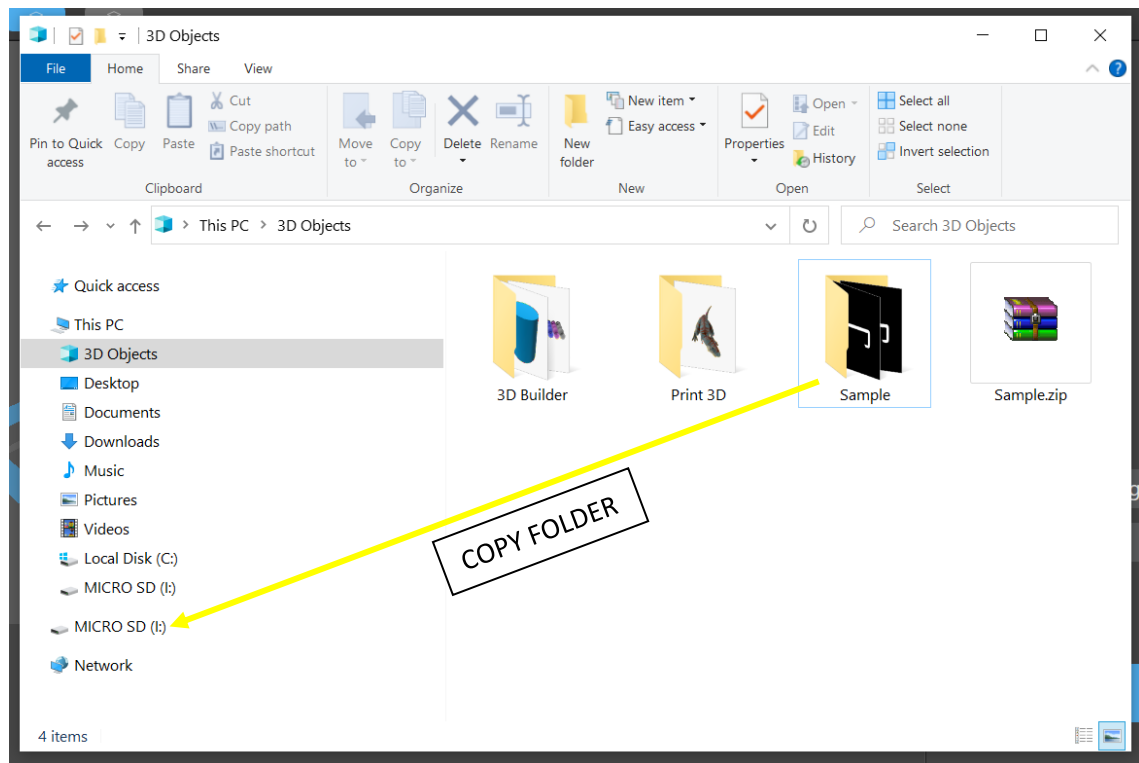




As a name for the ZIP file preferably select a single word, with no more than 10-12 characters.

As the last step, you will have to unzip this ZIP file in a folder, and then copy the unzipped folder to the micro SD card. The folder name will be what is shown in the Lite3DP selection menu, and the numbered PNG images inside will be used to build the part layer-by-layer.

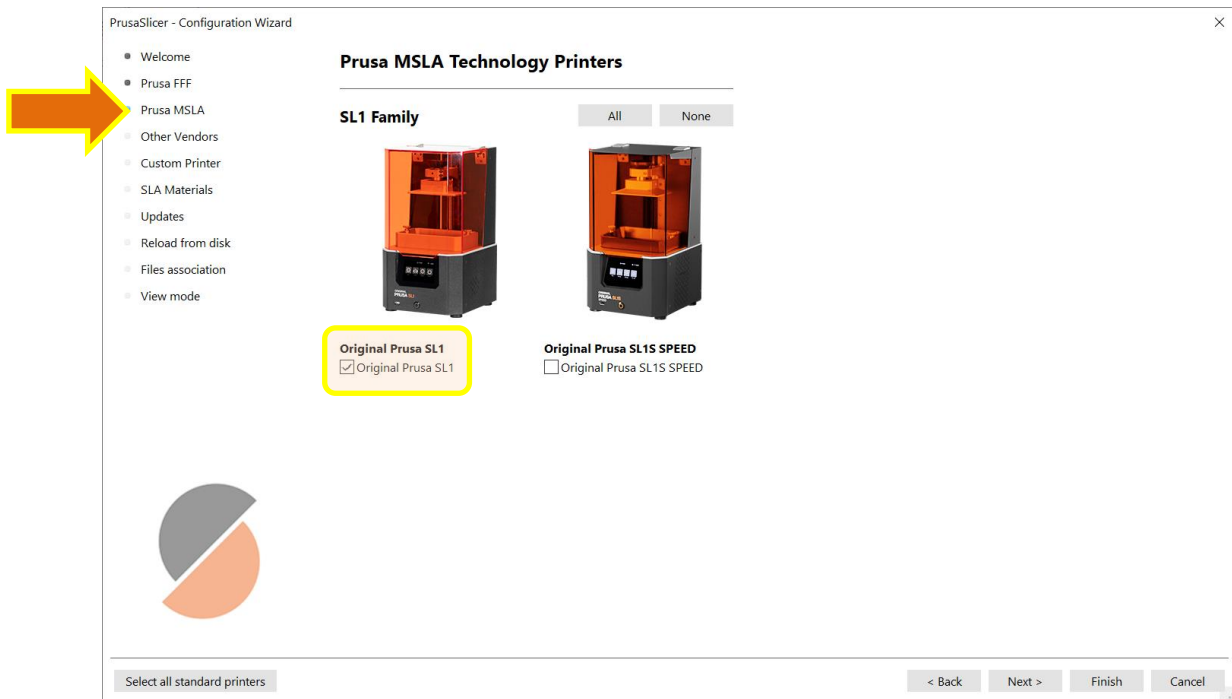




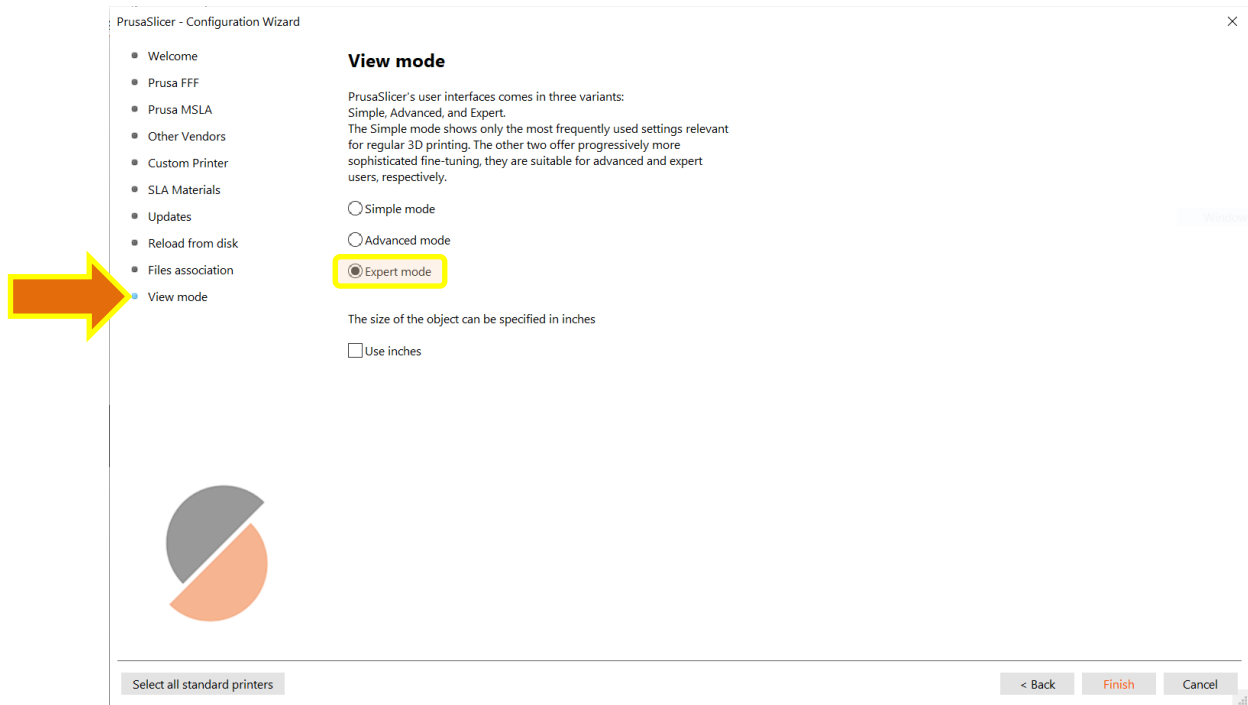
With this we would be ready to insert the micro SD into the Lite3DP and print.

2. PrusaSlicer

I) Once downloaded and installed, Lite3DP must be configured starting from the *Configuration Wizard*:

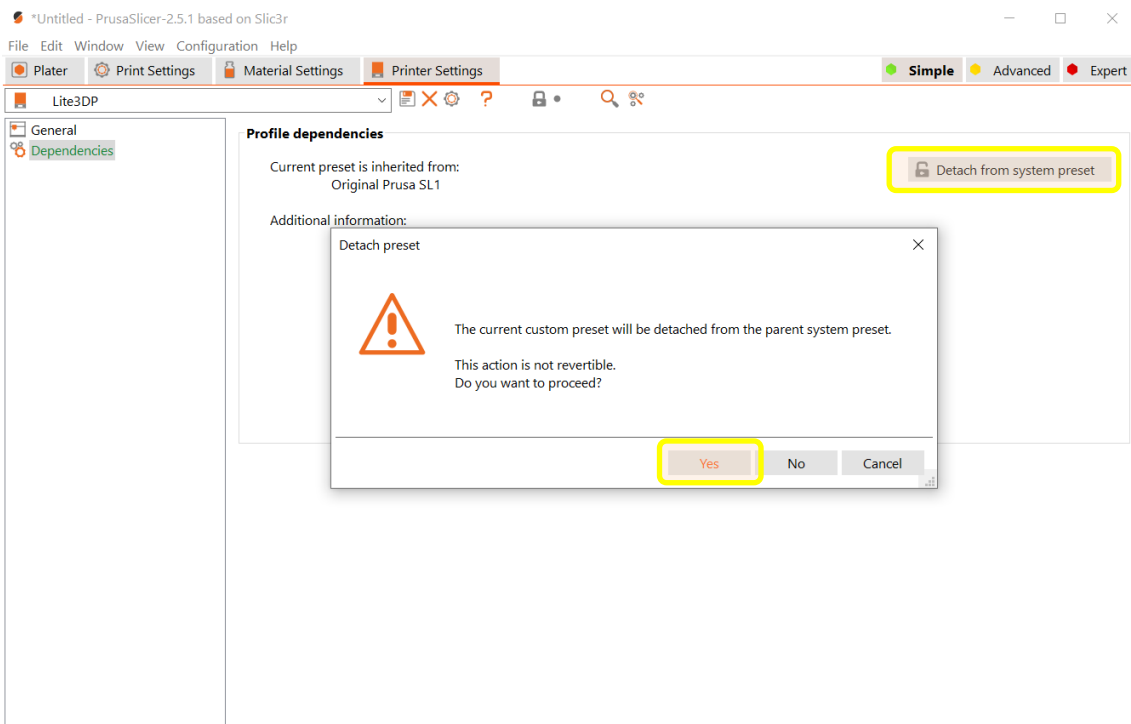


Select Prusa MSLA: Original Prusa SL1.

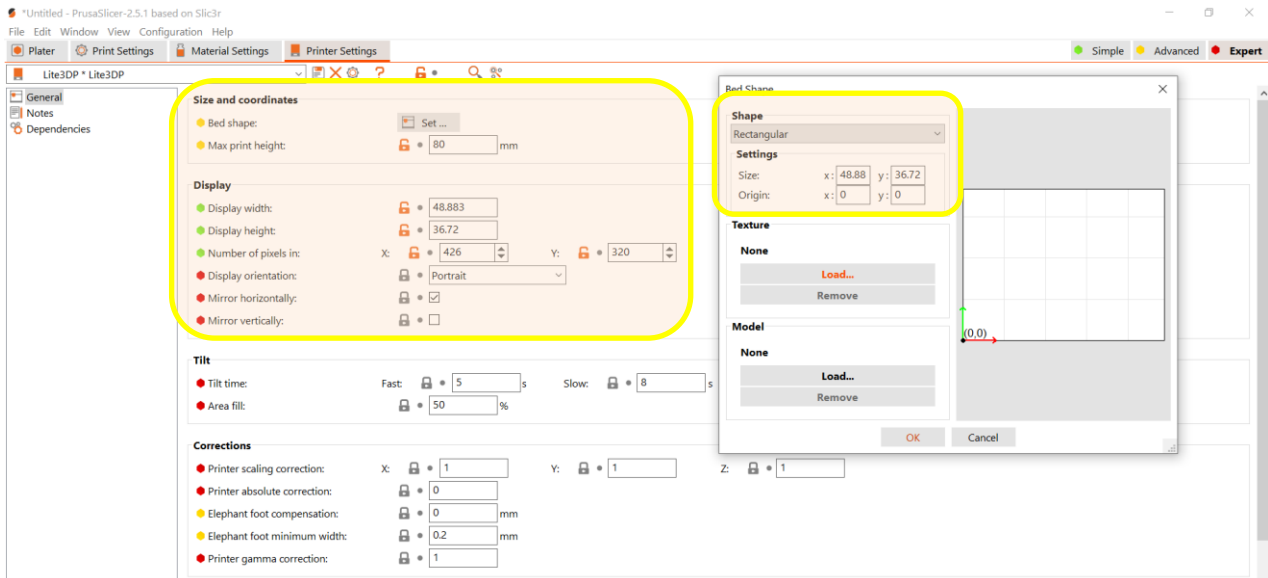


Select View mode: Expert mode.

Printer Settings tab:



Detach from system preset, Yes to proceed.



Set values:

Bed Shape

Size X:48.88 , Y:36.72

Origin X:0, Y:0

Max print height: 80mm

Display

Display width 48.883 Display height 36.72

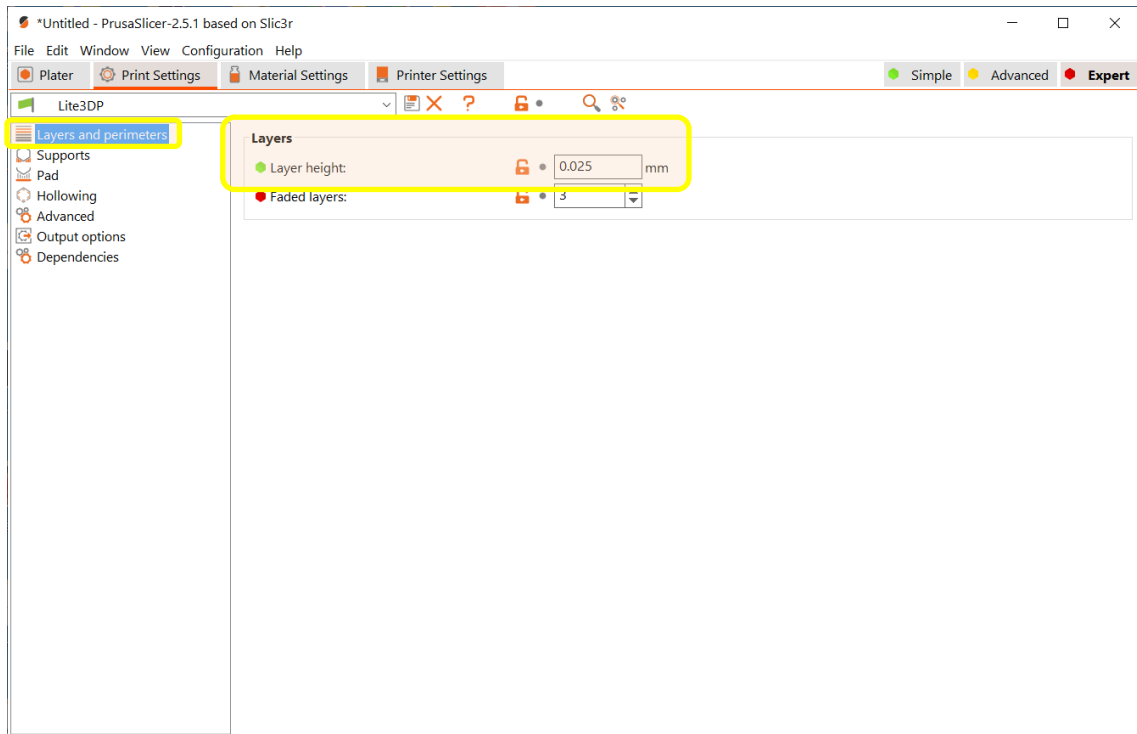
Number of pixels in: X:426 Y:320

Display orientation: Portrait

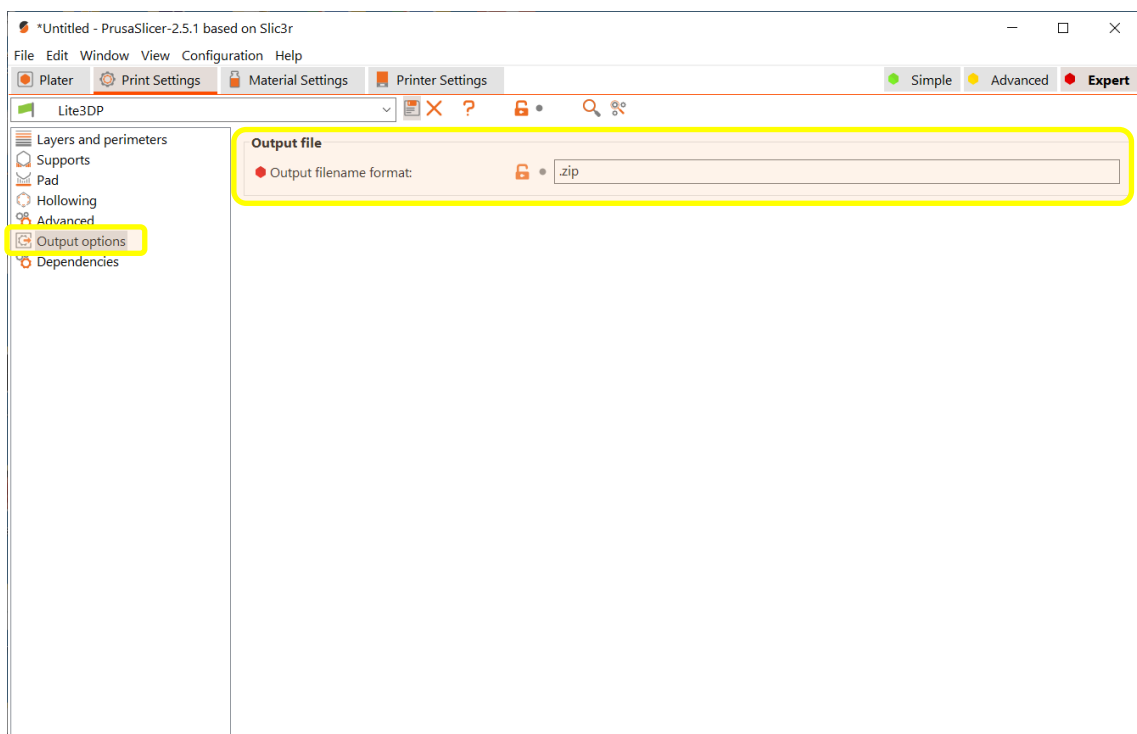
Mirror horizontally: YES

Mirror vertically: NO

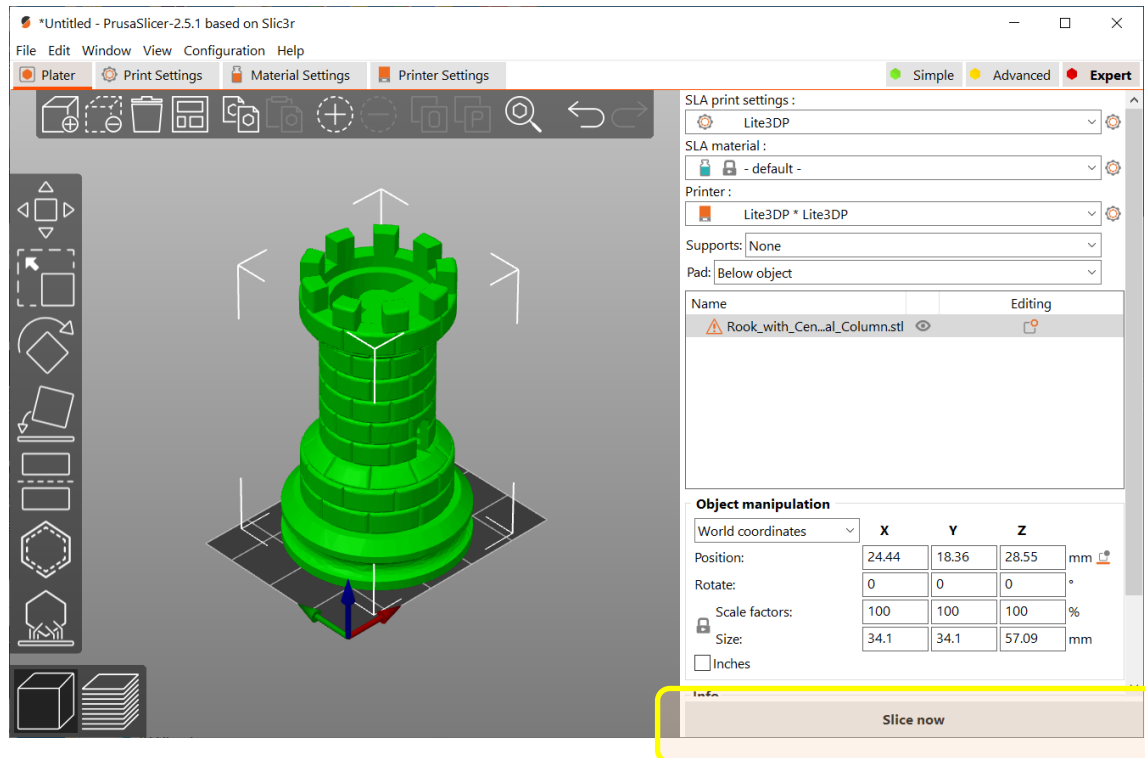
Print settings tab, Layers and perimeters **Layer height: 0.025mm**



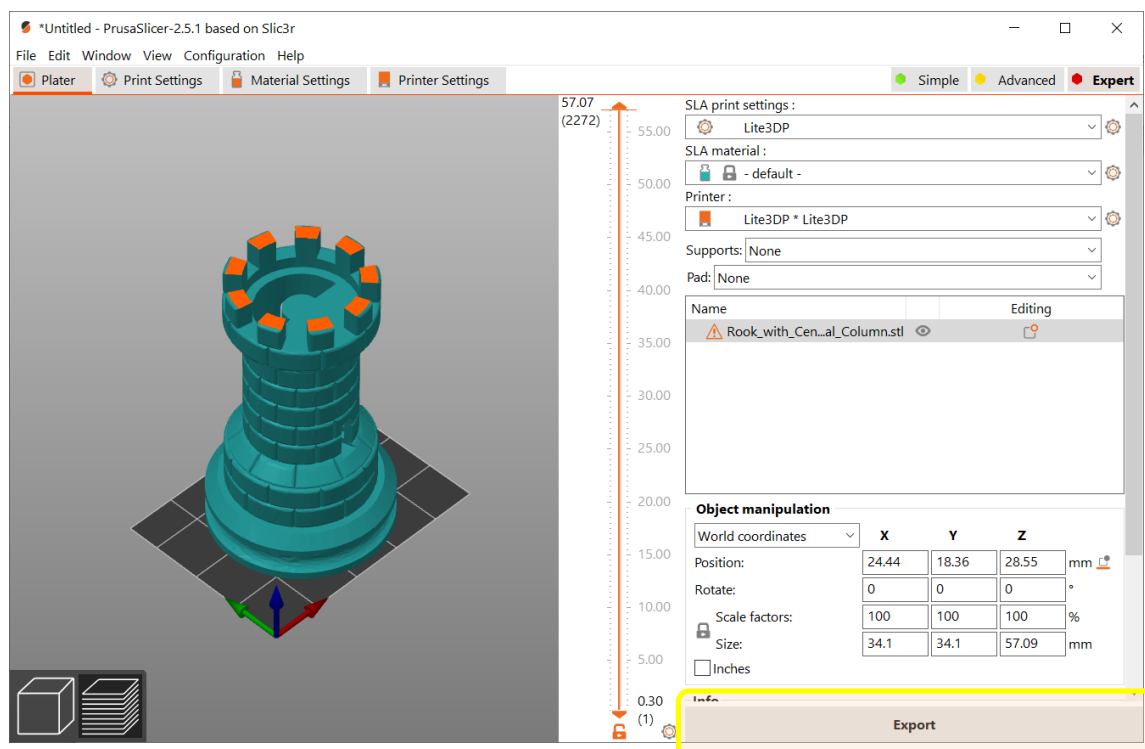
Print settings tab, Output options. Output filename format: .zip



II) Position the part, rotate it and scale it appropriately. Add the necessary support structures. Use the options provided by the software, which you will find in specific tutorials. When finished, press the button “Slice now”.



Check and Press the button “Export”.

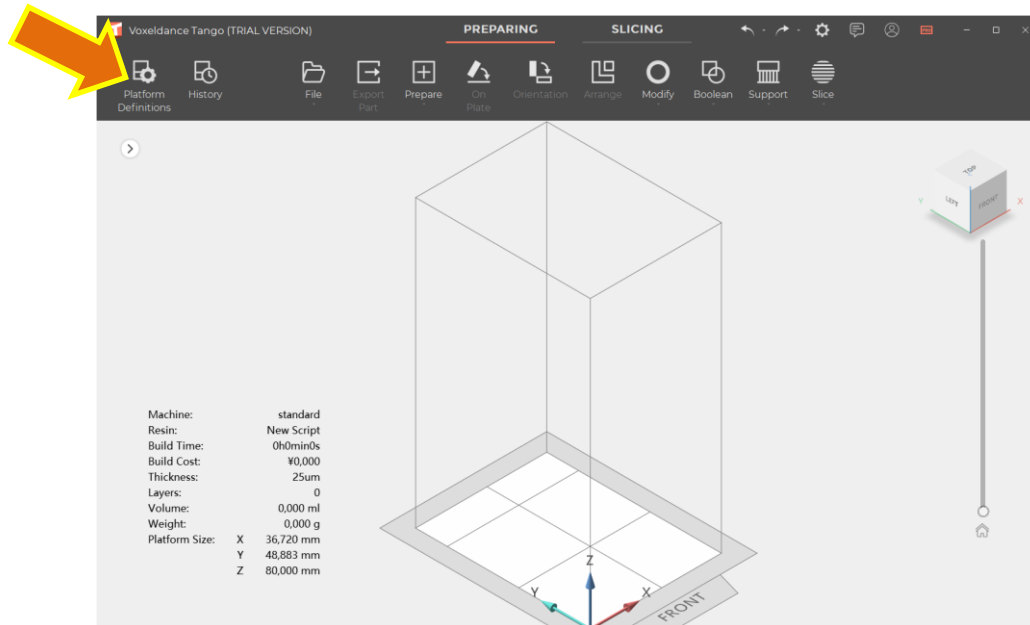


Save the **Zip file** with a short name with no more than 6 characters.

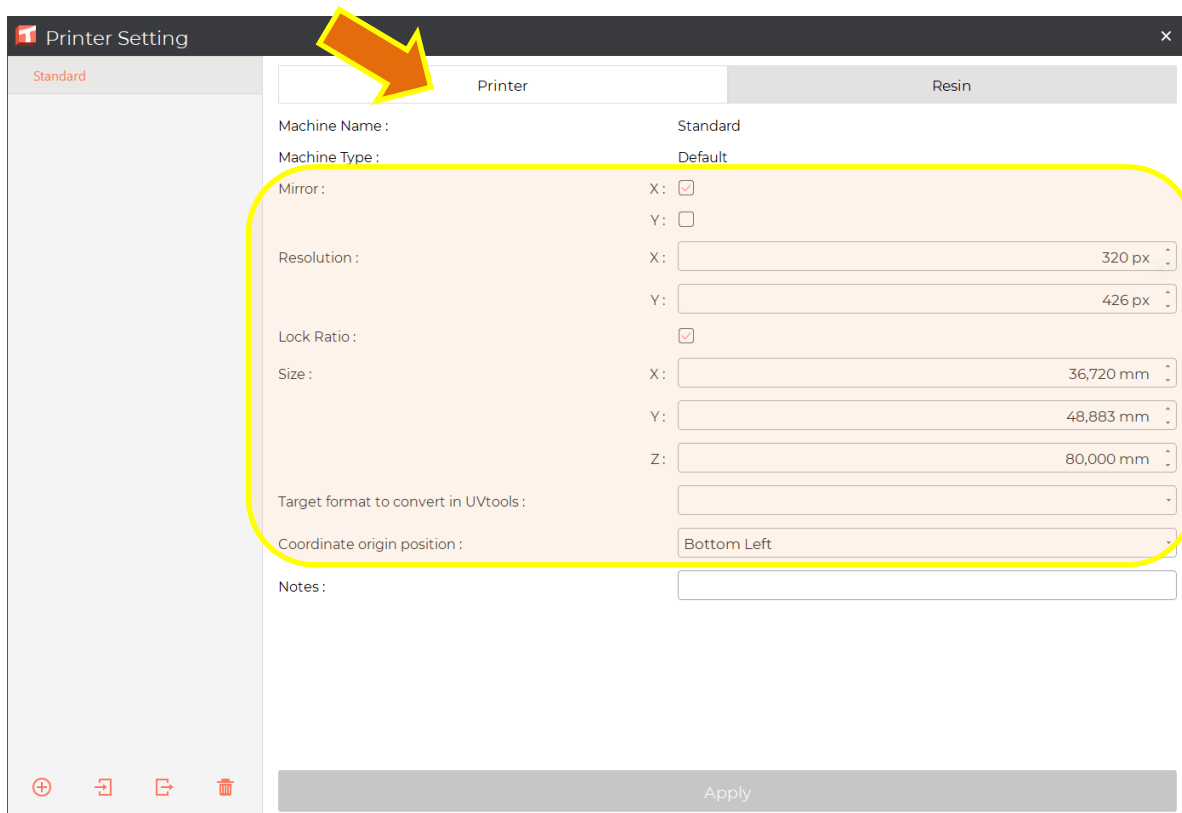
Unzip file and copy the unzipped folder to the micro SD card (see Chitubox section).

3. Voxeldance Tango

1)



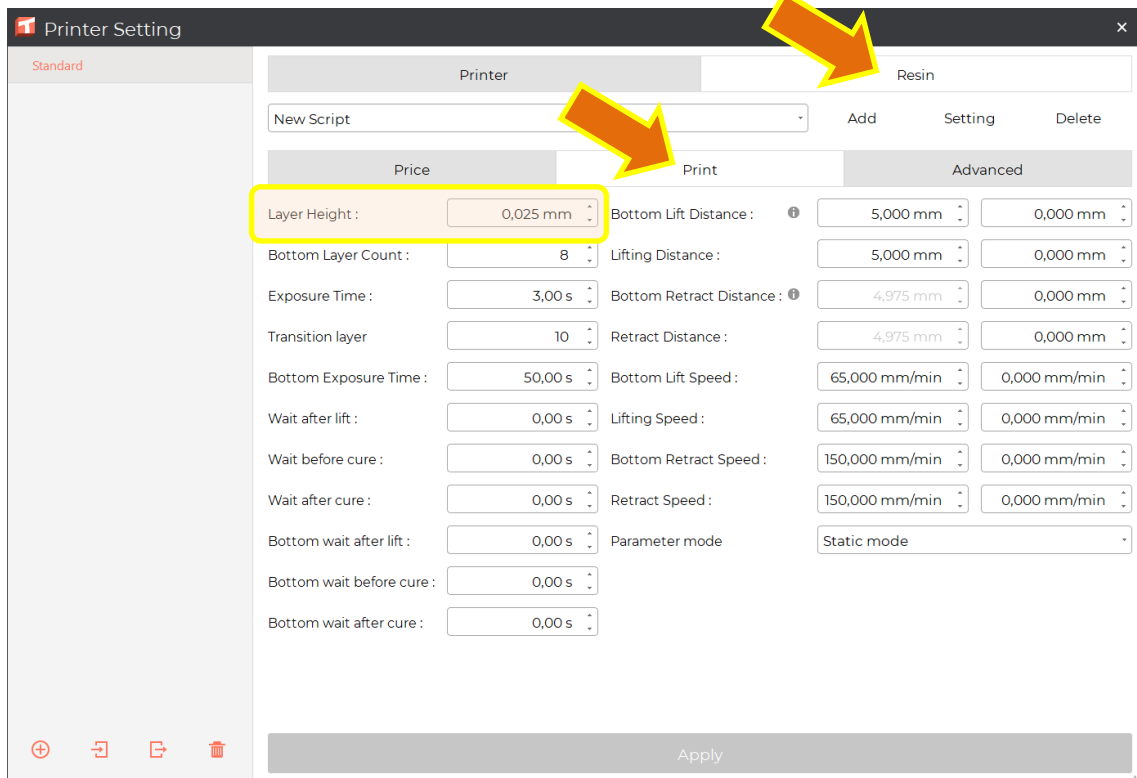
Go to **Platform Definitions, Printer tab:**



Set values:
Mirror X: YES Y: NO
Resolution X: 320px Y: 426px
Lock Ratio: YES

Size **X:**36.720mm **Y:**48.883mm **Z:**80.000 mm

Within the same window, go to Resin tab, Print tab:



Printer Setting

Standard

Printer Resin

New Script Add Setting Delete

Price Print Advanced

Layer Height : 0,025 mm

Bottom Layer Count : 8

Exposure Time : 3,00 s

Transition layer : 10

Bottom Exposure Time : 50,00 s

Wait after lift : 0,00 s

Wait before cure : 0,00 s

Wait after cure : 0,00 s

Bottom wait after lift : 0,00 s

Bottom wait before cure : 0,00 s

Bottom wait after cure : 0,00 s

Bottom Lift Distance : 5,000 mm

Lifting Distance : 5,000 mm

Bottom Retract Distance : 4,975 mm

Retract Distance : 4,975 mm

Bottom Lift Speed : 65,000 mm/min

Lifting Speed : 65,000 mm/min

Bottom Retract Speed : 150,000 mm/min

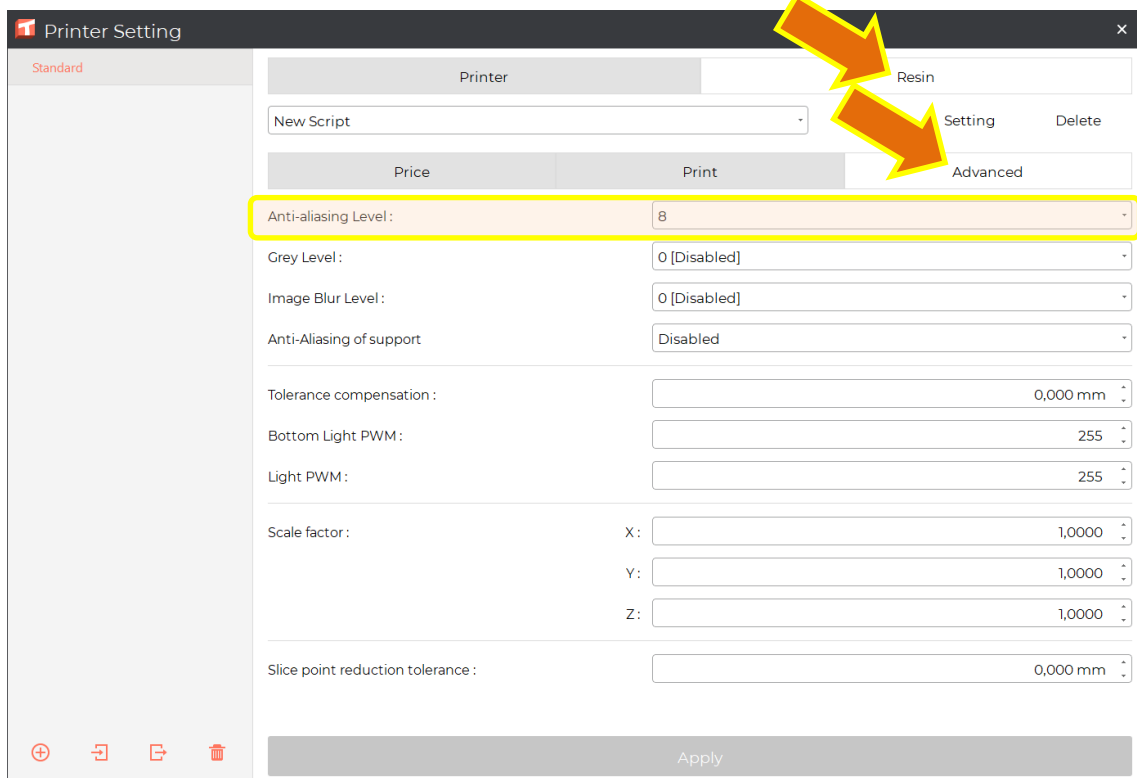
Retract Speed : 150,000 mm/min

Parameter mode : Static mode

Apply

Set Layer Height: 0,025 mm

Within the same window, go to Resin tab, Advanced tab:



Printer Setting

Standard

Printer Resin

New Script Setting Delete

Price Print Advanced

Anti-aliasing Level : 8

Grey Level : 0 [Disabled]

Image Blur Level : 0 [Disabled]

Anti-Aliasing of support : Disabled

Tolerance compensation : 0,000 mm

Bottom Light PWM : 255

Light PWM : 255

Scale factor : X : 1,0000

Y : 1,0000

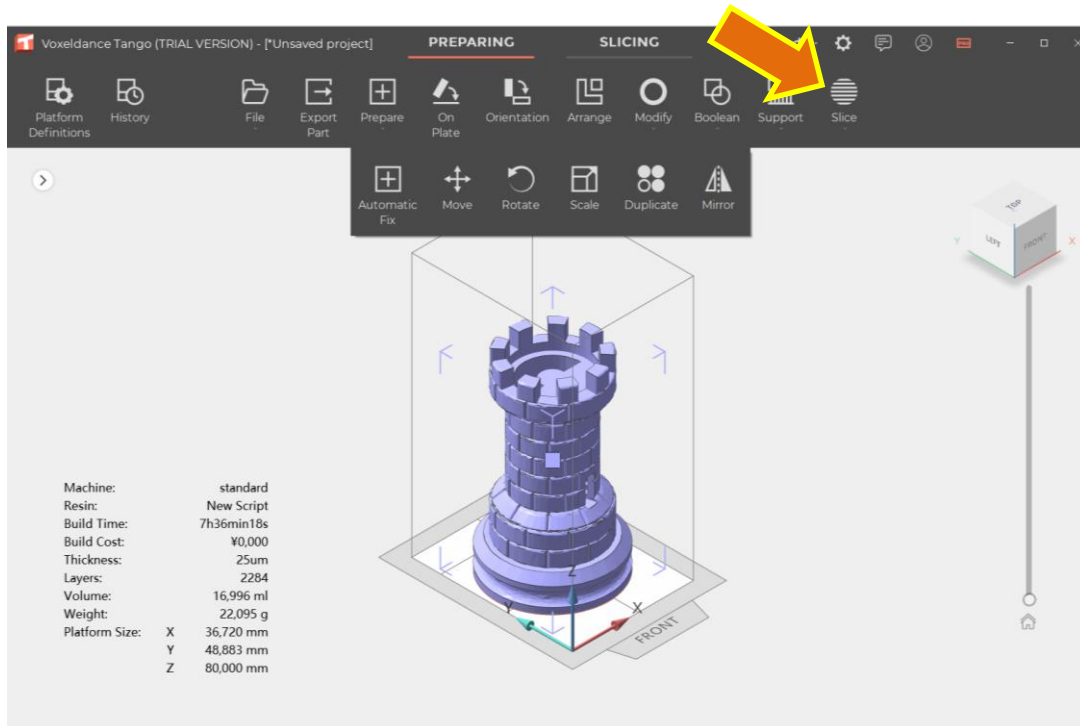
Z : 1,0000

Slice point reduction tolerance : 0,000 mm

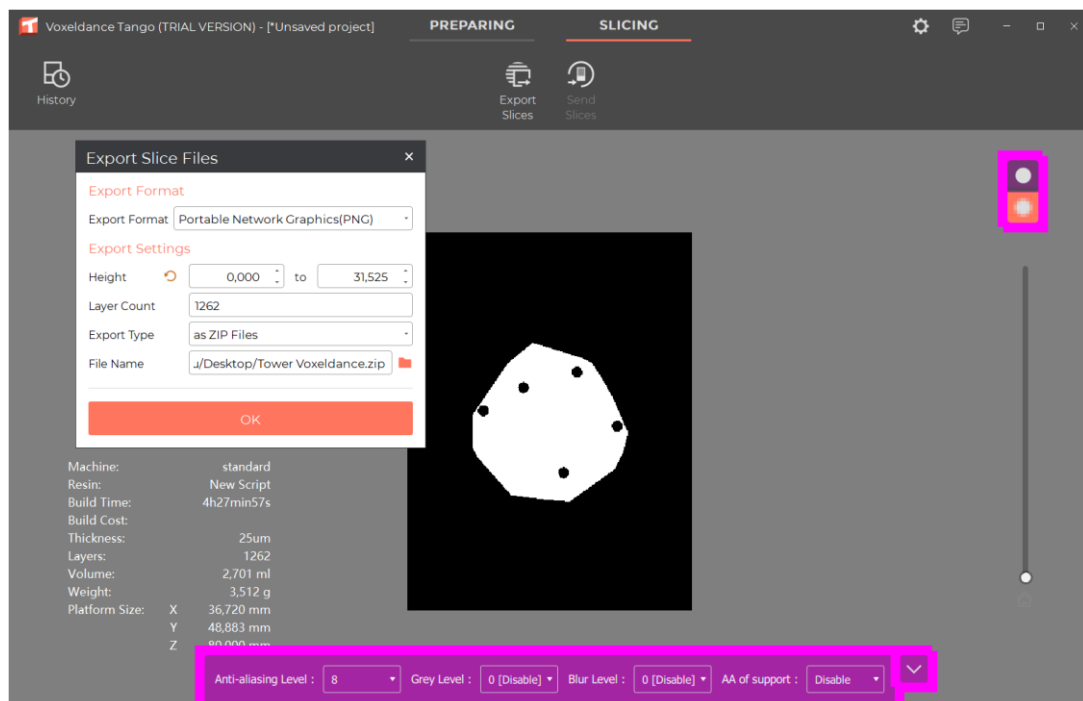
Apply

Set Anti-aliasing Level: 8

II) Position the part, rotate it and scale it appropriately. Add the necessary support structures. Use the options provided by the software, which you will find in specific tutorials. When finished, press the button **“Slice”** - **“Slice”**.



Check and press the button **“Export Slices”**.



Export Format: Portable Network Graphics(PNG)

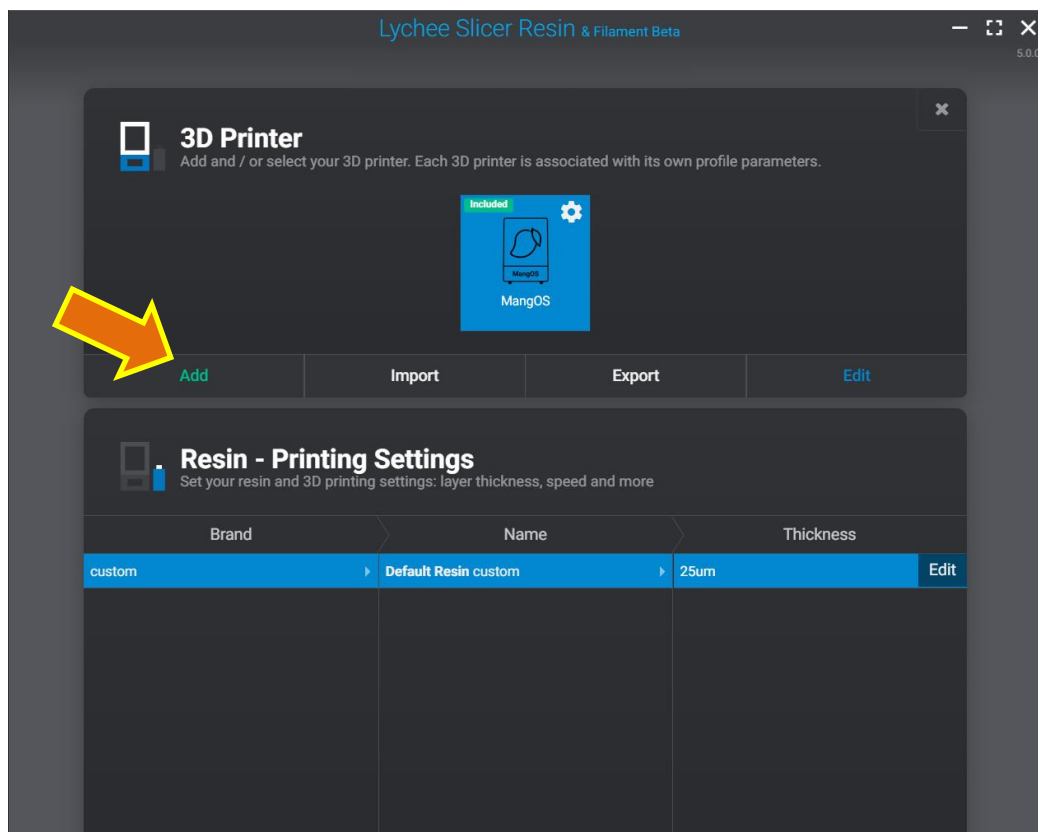
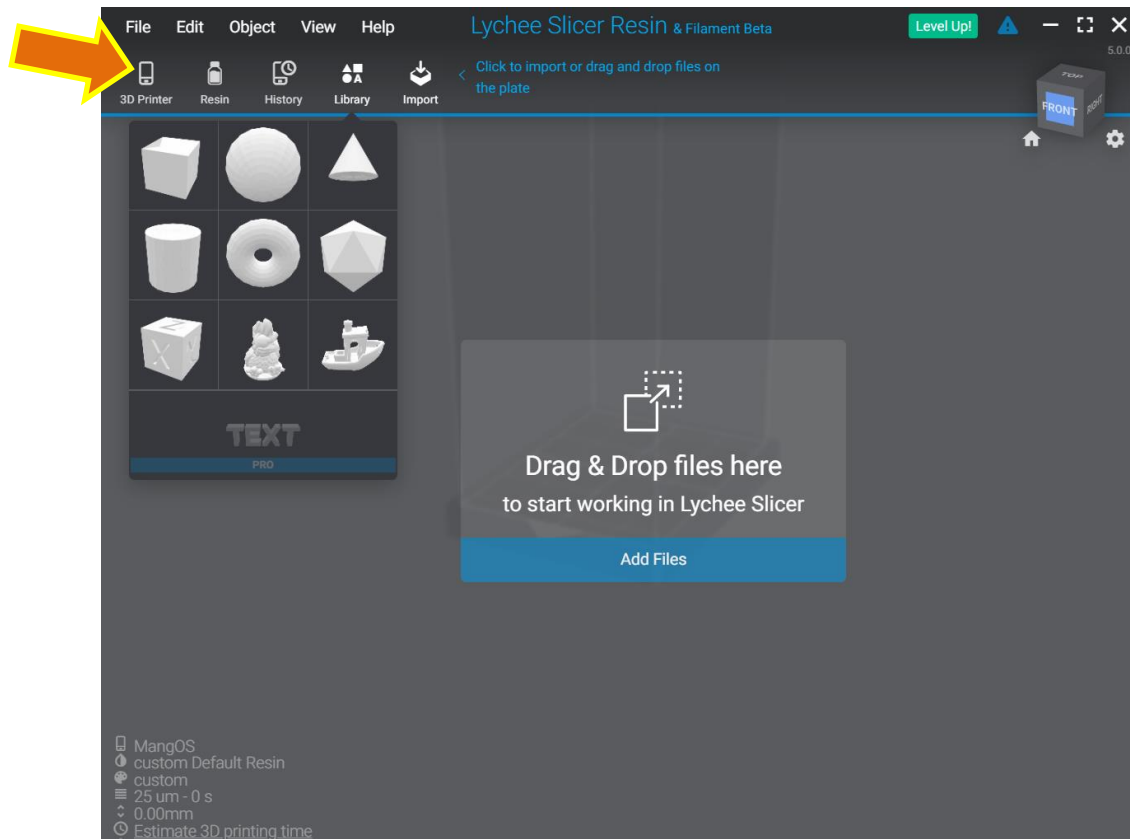
Export Type: as ZIP Files

Save the **Zip file** with a **single word name**, with **no more than 10-12 characters**.

Unzip file and copy the unzipped folder to the micro SD card (see Chitubox section).

4. Lychee

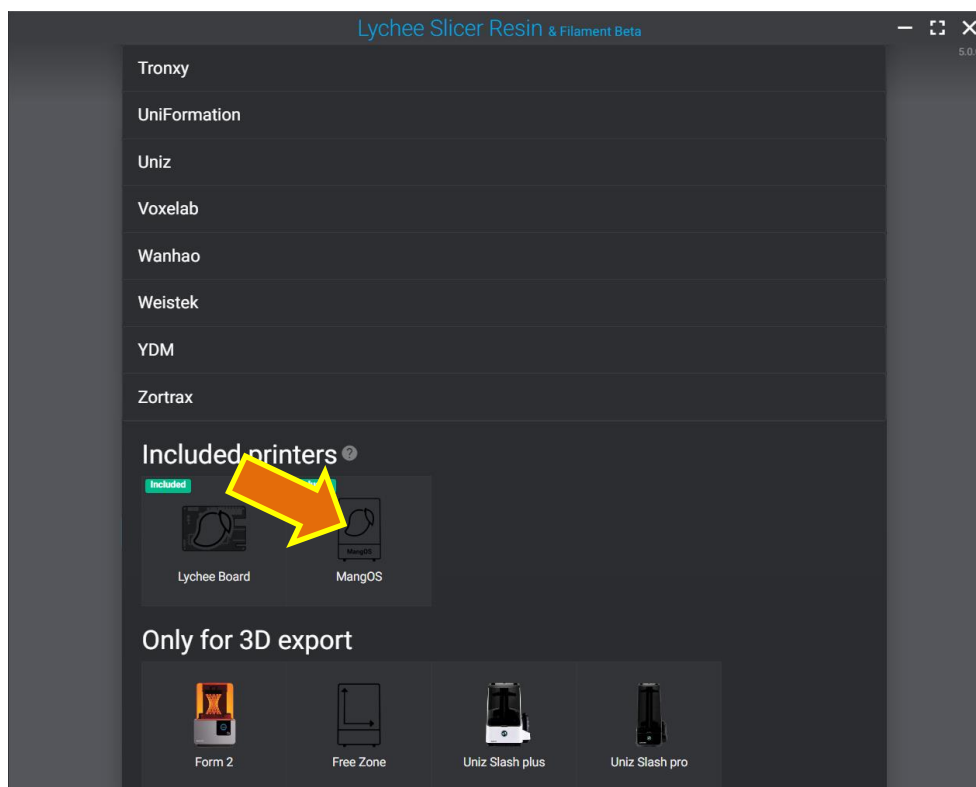
1) Press the “3D Printer” button.



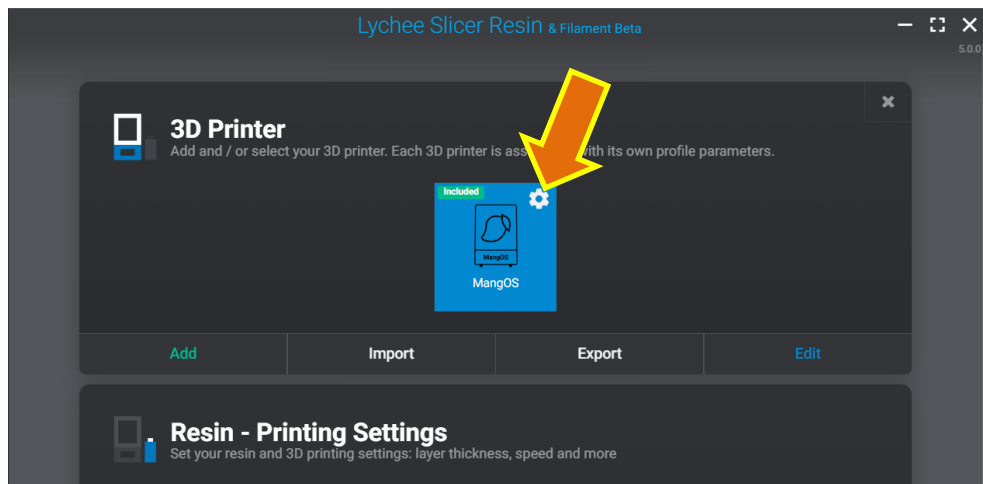
Press **Add**.



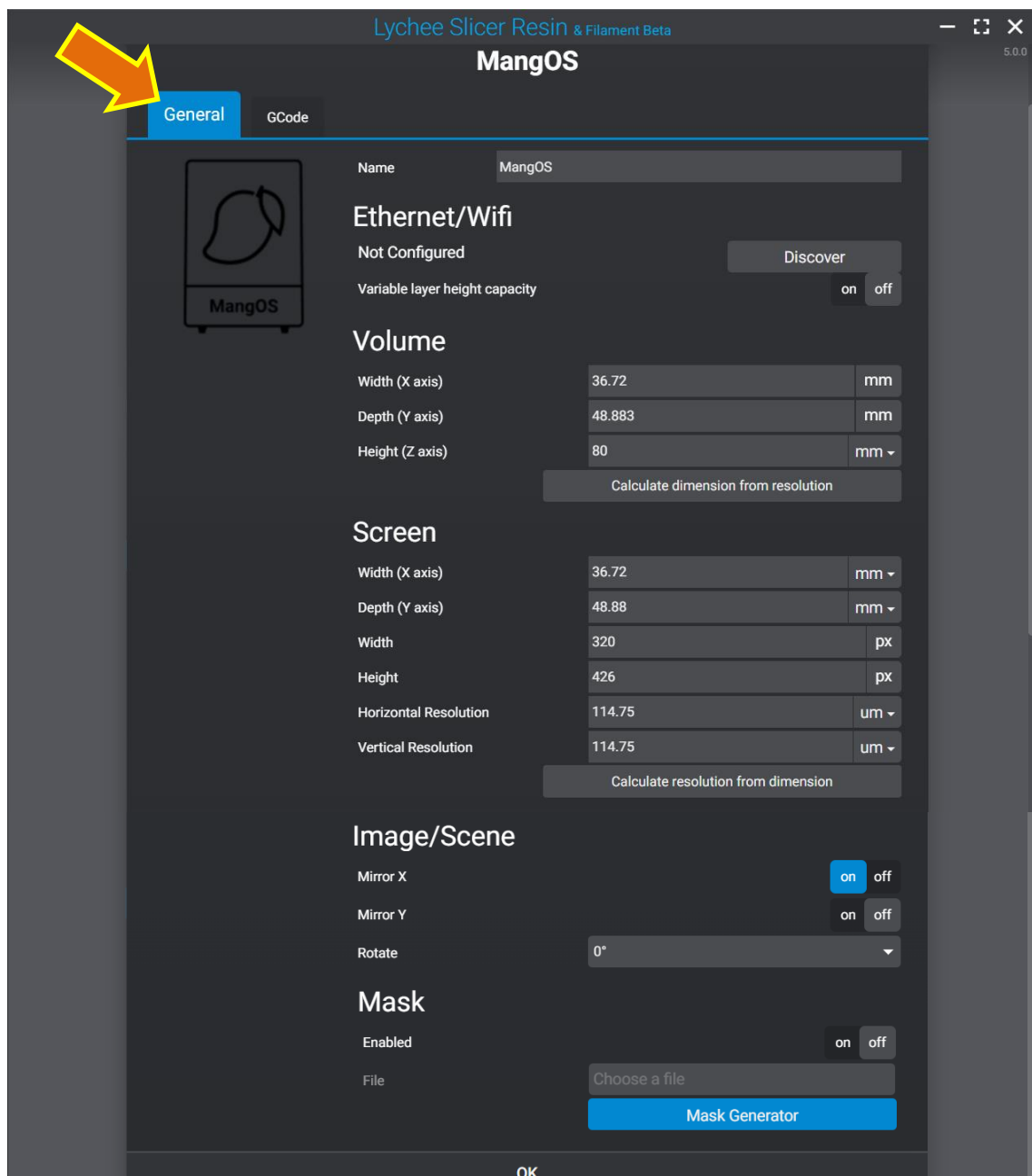
Select: **Resin 3d printer**.



Select: **MangOS**.



Press the “Gear icon” on MangOS.



General tab. Set Values:

Volume

Width (X axis): 36.72 mm

Depth (Y axis): 48.883 mm

Height (Z axis): 80 mm

Screen

Width (X axis): 36.72 mm

Depth (Y axis): 48.88 mm

Width: 320 px

Height: 426 px

Horizontal Resolution: 114.75 um

Vertical Resolution: 114.75 um

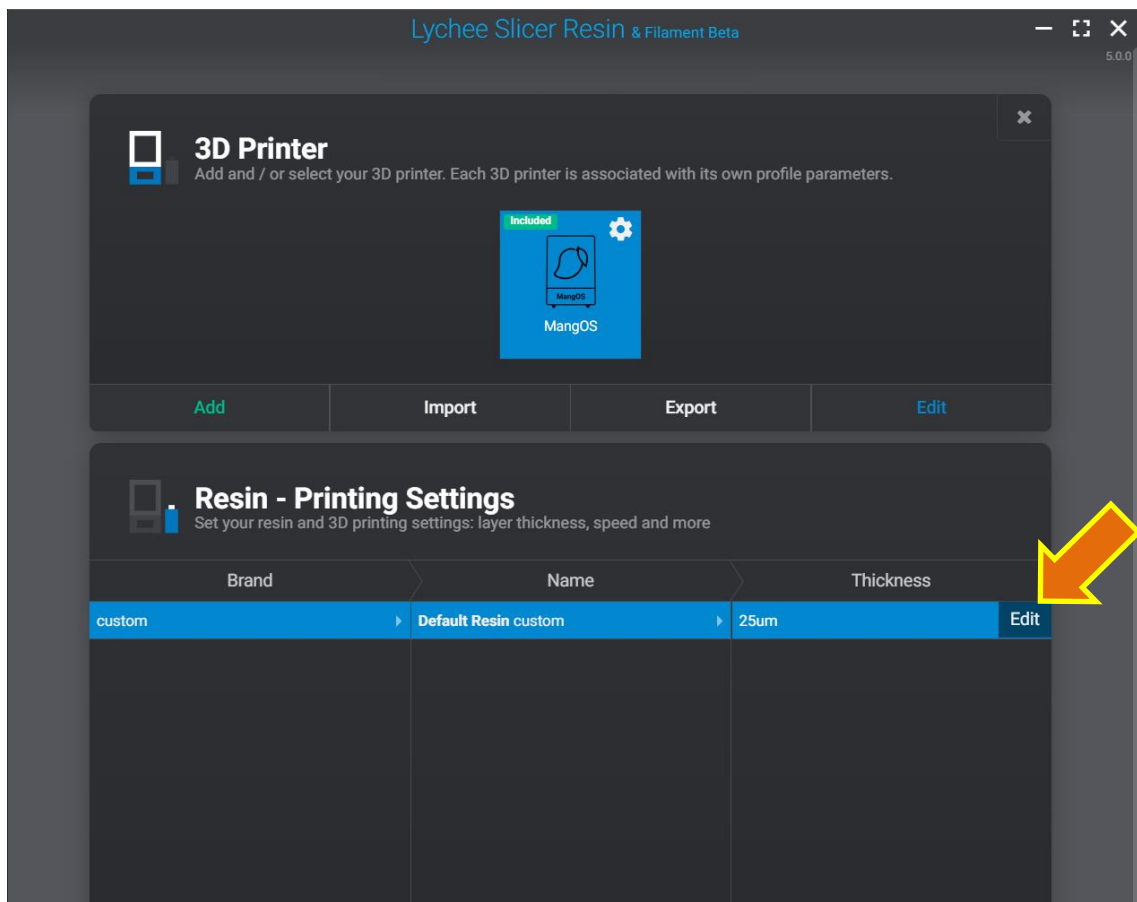
Image/scene

Mirror X: on

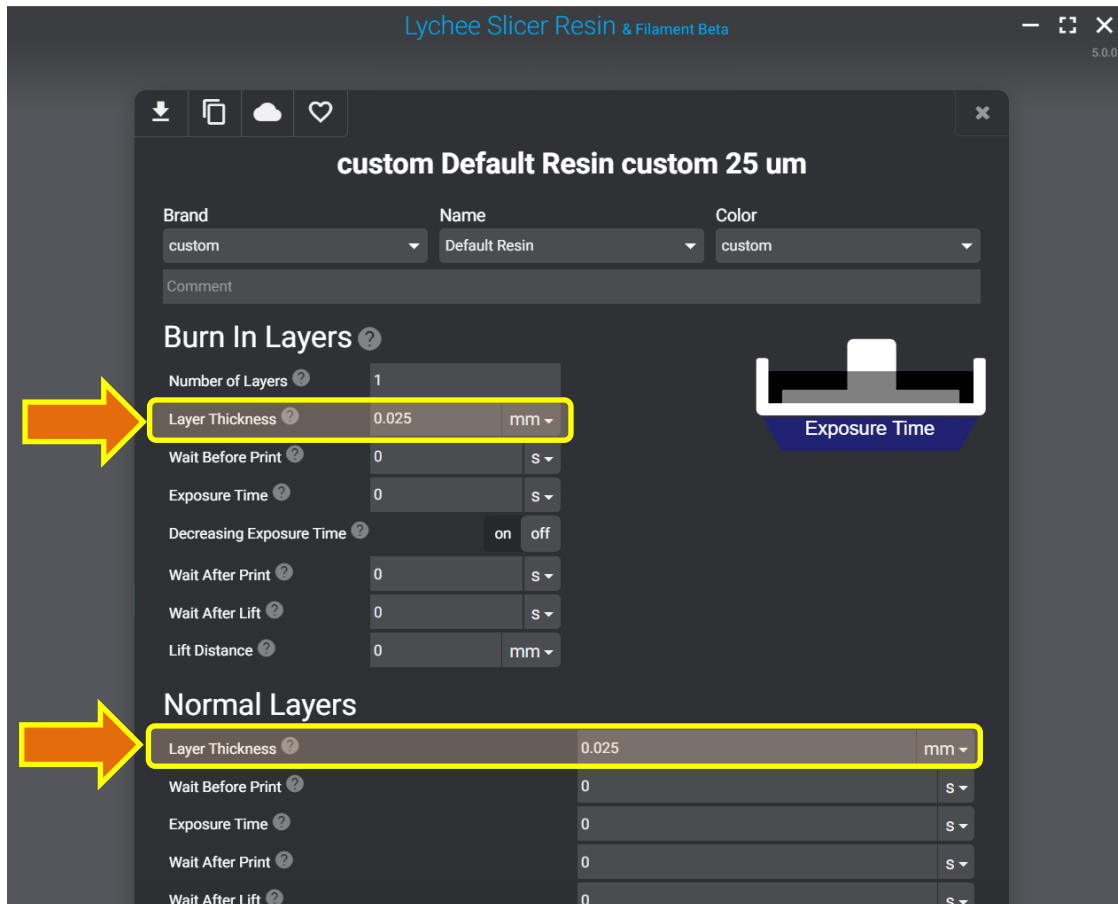
Mirror Y: off

Mask

Enabled: off



Resin – Printing Settings. Press **Edit** button.



Set values:

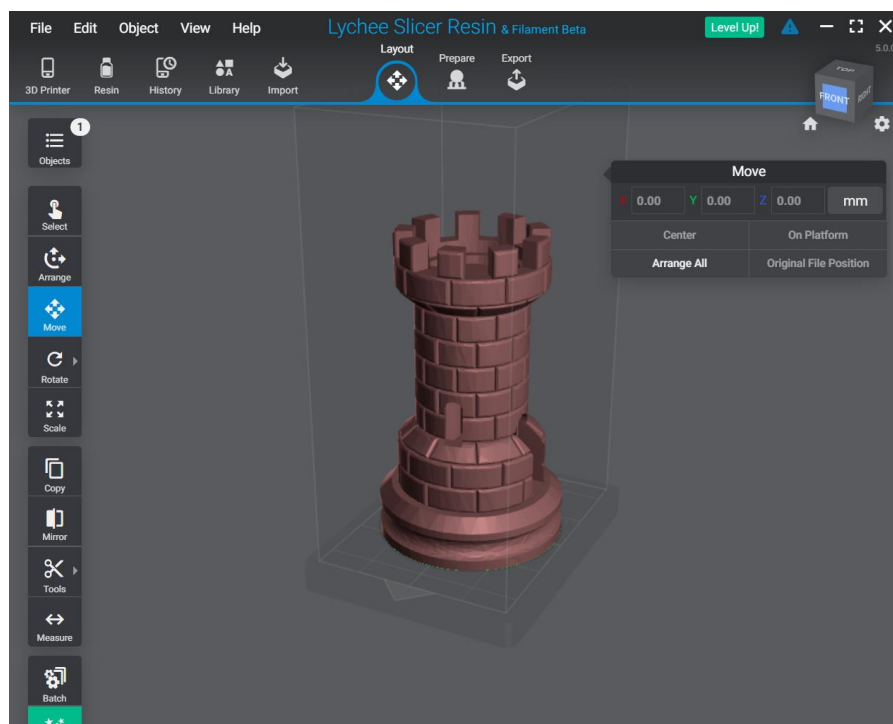
Burn in layers

Layer thickness: 0.025 mm

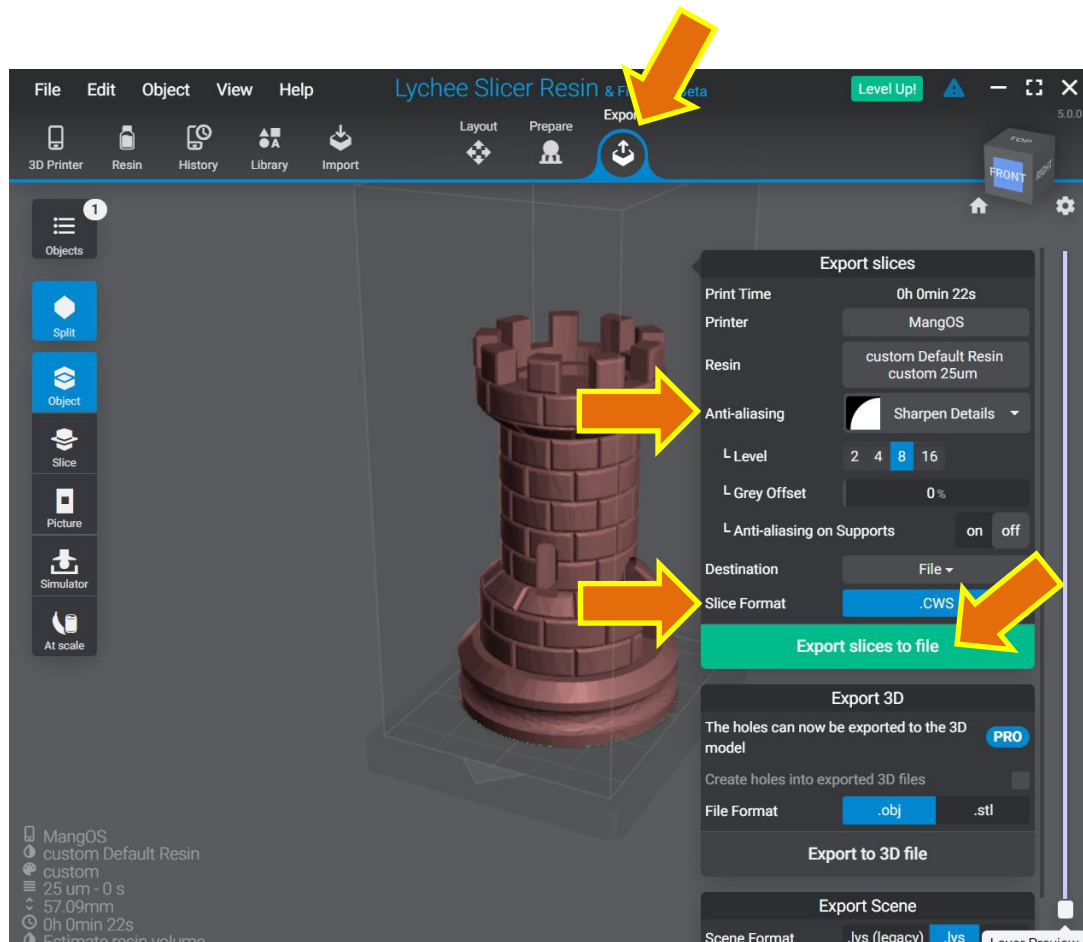
Normal Layers

Layer thickness: 0.025 mm

II)

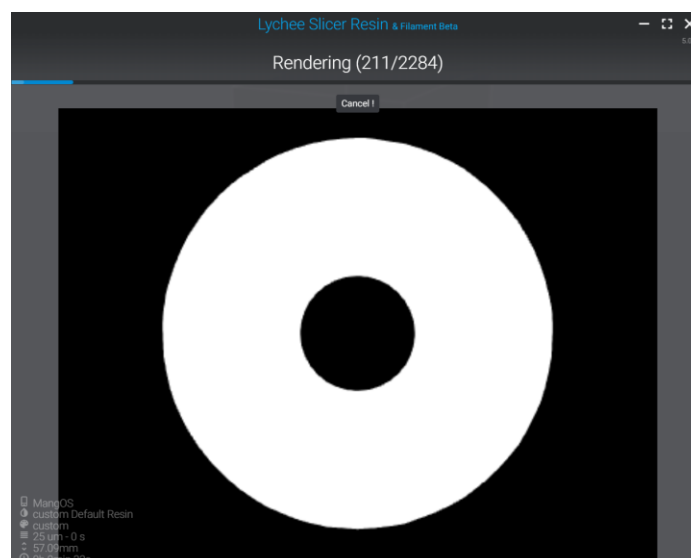


Position the part, rotate it and scale it appropriately. Add the necessary support structures. Use the options provided by the software, which you will find in specific tutorials. Go through the tabs Layout-Prepare-Export.



Export tab, select options:
Anti-aliasing: Sharpen Details, Level 8.
Slice Format: .CWS

Press the “Export slices to file” button.



After all sections are rendered, a file with a .CWS extension will be created. In this special case, we will have to treat this extension as a .ZIP file. You can manually change the extension by deleting .CWS and writing .ZIP, or directly run the UNZIP to the CWS file. In both cases, a folder should be generated with the PNG images inside (if it also has other files, it is not a problem). Finally, copy the unzipped folder to the micro SD card.

