

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_Freeprint cast 2.0 385_5
	Asiga Max 2	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Freeprint cast 2.0 385_5
	Asiga Pico 2	385 nm	20 mW/cm ²	Composer 1.2.11	Detax_Freeprint cast 2.0 385_5
	Asiga PRO 2	385 nm	5.7 mW/cm ²	Composer 1.2.11	Detax_Freeprint cast 2.0 385_5
	Asiga PRO 4K	385 nm	7.0 mW/cm ²	Composer 1.2.11	Detax_Freeprint cast 2.0 385_5
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_Freeprint cast 2.0 385_5
	Ivoclar Progra- Print PR5	388 nm	16 mW/cm ²	PrograPrint CAM 1.1.10.1	DetaxFREEPRINT cast 2.0

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

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	Microlay Eve Pro	405 nm	3.5 mW/cm ²	Microform 1.0.3.7	DETAX Freeprint Cast 2.0 385 100 microns v2.1
	Microlay Versus	385 nm	4.3 mW/cm ²	Microform 1.0.3.7	DETAX Freeprint Cast 2.0 385 50 microns v5.3
	Miicraft Alpha	385 nm	6.0 mW/cm ²	Utility 6.4.4	DETAX Freeprint cast 2.0
	Miicraft Prime Series	385 nm	6.2 mW/cm ²	Utility 6.3.0	Detax_Freeprint cast 2.0 385_100_PH
	Miicraft Ultra Series	385 nm	5.7 mW/cm ²	Utility 6.3.0	Detax_Freeprint cast 2.0 UV_100
	Phrozen Sonic 4K 2022	405 nm	2.0 mW/cm ²	Phrozen DS Slicer	DETAX Freeprint cast 2.0
	Rapidshape D20+/ D30+/ D40+	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-cast 2.0 385

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	Shining 3D AccuFab D1s	405 nm	7.6 mW/cm ²	AccuWare	DETAX FREEPRINT cast 2.0 385
	Shining 3D AccuFab L4D	405 nm	2.2 mW/cm ²	AccuWare	DETAX FREEPRINT cast 2.0 385
	Way2Production SoliFlex Series	385 nm	8.0 mW/cm ²	Netfabb 2020	Freeprint cast 2.0 385

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

Cleaning Equipment

Cleaning unit

Manufacturer, Model	Cleaning process
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Ivoclar PrograPrint Clean	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.
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Rapidshape RS wash	Use the following settings: DETAX Freeprint cast 2.0 385 Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air.
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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.
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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
Formlabs FormCure	30 min
Ivoclar PrograPrint Cure	Post curing A: Wavelength = 405 nm; Intensity = 100 %; Duration = 120 s Post curing B: Wavelength = 460 nm; Intensity = 100 %; Duration = 120 s
Meccatronicore BB Cure	30 min; 85 % Power
NK Optik Otoflash G171	2 x 2000 flashes under inert gas, turn around components after 2000 flashes
NK Optik Otoflash 250/500	4000 flashes under inert gas @15 Hz
Phrozen PhrozenCure	30 min
Prusa Research Medical CW One	30 min
Rapidshape RS cure	Use the following settings: DETAX Freeprint-cast 2.0 385
Rapidshape RS cure XL	Use the following settings: DETAX Freeprint-cast 2.0 385
Shining 3D FabCure	30 min



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