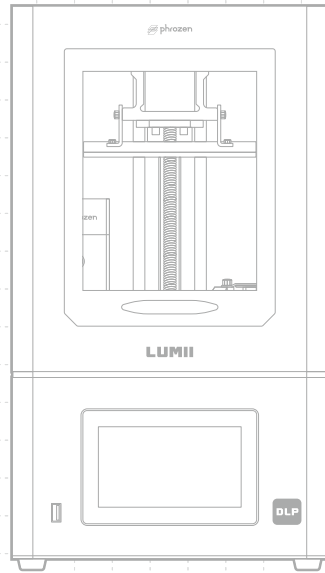


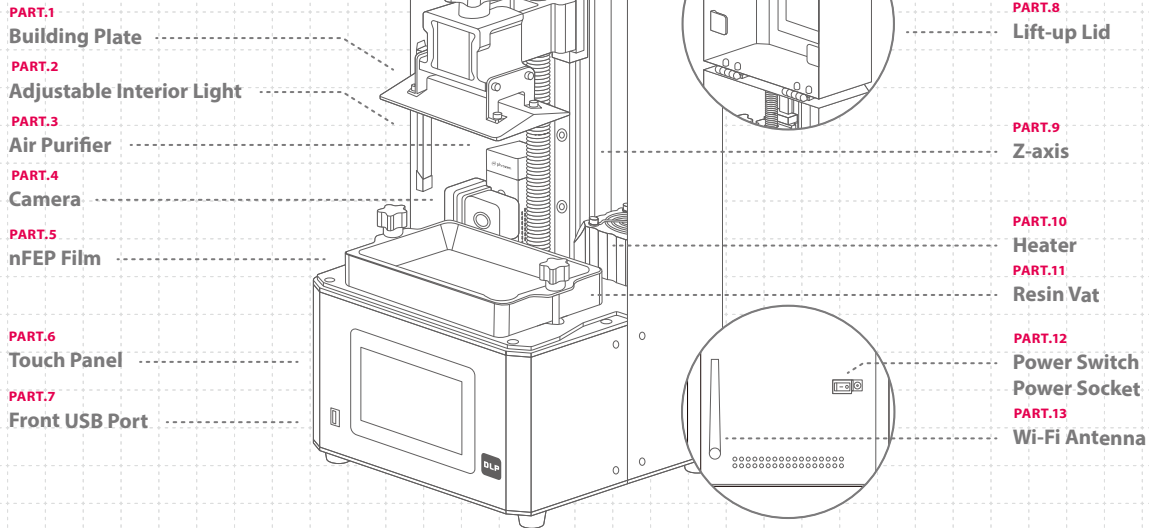
Dear User,

Thank you for purchasing the Lumii DLP. In order to ensure the optimal printing experience, please follow the step-by-step instructions provided in the manual below.



01 Introduction

Printer Parts



The Toolbox



After Sales Service Card



Gloves



Power Cord & Adapter



Plastic Funnel



Scrapers



Allen Wrench



USB



DS Slicer Dongle



Handle



Wi-Fi Antenna

Operation

System	Phrozen OS
Operation	5 inch Touch Panel
Slicer Software	Phrozen DS Slicer, VoxelDance Tango (Others)
Connectivity	USB Wi-Fi
Built-in Memory	2GB

Printing Specifications

Technology	DLP (Digital Light Processing)
Light Source	DLP optical projector
Z Resolution	10 μm
XY Resolution	51 μm
Layer Thickness	30 μm , 50 μm , 100 μm
Printing Speed	Up to 90 mm / hr
Compatible File Format	.PRZ
System Power	Max 96W
Power Requirement	DC 12V $\pm$ 8A

Hardware Specifications

Printer Size	23.7 x 23.7 x 42.3 cm
Printing Volume	13 x 7.3 x 16 cm
Printer Weight	11.8 kg

* All specifications were tested in a laboratory and are subject to change without prior notice. For the latest update, please refer to Phrozen's official website.

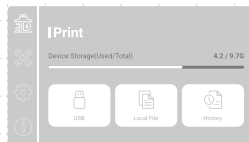
* The included power cord set packaged with the main unit cannot be used with electrical equipment other than the specified device.

02 Interface Introduction

Lumii DLP is equipped with a new interface and enhanced functionalities.

After turning on the printer, you can access the toolbar on the left side to adjust any relevant settings.

Print



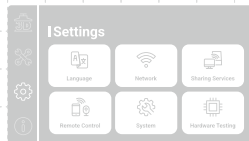
Begin printing by selecting the file inside the printer or USB, or the history section to locate your file.

Tools



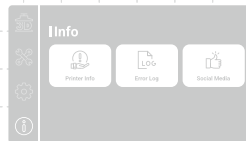
- Z-axis control
- Vat cleaning
- Heater
- Light Intensity
- Light switch

Setting



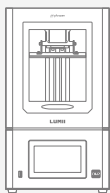
To adjust system settings such as language, network connection, remote control, etc.

Info



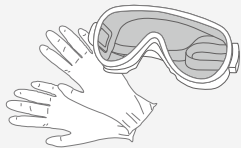
To access other related information.

03 Key Notes Before Start



Stable Printing Environment

Place your 3D printer in a dry and ventilated environment. Avoid exposure to direct sunlight. Make sure to place the printer on a flat surface.



Protective Measures

While printing and using resin, please make sure to wear gloves, masks, protective goggles, and long-sleeved clothing.

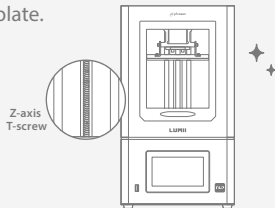
Maintenance

Clean the Z-axis

First, dry clean the Z-axis T-screw. Then apply a thin layer of general lubricant on it, so that it whirls smoothly.

Clean the 3D Printer

Use sanitizing alcohol and tissue paper to carefully clean the printer, the resin vat, and the building plate.

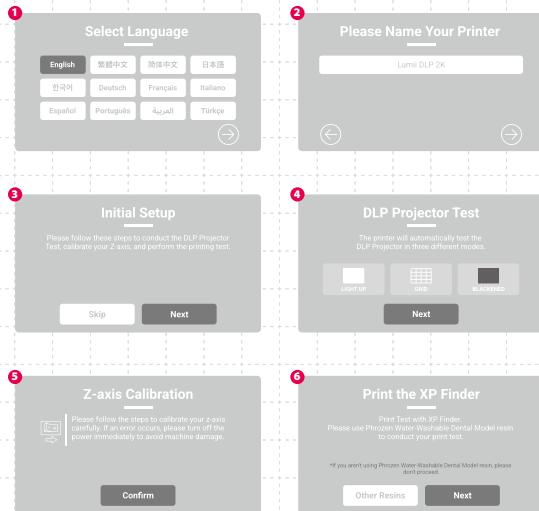


04 Initial Startup Procedures

When turning on your 3D printer for the first time, please follow the on-screen instructions on the touch panel to complete the initial tests, including the DLP projector test, z-axis calibration, and first test print.

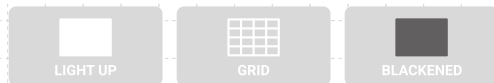
- 1 Select the language.
- 2 Insert a name for your printer.
- 3 Click on "NEXT" to continue the initial startup procedure.
- 4 Complete the initial DLP Projector Test.
- 5 Complete the initial Z-axis Calibration.
- 6 Complete the first test printing. The system provides a pre-sliced **XP Finder test file** using the optimal parameters for **Phrozen Dental Water-Washable Resin**.

* If you use other resin material, please follow section 07 and section 08 to prepare your files and conduct a printing test.



05 DLP Projector Test

- 1 Head to the "Settings" menu. Click on "Hardware Testing" and select the "DLP Projector Test."
- 2 Below are three DLP Projector tests that need to be conducted.

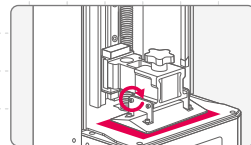
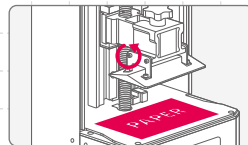


- 3 Place a sheet of blank white paper on top of the glass screen, then click each test to see if the DLP Projector displays the same image as seen on the touch panel.
- 4 When the projector displays all 3 images clearly, the DLP Projector test is complete.

* Please refer to the actual printer operation based on the touchscreen display.

06 Z-axis Calibration

- 1 Click on TOOLS. Then click on Z-axis calibration.
- 2 Remove the resin vat and place 1 piece of A4 paper on the glass screen.
- 3 Install the building plate and tighten the thumb screw. Loosen all 4 calibration screws on the building plate.
- 4 Click on NEXT. Wait until the building plate touches the glass screen.
- 5 Tighten all 4 calibration screws. Make sure the paper is unmovable, then click DONE to finish the calibration.
- 6 Wait until the building plate retracts to the top. Z-axis Calibration is now complete.



07 Prepare Your 3D Files With DS Slicer

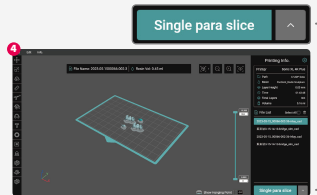
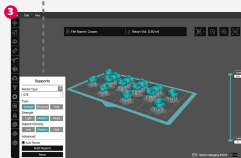
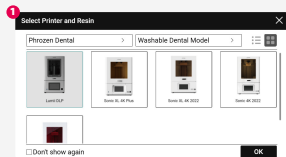
Lumii DLP only supports .PRZ file format. Use Phrozen DS Slicer software to turn your .STL files into .PRZ files.

Prepare files with Phrozen DS Slicer

- 1 Choose "Lumii DLP" printer and select the resin parameters according to the resin used.
- 2 Import your STL files into Phrozen DS Slicer software.
- 3 DS Slicer provides auto support and orientation functions for preparing various dental indications. Go to "Support Menu" Select the indication you intend to print, then choose the **type**, **density**, and **strength** for your support, and turn on the "Auto Rotate" function.
- 4 Once the objects are ready to be printed, slice the object by clicking the "Single para slice" button located in the bottom right corner.
- 5 Import your 3D files:
 - Save the sliced .PRZ file into your USB drive.
 - Plug in the USB drive into the 3D printer.
 - Head to "Print" > Click on "USB" > Select your file > Wait for upload.

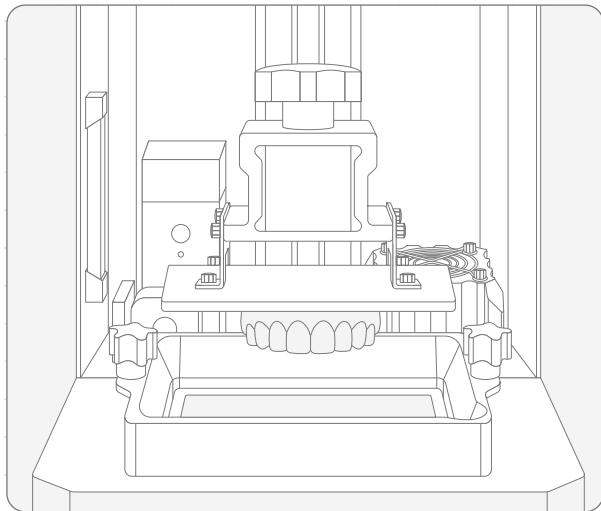


Download DS Slicer



08 Perform Printing Test

- 1 Install the building plate and resin vat. Make sure that both are parallel to the printer and its surface is clean.
- 2 Shake the resin bottle for 1 minute. When pouring, make sure the resin does not exceed the mark on the resin vat.
- 3 The building plate will go down automatically and begin printing.
- 4 After the printing process begins, the Air Filtration System will turn on automatically.
(Make sure to first insert the Air Purifier unit)
- 5 Keep the cover closed during printing to avoid excessive UV light.
- 6 After the printing process is complete, remove the building plate from the printer. Tilt and place it onto a desk and use a metal scraper to carefully remove your print.



After-sales service & warranty

- Phrozen offers a one-year warranty for all parts, excluding consumable components such as the DLP projector, building plate, and Resin Vat.
- Lumii DLP Projector is covered under a 12 month warranty. Please note that this warranty does not cover any damage caused by human factors.
- If you encounter any difficulties, please scan the QR codes down below to contact us.

FC CE E R 210-239039 CCAJ24LPAEV077

Contact us !



Congratulations!

You have just completed your first run.
We hope you've had a great experience!

Please follow Phrozen's social media accounts
to learn more about printing tips and share
information with the community.



Facebook



Facebook Group



Instagram



**Phrozen Dental
Official Website**



YouTube