

# Annex 1

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

| Model<br>(Picture)                                                               | Printer<br>Manufacturer,<br>Model | Light<br>source | Light<br>intensity     | Operation<br>Software | Parameter<br>data set*    |
|----------------------------------------------------------------------------------|-----------------------------------|-----------------|------------------------|-----------------------|---------------------------|
|  | Asiga Max                         | 385 nm          | 6.1 mW/cm <sup>2</sup> | Composer 1.2.11       | Detax_Freeprint IBT 385_5 |
|  | Asiga Max 2                       | 385 nm          | 7.0 mW/cm <sup>2</sup> | Composer 2.0.8        | Detax_Freeprint IBT 385_5 |
|  | Asiga Pico 2                      | 385 nm          | 20 mW/cm <sup>2</sup>  | Composer 1.2.11       | Detax_Freeprint IBT 385_5 |
|  | Asiga PRO 2                       | 385 nm          | 5.7 mW/cm <sup>2</sup> | Composer 1.2.11       | Detax_Freeprint IBT 385_5 |
|  | Asiga PRO 4K                      | 385 nm          | 7.0 mW/cm <sup>2</sup> | Composer 1.2.11       | Detax_Freeprint IBT 385_5 |
|  | Asiga Ultra                       | 385 nm          | 6.6 mW/cm <sup>2</sup> | Composer 2.0.8        | Detax_Freeprint IBT 385_5 |

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

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|----------------------------------------------------------------------------------|---------------------------------------|-----------------|------------------------|-----------------------|---------------------------------------------|
|  | Microlay<br>Versus                    | 385 nm          | 4.3 mW/cm <sup>2</sup> | Microform<br>1.0.3.7  | DETAX Freeprint IBT 385<br>100 microns v5.3 |
|  | Miicraft Alpha                        | 385 nm          | 6.0 mW/cm <sup>2</sup> | Utility 6.4.4         | DETAX freeprint IBT                         |
|  | Miicraft Prime<br>Series              | 385 nm          | 6.2 mW/cm <sup>2</sup> | Utility 6.3.0         | Detax_Freeprint<br>IBT 385_100_PH           |
|  | Miicraft Ultra<br>Series              | 385 nm          | 5.7 mW/cm <sup>2</sup> | Utility 6.3.0         | Detax_Freeprint<br>IBT UV_100               |
|  | Rapidshape<br>D10+/D20+/<br>D30+/D40+ | 385 nm          | 2.0 mW/cm <sup>2</sup> | Netfabb 2020          | DETAX Freeprint<br>IBT 385                  |
|  | Way2Produc-<br>tion SolFlex<br>Series | 385 nm          | 8.0 mW/cm <sup>2</sup> | Netfabb 2020          | Freeprint IBT 385                           |

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## Cleaning Equipment

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### Cleaning unit

| Manufacturer, Model | Cleaning process |
|---------------------|------------------|
|---------------------|------------------|

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|                           |                                                                                                                                                                            |
|---------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Rapidshape RS wash</b> | Use the following settings: DETAX Freeprint IBT 385<br>Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air. |
|---------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

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|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                     |
|---------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Ultrasonic bath<br/>Bandelin Sonorex</b> | Clean the parts with isopropyl alcohol (purity $\geq 98\%$ ) for 3 minutes. Then thoroughly clean the openings, cavities and gap areas with compressed air.<br><br>The main cleaning is performed in a separate vessel with fresh isopropyl alcohol (purity $\geq 98\%$ ) for 3 minutes.<br><br>Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air. |
|---------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

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**detax GmbH**

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

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## Light curing Equipment

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### Light Curing unit

| Manufacturer, Model | Curing process |
|---------------------|----------------|
|---------------------|----------------|

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|------------------------|------------------------------------------------------------------------------|
| Dentalfarm<br>Photopol | 2 × 3 min, progressive + N <sub>2</sub> , turn around components after 3 min |
|------------------------|------------------------------------------------------------------------------|

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|                           |                                                                             |
|---------------------------|-----------------------------------------------------------------------------|
| NK Optik Otoflash<br>G171 | 3 × 2000 flashes under inert gas, turn around components after 2000 flashes |
|---------------------------|-----------------------------------------------------------------------------|

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|------------------------------|-------------------------------------|
| NK Optik Otoflash<br>250/500 | 4000 flashes under inert gas @15 Hz |
|------------------------------|-------------------------------------|

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|-----------------------|-----------------------------------------------------|
| Rapidshape<br>RS cure | Use the following settings: DETAX Freeprint IBT 385 |
|-----------------------|-----------------------------------------------------|

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|--------------------------|-----------------------------------------------------|
| Rapidshape<br>RS cure XL | Use the following settings: DETAX Freeprint IBT 385 |
|--------------------------|-----------------------------------------------------|

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