

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/cm ²	Composer 1.2.11	Detax_Medicalprint shell COLOR_5
	Asiga Max 2	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Medicalprint shell COLOR_5
	Asiga Pico 2	385 nm	20 mW/cm ²	Composer 1.2.11	Detax_Medicalprint shell COLOR_5
	Asiga PRO 2	385 nm	5.7 mW/cm ²	Composer 1.2.11	Detax_Medicalprint shell COLOR_5
	Asiga PRO 4K	385 nm	7.0 mW/cm ²	Composer 1.2.11	Detax_Medicalprint shell COLOR_5
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_Medicalprint shell COLOR_5

*The set of parameters includes all relevant material- and printer specific information

The placeholder **COLOR** shall be replaced by **beige 2.0, skin 2.0, dark brown, medium brown, black, blue-opaque, red-opaque or white**

Note that **COLOR** white is not authorized for Rapidshape printers; **COLOR** dark/medium brown are authorized only for Asiga Max printer

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Model (Picture)	Printer Manufacturer, Model	Light source	Light intensity	Operation Software	Parameter data set*
	Microlay Versus	385 nm	4.3 mW/cm ²	Microform 1.0.3.7	DETAX Medicalprint Shell COLOR 100 microns v5.3
	Miicraft Alpha	385 nm	6.0 mW/cm ²	Utility 6.4.4	DETAX Medicalprint Shell COLOR 100 microns v5.3
	Miicraft Prime Series	385 nm	6.2 mW/cm ²	Utility 6.3.0	Detax_Medicalprint shell COLOR_100_PH
	Miicraft Ultra Series	385 nm	5.7 mW/cm ²	Utility 6.3.0	Detax_Medicalprint shell COLOR_100
	Rapidshape HA20+/ HA30+/HA40+	385 nm	2.0 mW/cm ²	Netfabb 2020	MedicalPrint COLOR
	Rapidshape HA70+/HA90+	385 nm	5.0 mW/cm ²	Netfabb 2020	MedicalPrint COLOR

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Model (Picture)	Printer Manufacturer, Model	Light source	Light intensity	Operation Software	Parameter data set*
	Way2Production SolFlex Series	385 nm	8.0 mW/cm ²	Netfabb 2020	Medicalprint Shell COLOR

*The set of parameters includes all relevant material- and printer specific information
The placeholder **COLOR** shall be replaced by **beige 2.0, skin 2.0, dark brown, medium brown, black, blue-opaque, red-opaque or white**
Note that **COLOR** white ist not authorized for Rapidshape printers; **COLOR** dark/medium brown are authorized only for Asiga Max printer

Cleaning Equipment

Cleaning unit	
Manufacturer, Model	Cleaning process**
Rapidshape RS wash	Use the following settings: MedicalPrint 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 $\geq 98\%$) for 3 minutes. Then thoroughly clean the openings, cavities and gap areas with compressed air. The main cleaning is performed in a separate vessel with fresh isopropyl alcohol (purity $\geq 98\%$) 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 **beige 2.0, skin 2.0, dark brown, medium brown, black, blue-opaque, red-opaque or white**
Note that **COLOR** dark/medium brown shall be washed only with Ultrasonic bath Bandelin Sonorex



Light curing Equipment

Light Curing unit	
Manufacturer, Model	Curing process***
Dentalfarm Photopol	2 x 6 min, 120 % + N ₂ , turn around components after 6 min
Dreve PCU LED N2	12 min, 80 %, vacuum and protective gas
NK Optik Otofash G171	2 x 2000 flashes under inert gas, turn around components after 2000 flashes
NK Optik Otofash 250/500	4000 flashes under inert gas @15 Hz
Rapidshape RS cure	Use the following settings: MedicalPrint COLOR
Rapidshape RS cure XL	Use the following settings: MedicalPrint COLOR

The placeholder **COLOR shall be replaced by **beige 2.0, skin 2.0, dark brown, medium brown, black, blue-opaque, red-opaque or white**

Note that **COLOR** white shall only be cured with NK Optik Otofash G171 or Dentalfarm Photopol; **COLOR** dark/medium brown are authorized only for NK Optik Otofash G171



detax GmbH

Carl-Zeiss-Str. 4 • 76275 Ettlingen • Germany
+49 7243 510 0 • post@detax.com • detax.com

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Mechanical finishing

Polishing unit

Manufacturer, Model	Polishing process
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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
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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
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