

Annex 1

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

Model (Picture)	Printer Manufactu- rer, 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 splint 2.0 385_5
	Asiga Max 2	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Freeprint splint 2.0 385_5
	Asiga Pico 2	385 nm	20 mW/cm ²	Composer 1.2.11	Detax_Freeprint splint 2.0 385_5
	Asiga PRO 2	385 nm	5.7 mW/cm ²	Composer 1.2.11	Detax_Freeprint splint 2.0 385_5
	Asiga PRO 4K	385 nm	7.0 mW/cm ²	Composer 1.2.11	Detax_Freeprint splint 2.0 385_5
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_Freeprint splint 2.0 385_5
	Ivoclar PrograPrint PR5	388 nm	16 mW/cm ²	PrograPrint CAM 1.1.10.1	Detax FREEPRINT Splint 2.0

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

Annex 1

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

Model (Picture)	Printer Manufactu- rer, Model	Light source	Light intensity	Operation Software	Parameter data set*
	Microlay Versus	385 nm	4.3 mW/cm ²	Microform 1.0.3.7	DETAX Freeprint Splint 2.0 385 100 microns v5.3
	Miicraft Alpha	385 nm	6.0 mW/cm ²	Utility 6.4.4	DETAX freeprint splint 2.0
	Miicraft Prime Series	385 nm	6.2 mW/cm ²	Utility 6.3.0	Detax_Freeprint splint 2.0 385_100_PH
	Miicraft Ultra Series	385 nm	5.7 mW/cm ²	Utility 6.3.0	Detax_Freeprint splint 2.0 UV_100
	Rapidshape D20+/D30+/ D40+	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint splint 2.0 385
	Way2 Production SolFlex Series	385 nm	8.0 mW/cm ²	Netfabb 2020	Freeprint splint 2.0 385

*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 3 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-splint 2.0 uv. 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 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.
---	---



detax GmbH

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

06/2025

Light curing Equipment

Light Curing unit

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

Dentalfarm Photopol	2 × 3 min, progressive + N ₂ , turn around components after 3 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
-----------------------------	--

NK Optik Otoflash G171	2 × 2000 flashes under inert gas, turn around components after 2000 flashes
---------------------------	---

NK Optik Otoflash 250/500	4000 flashes under inert gas @15 Hz
------------------------------	-------------------------------------



detax GmbH

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

06/2025