Annex 1

Digital light Processing (DLP) printer, operation software and parameter

Model (Picture)	Printer Manufacturer, Model	Light source	Light intensity	Operation Software	Parameter data set*
	Asiga Max	385 nm	6.1 mW/cm²	Composer 1.2.11	Detax_Medicalprint mould **COLOR**_5
	Asiga Max 2	385 nm	7.0 mW/cm²	Composer 2.0.8	Detax_Medicalprint mould **COLOR**_5
	Asiga Pico 2	385 nm	20 mW/cm²	Composer 1.2.11	Detax_Medicalprint mould **COLOR**_5
	Asiga PRO 2	385 nm	5.7 mW/cm²	Composer 1.2.11	Detax_Medicalprint mould **COLOR**_5
	Asiga PRO 4K	385 nm	7.0 mW/cm²	Composer 1.2.11	Detax_Medicalprint mould **COLOR**_5
	Asiga Ultra	385 nm	6.6 mW/cm²	Composer 2.0.8	Detax_Medicalprint mould **COLOR**_5
	Microlay Versus	385 nm	4.3 mW/cm²	Microform 1.0.3.7	DETAX Medicalprint Mould **COLOR** 100 microns v5.3

*The set of parameters includes all relevant material- and printer specific information
The placeholder **COLOR** shall be replaced by **clear, clear 2.0, rose, rose 2.0** or **rose-orange 2.0**

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Digital light Processing (DLP) printer, operation software and parameter

Model (Picture)	Printer Manufacturer, Model	Light source	Light intensity	Operation Software	Parameter data set*
	Miicraft Alpha	385 nm	6.0 mW/cm²	Utility 6.4.4	DETAX Medicalprint mould clear 2.0
	Miicraft Prime Series	385 nm	6.2 mW/cm²	Utility 6.3.0	Detax_Medicalprint mould **COLOR**_100_PH
	Miicraft Ultra Series	385 nm	5.7 mW/cm²	Utility 6.3.0	Detax_Medicalprint mould **COLOR**_100
	Rapidshape HA20+/ HA30+/HA40+	385 nm	2.0 mW/cm²	Netfabb 2020	MedicalPrint mould **COLOR**
	Rapidshape HA70+/HA90+	385 nm	5.0 mW/cm²	Netfabb 2020	MedicalPrint mould **COLOR**
	Way2Production SolFlex Series	385 nm	8.0 mW/cm²	Netfabb 2020	MedicalPrint mould **COLOR**

*The set of parameters includes all relevant material- and printer specific information
The placeholder **COLOR** shall be replaced by **clear, clear 2.0, rose, rose 2.0** or **rose-orange 2.0**

Cleaning Equipment

Cleaning unit Manufacturer, Model	Cleaning process**
Rapidshape RS wash	Use the following settings: MedicalPrint mould **COLOR** Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air.
Ultrasonic bath Bandelin Sonorex	Clean the parts with isopropyl alcohol (purity ≥ 98 %) for 3 minutes. Then thoroughly clean the openings, cavities and gap areas with compressed air. The main cleaning is performed in a seperate vessel with fresh isopropyl alcohol (purity ≥ 98 %) for 3 minutes. Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air.

The placeholder **COLOR shall be replaced by **clear, clear 2.0, rose, rose 2.0** or **rose-orange 2.0**

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Light curing Equipment

Light Curing unit Manufacturer, Model	Curing process***
Dentalfarm Photopol	2 × 6 min, 120 % + N_2, turn around components after 6 min
NK Optik Otoflash G171	2 × 2000 flashes under inert gas, turn around components after 2000 flashes
NK Optik Otoflash 250/500	4000 flashes under inert gas @15 Hz
Rapidshape RS cure	Use the following settings: MedicalPrint mould **COLOR**
Rapidshape RS cure XL	Use the following settings: MedicalPrint mould **COLOR**

***The placeholder **COLOR** shall be replaced by **clear, clear 2.0, rose, rose 2.0** or **rose-orange 2.0**

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Mechanical finishing

Polishing unit Manufacturer, Model	Polishing process
Otec ECO-Maxi wet	Step 1: Media: DZS 10/10 Ceramic grinding wheel, Compound: SC 15 Compound, Runtime: 90 min, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 4 l/h Step 2: Media: KM 10 plastic abrasive media (70 %), PM 10 plastic abrasive media (30 %), Compound: SC 15 Compound, Runtime: 90 min, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 4 l/h Step 3: Media: ZSP 4/5 Porcelain polishing body, Runtime: 60 min, Splitting system: Wet splitting, Speed: 260 U/min, Water flow: 10 l/h
Otec CF 3x18	Step 1: Media: DZS 10/10 Ceramic grinding wheel, Compound: SC 15 Compound, Runtime: 90 min, Rib shape: standard, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 8 l/h Step 2: Media: KM 10 plastic abrasive media (70 %), PM 10 plastic abrasive media (30 %), Compound: SC 15 Compound, Runtime: 90 min, Rib shape: standard, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 8 l/h Step 3: Media: ZSP 4/5 Porcelain polishing body, Runtime: 60 min, Rib shape: standard, Splitting system: Wet splitting, Speed: 240 U/min, Water flow: 15 l/h