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	7.0 mW/cm²	Composer 1.2.11	Detax_Freeprint denture flex_5
	Asiga Max 2	385 nm	7.0 mW/cm²	Composer 2.0.8	Detax_Freeprint denture flex_5
	Asiga PRO 4K	385 nm	7.0 mW/cm	Composer 1.2.11	Detax_Freeprint denture flex_5
	Asiga Ultra	385 nm	6.6 mW/cm²	Composer 2.0.8	Detax_Freeprint denture flex_5
	Rapidshape D10+/D20+/D30+/D40+	385 nm	2.0 mW/cm²	Netfabb 2020	DETAX Freeprint-denture-flex

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

Cleaning Equipment

Cleaning unit Manufacturer, Model	Cleaning process
Rapidshape RS wash	Use the following settings: DETAX Freeprint-denture-flex
	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.

Light curing Equipment

Light Curing unit Manufacturer, Model	Curing process
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
Rapidshape RS cure	Use the following settings: DETAX Freeprint-denture-flex