

# 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          | 7.0 mW/cm <sup>2</sup> | Composer 1.2.11       | Detax_Freeprint model pro<br><b>COLOR_5</b> |
|  | Asiga Max 2                       | 385 nm          | 7.0 mW/cm <sup>2</sup> | Composer 2.0.8        | Detax_Freeprint model pro<br><b>COLOR_5</b> |
|  | Asiga PRO 4K                      | 385 nm          | 7.0 mW/cm <sup>2</sup> | Composer 1.2.11       | Detax_Freeprint model pro<br><b>COLOR_5</b> |
|  | Asiga Ultra                       | 385 nm          | 6.6 mW/cm <sup>2</sup> | Composer 2.0.8        | Detax_Freeprint model pro<br><b>COLOR_5</b> |
|  | Miicraft Alpha                    | 385 nm          | 6.0 mW/cm <sup>2</sup> | Utility 6.4.4         | DETAX freeprint model pro                   |
|  | Phrozen Sonic<br>4K 2022          | 405 nm          | 2.0 mW/cm <sup>2</sup> | Phrozen DS<br>Slicer  | DETAX Freeprint<br>model Pro                |

\*The set of parameters includes all relevant material- and printer specific information  
The placeholder **COLOR** shall be replaced by **caramel, grey, light grey** or **sand**

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|----------------------------------------------------------------------------------|---------------------------------------|-----------------|------------------------|------------------------|-------------------------------------|
|  | Rapidshape<br>D10+/D20+/<br>D30+/D40+ | 385 nm          | 2.0 mW/cm <sup>2</sup> | Netfabb 2020           | DETAX Freeprint-<br>model-pro-COLOR |
|  | Shining 3D<br>AccuFab D1s             | 405 nm          | 7.6 mW/cm <sup>2</sup> | AccuWare<br>V3.2.1.108 | DETAX FREEPRINT<br>model PRO 385    |
|  | Shining 3D<br>AccuFab L4D             | 405 nm          | 2.2 mW/cm <sup>2</sup> | AccuWare<br>V3.2.1.108 | DETAX FREEPRINT<br>model PRO 385    |

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# Cleaning Equipment

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| Cleaning unit<br>Manufacturer, Model | Cleaning process**                                                                                                                                                                                                                                                                                                                                                                                          |
|--------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Rapidshape RS<br>wash                | Use the following settings: DETAX Freeprint-model-pro-COLOR<br>Prior to post-exposure, check the openings, cavities and gap areas for residues.<br>Then blow off with compressed air.                                                                                                                                                                                                                       |
| Ultrasonic bath<br>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.<br>The main cleaning is performed in a separate vessel with fresh isopropyl alcohol (purity $\geq 98\%$ ) for 3 minutes.<br>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 **caramel**, **grey**, **light grey** or **sand**



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## Light curing Equipment

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### Light Curing unit

#### Manufacturer, Model    Curing process\*\*\*

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|                           |                                                                                |
|---------------------------|--------------------------------------------------------------------------------|
| NK Optik Otoflash<br>G171 | 2 x 2000 flashes under inert gas, turn around components after<br>2000 flashes |
|---------------------------|--------------------------------------------------------------------------------|

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

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|                    |                                                             |
|--------------------|-------------------------------------------------------------|
| Rapidshape RS cure | Use the following settings: DETAX Freeprint-model-pro-COLOR |
|--------------------|-------------------------------------------------------------|

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|                          |                                                             |
|--------------------------|-------------------------------------------------------------|
| Rapidshape RS<br>cure XL | Use the following settings: DETAX Freeprint-model-pro-COLOR |
|--------------------------|-------------------------------------------------------------|

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