MonoPrinter.com

MonoWare Job File Structure

Rev. 1.0



MONO PRINTER

Revision History Document number: MNWR-S01

Rev. 1.0	07-19-2022	Initial draft, MonoWare version: 0.41

Please read thoroughly and contact us if you have any further questions or suggestions at info@monoprinter.com

MONO PRINTER

1. Job file structure

- The job file (*.mnf) is a password protected zip file.
- The password is "MONO129034" without double quotation marks.
- After you unzip a job file, its folder has the following files.



- Fig. 1
- buildscript.ini has a printing sequence with layer exposure/movement information
- parameters.ini has printer and slicing information.
- Preview_***.png images are 5 snapshots of the scene to be printed.
- S*****_P1.png images are actual slice images to be projected on the printer.

MONO PRINTER

2. Structure of buildscript.ini file

📕 buildscript.ini - Notepad				
<u>F</u> ile <u>E</u> dit F <u>o</u> rmat <u>V</u> iew <u>H</u> elp	Total slice counts			
Machine = MONO3 20um				
Slice thickness = 50				
number of slices = 200	Normal layer exposure			
illumination time = 2.5				
number of override slices = 2 🛶				
override illumination time = 40 <	Base laver counts			
support burn in time = 0				
0.0000, S000001_P1, 40.0, 4.0, 0, 0	.0			
0.0500, S000002_P1, 40.0, 4.0, 0, 0	. ⁰ Base laver exposure			
0.1000, S000003_P1, 2.5, 4.0, 0, 0.				
0.1500, S000004_P1, 2.5, 4.0, 0, 0.				
0.2000, S000005_P1, 2.5, 4.0, 0, 0.				
0.2500, 5000000_P1, 2.5, 4.0, 0, 0.				
0.3000, 5000007_P1, 2.5, 4.0, 0, 0.				
0.5500, 5000000_P1, 2.5, 4.0, 0, 0.	8			
a 4500 S00005_F1, 2.5, 4.0, 0 150	$0.0 \rightarrow 1$ aver height (mm)			
a 5000 S000010_F1, 2.5, 4.0, 0.10	004 P1 \rightarrow slice file name			
0.5500, S000012 P1, 2.5, 3.0, 2.5	$\sim 2 \times 2 $			
0.6000. S000013 P1. 2.5. 3.0.	\rightarrow exposure time (sec),			
0.6500, S000014 P1, 2.5, 3.0, 4.0 -	\rightarrow lift distance (mm),			
0.7000, S000015 P1, 2.5, 3.0, $0 \rightarrow$	layer type,			
0.7500, S000016 P1, 2.5, 3.0, 0.0 -	→ delay time (sec)			
0.8000, S000017_P1, 2.5, 3.0,	0			
0.8500, S000018_P1, 2.5, 3.0, 0, 0.	0			
0.9000, S000019_P1, 2.5, 3.0, 0, 0.	0			
0.9500, S000020_P1, 2.5, 3.0, 0, 0.	0			
1.0000, S000021_P1, 2.5, 3.0, 0, 0.	0			
1.0500, S000022_P1, 2.5, 3.0, 0, 0.	0			
1.1000, S000023_P1, 2.5, 3.0, 0, 0.	0			
1.1500, S000024_P1, 2.5, 3.0, 0, 0.	0			
1.2000, S000025_P1, 2.5, 3.0, 0, 0.	0			
1.2500, S000026_P1, 2.5, 3.0, 0, 0.	0			
1.3000, S000027_P1, 2.5, 3.0, 0, 0.	0			
1.3500, S000028_P1, 2.5, 3.0, 0, 0.	0			
1.4000, S000029_P1, 2.5, 3.0, 0, 0.	0 v			
Ln 1, Col 1 100% Window	vs (CRLF) UTF-8			
Fig. 2				

- When you open the buildscript.ini file, you will see a few header information followed by each layer information.
- You will understand header information easily.
- Each layer has one or more layers depending on the printing process and printer type.
- If you want to modify the job file outside of MonoWare, the total slice counts should be matched to the actual number of layers. Each layer's information should be formatted exactly the same as above to avoid any crash during printing.



3. Manually modified job file

- If you want to replace the slice images, you have to keep the same pixel array and image format (ex. 1920 x 1080, 8 bit depth for Mono3 DLP printers).
- Once you modify the job file manually, make a zip file from all of the above files into a single file with the same password mentioned in Step 1.
- Test the new job file without a resin first since the file can cause an issue.

4. Closing remarks

• If you have any issues while using the printer, please contact us at info@monoprinter.com