

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 crown_5
	Asiga Max 2	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Freeprint crown_5
	Asiga PRO 4K	385 nm	7.0 mW/cm ²	Composer 1.2.11	Detax_Freeprint crown_5
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_Freeprint crown_5
	Heygears UltraCraft A2D HD	385 nm	1.75 mW/cm ²	Heygears Cloud V4.3.7.6	Detax Crown

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

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Model (Picture)	Printer Manufacturer, Model	Light source	Light intensity	Operation Software	Parameter data set*
	Ivoclar PrograPrint PR5	388 nm	16 mW/cm ²	PrograPrint CAM 1.1.10.1	Detax FREEPRINT crown
	LuxCreo FastPrint.io	385 nm	6 mW/cm ²	LuxFlow v3.1.0.301229	DETAX freeprint-crown
	Microlay Versus	385 nm	4.3 mW/cm ²	Microform 1.0.3.7	DETAX Freeprint Crown 385 50 microns v5.6
	Rapidshape D10+/D20+/ D30+/D40+	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-crown

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

Cleaning Equipment

Cleaning unit

Manufacturer, Model	Cleaning process
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 2 minutes. Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air.
Rapidshape RS wash	Use the following settings: DETAX Freeprint-crown 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 1 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 1 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
Ivoclar PrograPrint Cure	Post curing A: Wavelength = 405 nm; Intensity = 45 %; Duration = 5 min Post curing B: Wavelength = 460 nm; Intensity = 45 %; Duration = 5 min
LuxCreo ILCD	Program „P02“
NK Optik Otoflash G171	2 × 2000 flashes under inert gas, turnaround components after 2000 flashes
NK Optik Otoflash 250/500	4000 flashes under inert gas @15 Hz
Rapidshape RS cure	Use the following settings: DETAX Freeprint-crown
Rapidshape RS cure XL	Use the following settings: DETAX Freeprint-crown



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