

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	6.1 mW/cm ²	Composer 1.2.11	Detax_Freeprint temp 385_5
	Asiga Max 2	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Freeprint temp 385_5
	Asiga Pico 2	385 nm	20 mW/cm ²	Composer 1.2.11	Detax_Freeprint temp 385_5
	Asiga PRO 2	385 nm	5.7 mW/cm ²	Composer 1.2.11	Detax_Freeprint temp 385_5
	Asiga PRO 4K	385 nm	7.0 mW/cm ²	Composer 1.2.11	Detax_Freeprint temp 385_5
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_Freeprint temp 385_5

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

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	Heygears UltraCraft A2D	385 nm	2.1 mW/cm ²	Materialise Magic 23	Detax Temp UV
	Ivoclar Progra-Print PR5	388 nm	16 mW/cm ²	PrograPrint CAM 1.1.10.1	DETAX Freeprint Temp
	Microlay Versus	385 nm	4.3 mW/cm	Microform 1.0.3.7	DETAX Freeprint Temp 385 50 microns v5.3
	Miicraft Alpha	385 nm	6.0 mW/cm ²	Utility 6.4.4	Detax_Freeprint temp
	Miicraft Prime Series	385 nm	6.2 mW/cm ²	Utility 6.3.0	Detax_Freeprint temp 385_50_PH / 100_PH
	Miicraft Ultra Series	385 nm	5.7 mW/cm ²	Utility 6.3.0	Detax_Freeprint temp UV_50 / 100

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	Rapidshape D10+/D20+/ D30+/D40+	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-temp 385
	Rapidshape D70+/D90+	385 nm	5.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-temp 385
	Way2Produc- tion SolFlex Series	385 nm	8.0 mW/cm ²	Netfabb 2020	Freeprint temp 385

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Cleaning Equipment

Cleaning unit

Manufacturer, Model	Cleaning process
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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.
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Rapidshape RS wash	Use the following settings: DETAX Freeprint-temp uv Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air.
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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.
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Light curing Equipment

Light Curing unit

Manufacturer, Model	Curing process
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Dentalfarm Photo-pol	2 × 3 min, progressive + N ₂ , turn around components after 3 min
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Heygears UltraCraft PCU 3.0	5 min under water
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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
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NK Optik Otoflash G171	2 × 2000 flashes under inert gas, turn around components after 2000 flashes
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NK Optik Otoflash 250/500	4000 flashes under inert gas @15 Hz
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Rapidshape RS cure	Use the following settings: DETAX Freeprint-temp uv
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Rapidshape RS cure XL	Use the following settings: DETAX Freeprint-temp uv
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