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 splintmaster taff_5 Detax_Freeprint splintmaster flex_5
	Asiga Max 2	385 nm	7.0 mW/cm²	Composer 2.0.8	Detax_Freeprint splintmaster taff_5 Detax_Freeprint splintmaster flex_5
	Asiga PRO 4K	385 nm	7.0 mW/cm²	Composer 1.2.11	Detax_Freeprint splintmaster taff_5 Detax_Freeprint splintmaster flex_5
	Asiga Ultra	385 nm	6.6 mW/cm²	Composer 2.0.8	Detax_Freeprint splintmaster taff_5 Detax_Freeprint splintmaster flex_5

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

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

Model (Picture)	Printer Manufacturer, Model	Light source	Light intensity	Operation Software	Parameter data set*
	Ivoclar PrograPrint PR5	388 nm	16 mW/cm²	PrograPrint CAM 1.1.10.1	Detax FREEPRINT Splintmaster taff Detax FREEPRINT Splintmaster flex
	Miicraft Alpha	385 nm	6.0 mW/cm²	Utility 6.4.4	DETAX Freeprint splintmaster taff DETAX Freeprint splintmaster flex
	Rapidshape D10+/D20+/ D30+/D40+	385 nm	2.0 mW/cm²	Netfabb 2020	DETAX Freeprint-splintmaster-taff DETAX Freeprint-splintmaster-flex

*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 ≥ 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.
Rapidshape RS wash	Use the following settings: DETAX Freeprint-splintmaster-taff; DETAX Freeprint-splintmaster-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
Ivoclar PrograPrint Cure	Post curing A: Wavelength = 405 nm; Intensity = 100 %; Duration = 90 s Post curing B: n/a
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
Rapidshape RS cure	Use the following settings: DETAX Freeprint-splintmaster-taff; DETAX Freeprint-splintmaster-flex
Rapidshape RS cure XL	Use the following settings: DETAX Freeprint-splintmaster-taff; DETAX Freeprint-splintmaster-flex

Mechanical finishing

Polishing unit Manufacturer, Model	Polishing process
Otec ECO-Maxi wet	Step 1: Media: DZS 10/10 Ceramic grinding wheel (50 %), ZSS 4/10 Ceramic grinding wheel (50 %), Compound: SC 15 Compound, Runtime: 60 min, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 4 l/h
	Step 2: Media: KM 10 plastic abrasive media (70 %), PM 10 plastic abrasive media (30 %), Compound: SC 15 Compound, Runtime: 60 min, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 4 l/h
	Step 3: Media: ZSP 4/5 Porcelain polishing body, Compound: SC 5 Compound, Runtime: 60 min, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 4 l/h
Otec CF 1x18-I without sieve unit	Step 1: Media: DZS 10/10 Ceramic grinding wheel (50 %), ZSS 4/10 Ceramic grinding wheel (50 %), Compound: SC 15 Compound, Runtime: 60 min, Rib shape: standard, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 11 l/h
	Step 2: Media: KM 10 plastic abrasive media (70 %), PM 10 plastic abrasive media (30 %), Compound: SC 15 Compound, Runtime: 60 min, Rib shape: standard, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 11 l/h
	Step 3: Media: ZSP 4/5 Porcelain polishing body, Compound: SC 5 Compound, Runtime: 60 min, Rib shape: round, Splitting system: Wet splitting, Speed: 240 U/min, Compound content: 3 %, Water flow: 11 l/h

Mechanical finishing

Manual polishing process	Polishing recommendation
Step 1:	Roughly remove the rough support structures with Scotch Brite rough.
Step 2:	• Use sandpaper to process the entire splint, in order to remove any major impurities. • Alternatively: Further finely refine the surface of the splint with Scotch Brite fine. • Alternatively: Use a commercially available rubber polisher.
Step 3:	Use a fine goat hair brush with pumice stone on the polishing machine for pre-polishing.
Step 4:	• For the final high-gloss polish, use a cotton buffing pad for the handpiece with Oropol (universal polishing paste for plastic and metal) or PoliStar high-gloss polishing emulsion. • Alternatively: Use the cotton buff on your polishing machine in conjunction with Oropol polishing paste or PoliStar emulsion. • for flex: **First** use a cotton buff in combination with Oropol (universal polishing paste for plastic and metal) and **then** a cotton buff with PoliStar high-gloss polishing emulsion.
Step 5 (optional):	Use a fresh cotton buff without polish to remove polish residue and apply a final shine.