MonoPrinter.com

MonoWare Job File Structure

Rev. 1.2

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Revision History

Document number: MNWR-S01

Rev. 1.0	07-19-2022	Initial draft, MonoWare version: 0.41
Rev. 1.1	09-09-2022	Added a procedure how to make MNF files after slice modification
Rev. 1.2	06-10-2024	“Pause” printing with manual edit of the buildscript

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

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.

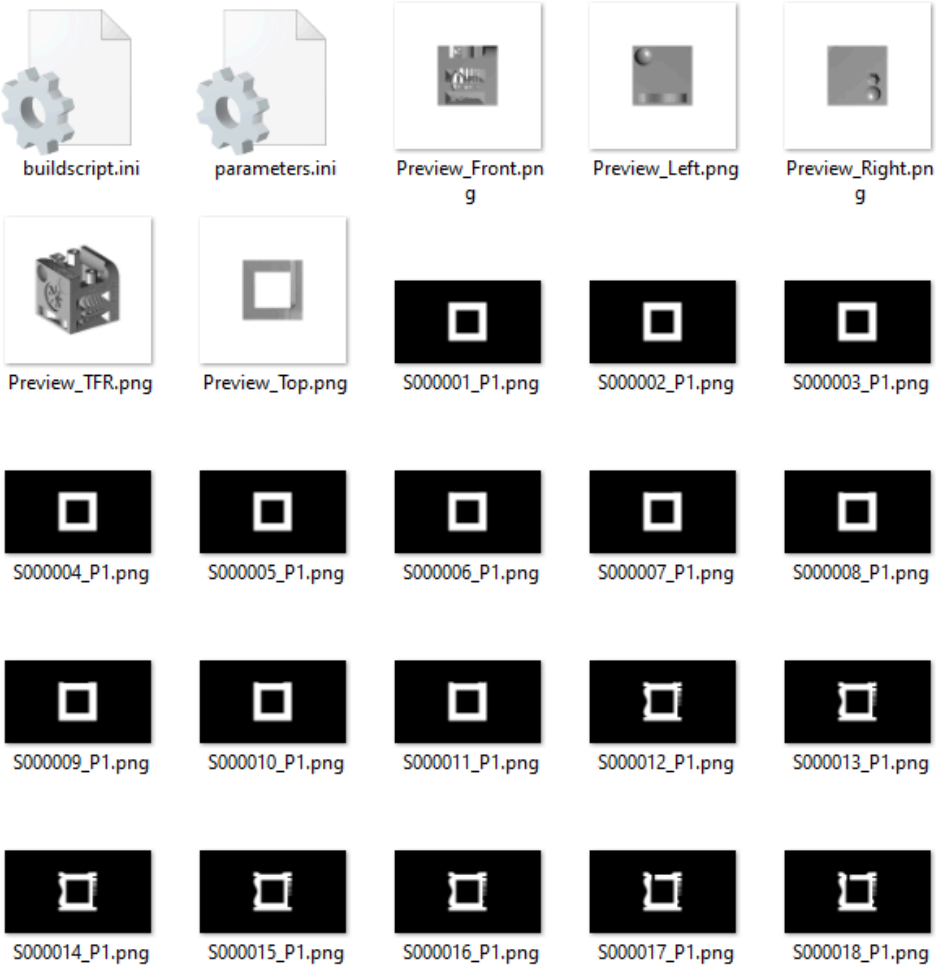

Fig. 1. Extracted files in a job file

- 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.

2. Structure of buildscript.ini file

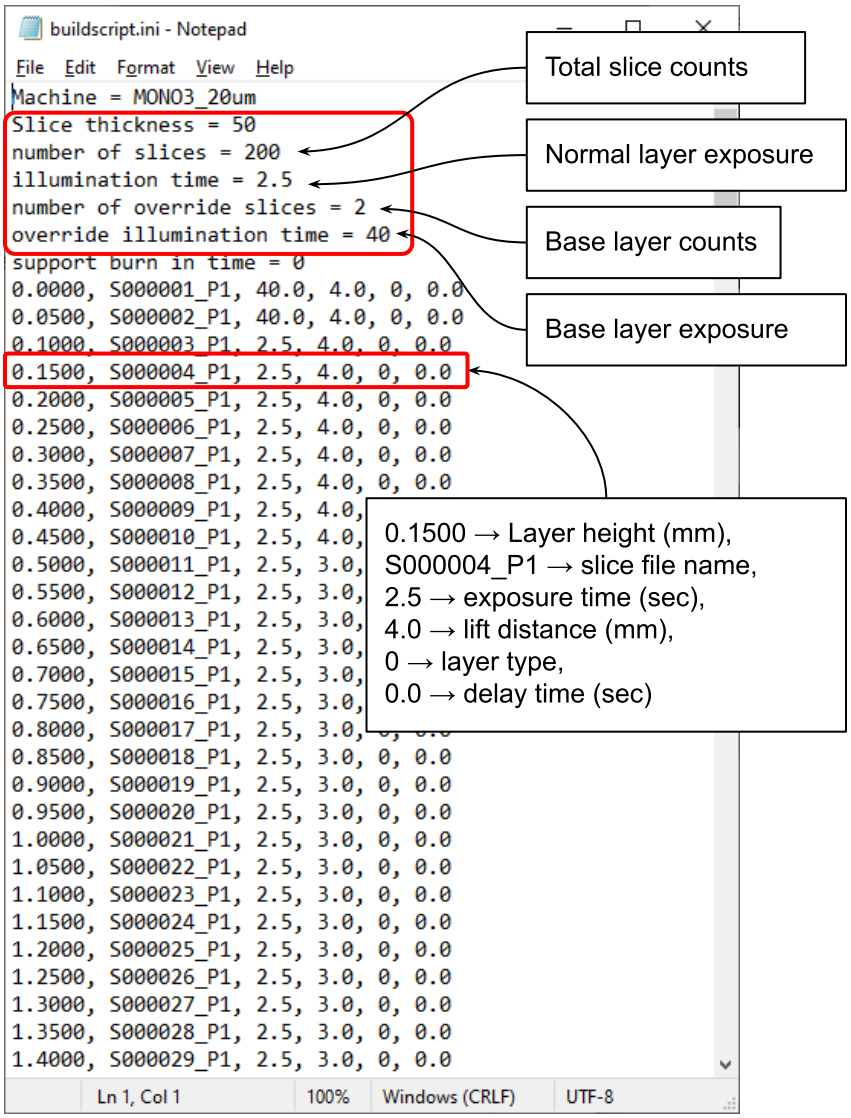

Fig. 2. Buildscript file

- 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. Making an MNF file

- If you don't have 7zip, install it first from here: https://www.7-zip.org/
- Select files and open 7zip. Right click >> 7zip >> Add to archive
- Update the file name, Archive format (zip), password, and encryption method (ZipCrypto).
- Then press OK to create a new MNF file.

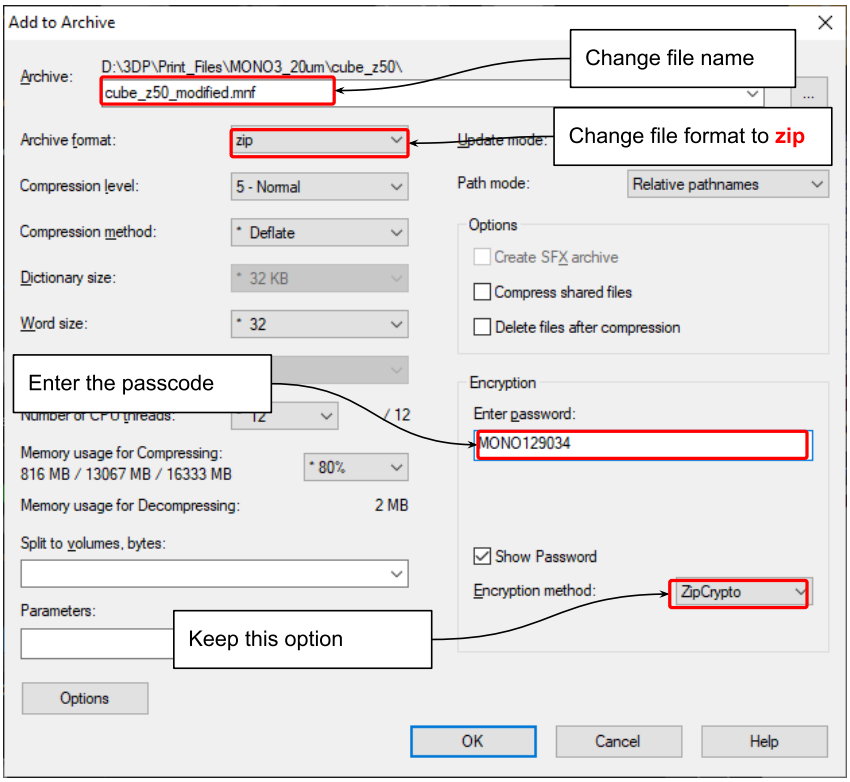

Fig. 3. How to zip the job file using 7zip

5. Adding "pause" commands to the buildscript.ini

INFO ***This feature is added on or after the firmware version of 3.2K (K series firmware for single channel printer). Please consult us if you need this feature with Z series firmware.***

- If you want to pause the printing process after certain layers, you can edit the buildscript.ini and add “pause” statements.
- Every time the firmware detects the “pause” commands, the printing process is paused and waits for user input.
- You can add multiple “pause” commands.

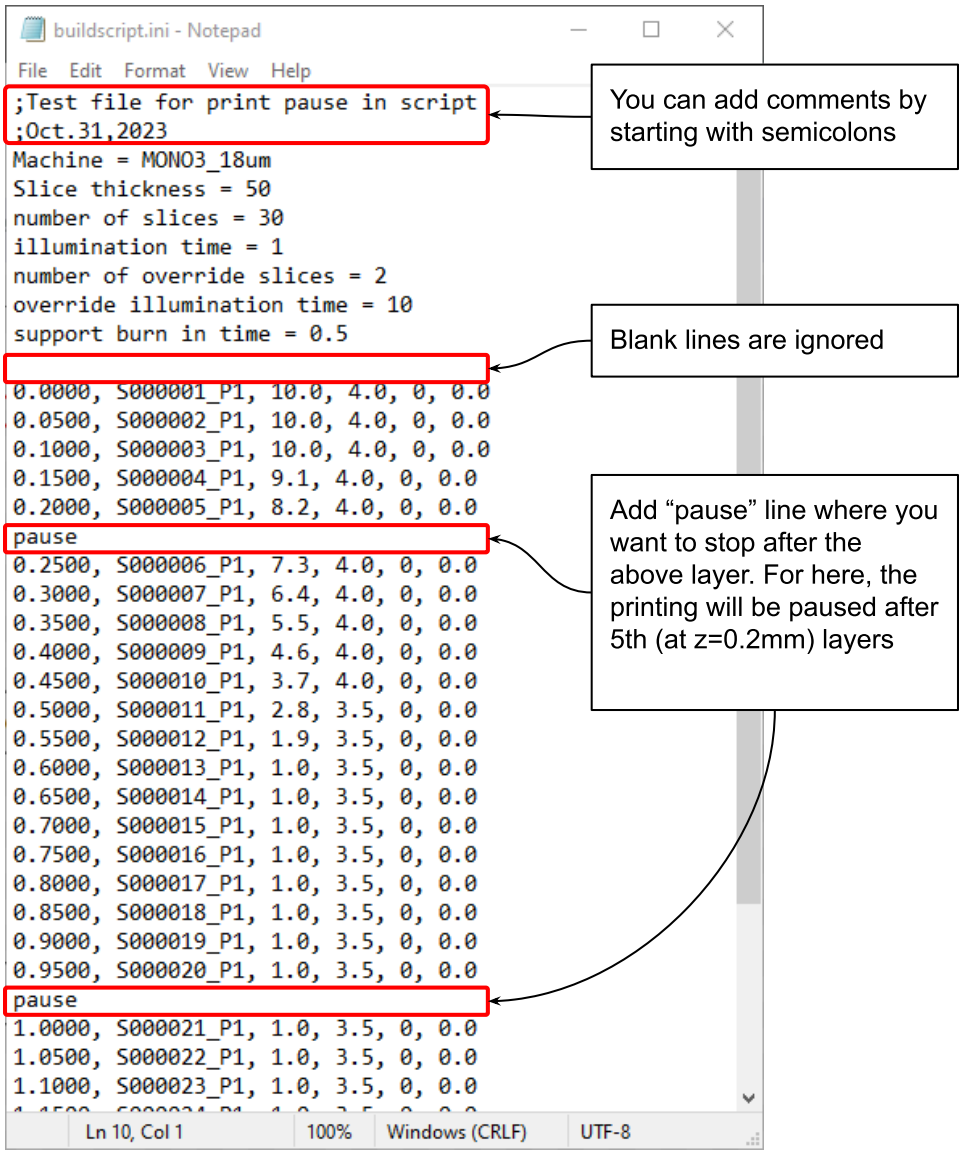

Fig. 4. Edit the buildscript.ini to add “pause” layers

6. Closing remarks

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