Annex 1

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

Model (Picture)	Printer Manufacturer	Light source	Light intensity	Operation Software	Parameter data set*
	Asiga Max	385 nm	7.0 mW/cm²	Composer 1.2.11	Detax_Medicalprint nobreak COLOR_5
	Asiga Max 2	385 nm	7.0 mW/cm²	Composer 2.0.8	Detax_Medicalprint nobreak COLOR_5
	Asiga PRO 4K	385 nm	7.0 mW/cm	Composer 1.2.11	Detax_Medicalprint nobreak COLOR_5
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_Medicalprint nobreak COLOR_5
	Rapidshape HA2O+/HA3O+ /HA4O+	385 nm	2.0 mW/cm ²	Netfabb 2020	Medicalprint nobreak COLOR

* The set of parameters includes all relevant material- and printer specific information The placeholder COLOR shall be replaced by beige, black, blue-transparent, brown, clear, dark brown, dark grey, green-opaque, light beige, light grey, medium brown, neon yellow, orange-transparent, purple, red-transparent, rose, rose-orange, skin or white

Cleaning Equipment

Cleaning unit Manufacturer, Model	Cleaning process**	
Rapidshape RS	Use the following settings: Medicalprint nobreak COLOR	
wash	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 \ge 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 \ge 98 %) for 3 minutes.	
	Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air.	

Light curing Equipment

Light Curing unit Manufacturer, Model	Curing process**
Dreve PCU LED N ₂	Option 1 Intensity = 33 %, Duration = 6 min 40 s; for clear, light beige, rose and rose-orange Option 2 Intensity = 80 %, Duration = 6 min 40 s; for beige, brown, medium brown and skin Option 3 Intensity = 80 %, Duration = 7 min 30 s; for dark brown Option 4 Intensity = 40 %, Duration = 6 min 40 s; for white Option 5 Intensity = 80 %, Duration = 12 min; for black, dark grey and green Option 6 Intensity = 80 %, Duration = 8 min; for blue-transparent, light grey, neon yellow, orange-transparent, purple and red-transparent

** The placeholder COLOR shall be replaced by beige, black, blue-transparent, brown, clear, dark brown, dark grey, green-opaque, light beige, light grey, medium brown, neon yellow, orange-transparent, purple, red-transparent, rose, rose-orange, skin or white

Light curing Equipment

Manufacturer, Model Curin	ng process**
NK Optik Otoflash 2×2	000 flashes under inert gas, turn around components
G171 after	2000 flashes

Rapidshape RS cure Use the following settings: Medicalprint nobreak COLOR

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 I/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: 41/h
	Step 3: Media: ZSP 4/5 Porcelain polishing body, Runtime: 60 min, Splitting system: Wet splitting, Speed: 260 U/min, Water flow: 10 I/h

** The placeholder COLOR shall be replaced by beige, black, blue-transparent, brown, clear, dark brown, dark grey, green-opaque, light beige, light grey, medium brown, neon yellow, orange-transparent, purple, red-transparent, rose, rose-orange, skin or white

