







# 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*
	Aidite Cameo CPD-100	405 nm	4.3 mW/cm <sup>2</sup>	Aidite Dental	EZPRINT Temp
	Asiga Max	385 nm	6.1 mW/cm <sup>2</sup>	Composer 1.2.11	Detax_Freeprint temp 385_5
	Asiga Max 2	385 nm	7.0 mW/cm <sup>2</sup>	Composer 2.0.8	Detax_Freeprint temp 385_5
	Asiga Pico 2	385 nm	20 mW/cm <sup>2</sup>	Composer 1.2.11	Detax_Freeprint temp 385_5
	Asiga PRO 2	385 nm	5.7 mW/cm <sup>2</sup>	Composer 1.2.11	Detax_Freeprint temp 385_5
	Asiga PRO 4K	385 nm	7.0 mW/cm <sup>2</sup>	Composer 1.2.11	Detax_Freeprint temp 385_5

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

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	Asiga Ultra	385 nm	6.6 mW/cm <sup>2</sup>	Composer 2.0.8	Detax_Freeprint temp 385_5
	Formlabs Form 4B	405 nm	7.0 mW/cm <sup>2</sup>	PreForm V3.44.0.471	detax Freeprint temp V01
	Heygears Ul- traCraft A2D	385 nm	2.1 mW/cm <sup>2</sup>	Materialise Magic 23	Detax Temp UV
	Ivoclar Progra- Print PR5	388 nm	16 mW/cm <sup>2</sup>	PrograPrint CAM 11.10.1	DETAX Freeprint Temp
	Microlay Versus	385 nm	4.3 mW/cm <sup>2</sup>	Microform 1.0.3.7	DETAX Freeprint Temp 385 50 microns v5.3
	Miicraft Alpha	385 nm	6.0 mW/cm <sup>2</sup>	Utility 6.4.4	Detax_Freeprint temp

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	MiiCraft Prime Series	385 nm	6.2 mW/cm <sup>2</sup>	Utility 6.3.0	Detax_Freeprint temp 385_50_PH / 100_PH
	MiiCraft Ultra Series	385 nm	5.7 mW/cm <sup>2</sup>	Utility 6.3.0	Detax_Freeprint temp UV_50 / 100
	Rapidshape ONE	385 nm	3.5 mW/cm <sup>2</sup>	Print Studio 1.2.	DETAX Freeprint-temp 385
	Rapidshape D10+/D20+/D30+/D40+	385 nm	2.0 mW/cm <sup>2</sup>	Netfabb 2020	DETAX Freeprint-temp 385
	Rapidshape D70+/D90+	385 nm	5.0 mW/cm <sup>2</sup>	Netfabb 2020	DETAX Freeprint-temp 385
	Rapidshape Pro20 (Dental)/Pro30 (Dental)	385 nm	2.0 mW/cm <sup>2</sup>	Netfabb 2020	DETAX Freeprint-temp 385

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	Rayshape Edge E2	405 nm	5.0 mW/cm <sup>2</sup>	ShapePanel V1.0.09	DETAX FREEPRINT temp
	Shining 3D AccuFab L4D	405 nm	2.0 mW/cm <sup>2</sup>	AccuWare	DETAX FREEPRINT temp-0.05
	W2P SolFlex 250 UHD	385 nm	5.0 mW/cm <sup>2</sup>	SolFab Slicing	Detax FREEPRINT temp 385
	Way2Produc- tion SolFlex Series	385 nm	8.0 mW/cm <sup>2</sup>	Netfabb 2020	Freeprint temp 385

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# Cleaning Equipment

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## Cleaning unit

Manufacturer, Model	Cleaning process
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<b>Ivoclar PrograPrint Clean</b>	<p>Clean the parts with isopropyl alcohol (purity <math>\geq 98\%</math>) for 3 minutes. Then thoroughly clean the openings, cavities and gap areas with compressed air.</p> <p>The main cleaning is performed in a separate vessel with fresh isopropyl alcohol (purity <math>\geq 98\%</math>) for 3 minutes.</p> <p>Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air.</p>
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<b>Rapidshape RS wash</b>	<p>Use the following settings: DETAX Freeprint-temp uv</p> <p>Prior to post-exposure, check the openings, cavities and gap areas for residues.</p> <p>Then blow off with compressed air.</p>
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<b>Ultrasonic bath Bandelin Sonorex</b>	<p>Clean the parts with isopropyl alcohol (purity <math>\geq 98\%</math>) for 3 minutes. Then thoroughly clean the openings, cavities and gap areas with compressed air.</p> <p>The main cleaning is performed in a separate vessel with fresh isopropyl alcohol (purity <math>\geq 98\%</math>) for 3 minutes.</p> <p>Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air.</p>
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## Light curing Equipment

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### Light Curing unit

#### Manufacturer, Model    Curing process

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**Asiga Cure**                      Use the following settings: Detax\_Freeprint temp 385\_6

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**Dentalfarm  
Photopol**                      2 × 3 min, progressive + N<sub>2</sub>, 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 Otoplast  
G171**                      2 × 2000 flashes under inert gas, turn around components  
after 2000 flashes

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**NK Optik Otoplast  
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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