Annex 1

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

Model (Picture)	Printer Manufacturer, Model	Light source	Pixel size x,y	Light intensity	Operation Software	Parameter data set*	Curing time	Slicing	Recommended orientation angle (degree)
	Aidite Cameo CPD-100	405 nm	±30 µm	4.3 mW/cm²	Aidite Dental	EZPRINT Temp	2.1 s	50 µm	0-90
	Asiga Max	385 nm	±62 µm	6.1 mW/cm²	Composer 1.2.11	Detax_Freeprint temp UV_3.3	1.8 s	50 µm	0-90
	Asiga Max 2	385 nm	±62 µm	7.0 mW/cm²	Composer 2.0.8	Detax_Freeprint temp 385_5	1.5 s	50 µm	0-90
	Asiga Pico 2	385 nm	±39 µm	20 mW/cm²	Composer 1.2.11	Detax_Freeprint temp UV_3.3	0.6 s	50 µm	0-90
	Asiga PRO 2	385 nm	±39 µm	5.7 mW/cm²	Composer 1.2.11	Detax_Freeprint temp 385_5	2.0 s	50 µm	0-90
	Asiga PRO 4K	385 nm	±65 µm	7.0 mW/cm²	Composer 1.2.11	Detax_Freeprint temp 385_5	1.5 s	50 µm	0-90
	Asiga Ultra	385 nm	±50 µm	6.6 mW/cm²	Composer 2.0.8	Detax_Freeprint temp 385_5	1.6 s	50 µm	0-90
	Formlabs Form 4B	405 nm	±50 µm	7.0 mW/cm²	PreForm V3.44.0.471	detax Freeprint temp V01	2.1 s	50 µm	0-90
	Heygears UltraCraft A2D	385 nm	±75 µm	2.1 mW/cm²	Materialise Magic Version 23	Detax Temp UV	1.7 s	50 µm	0-90
	Ivoclar PrograPrint PR5	385 nm	±49 µm	16 mW/cm²	PrograPrint CAM 1.1.10.1	Detax FREEPRINT temp	0.6 s	50 µm	0-90
	Microlay Versus	385 nm	±65 µm	4.3 mW/cm²	Microform 1.0.3.7	DETAX Freeprint Temp 385 50 microns v5.3	2.0 s	50 µm	0-90
	Miicraft Alpha	385 nm	±68 µm	6.0 mW/cm²	Utility 6.4.4	DETAX Freeprint temp	2.0 s	50 µm	0-90
	Miicraft Ultra Series	385 nm	±65 µm	5.7 mW/cm²	Utility 6.3.0	Detax_Freeprint temp UV_50	1.0 s	50 µm	0-90
	Rapidshape ONE	385 nm	±34 µm	3.5 mW/cm²	Print Studio 1.2.	DETAX Freeprint-temp 385	1.5 s	50 µm	0-90
	Rapidshape D10+/D20+/ D30+/D40+	385 nm	±34 µm	2.0 mW/cm²	Netfabb 2020	Detax freeprint-temp uv	2.8 s	50 µm	0-90

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

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Model (Picture)	Printer Manufacturer, Model	Light source	Pixel size x,y	Light intensity	Operation Software	Parameter data set*	Curing time	Slicing	Recommended orientation angle (degree)
	Rapidshape D70+/D90+	385 nm	±23 µm	5.0 mW/cm²	Netfabb 2020	Detax freeprint-temp uv	1.8 s	50 µm	0-90
	Rapidshape Pro20 (Dental)/ Pro30 (Dental)	385 nm	±34 µm	2.0 mW/cm²	Netfabb 2020	DETAX Freeprint-temp 385	2.8 s	50 µm	0-90
	Rayshape Edge E2	405 nm	±34.4 µm	5.0 mW/cm²	ShapePanel V1.0.09	DETAX FREEPRINT temp	3.0 s	50 µm	0-90
	Shining 3D AccuFab L4D	405 nm	±50 µm	2.0 mW/cm²	AccuWare	DETAX FREEPRINT temp-0.05	3.8 s	50 µm	0-90
	W2P SolFlex 250 UHD	385 nm	±50 µm	5.0 mW/cm²	SolFab Slicing	Detax FREEPRINT temp 385	1.92 s	50 µm	0-90
	Way2Production SolFlex Series	385 nm	±50 µm	8.0 mW/cm²	Netfabb 2020	Freeprint temp 385	1.2 s	50 µm	0-90

*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-temp 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 ≥ 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
Asiga Cure	Use the following settings: Detax_Freeprint temp 385_6
Dentalfarm Photopol	2 x 3 min, progressive + N_2, turn around components after 3 min
Heygears UltraCraft PCU 3.0	5 min under water
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 x 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-temp uv
Rapidshape RS cure XL	Use the following settings: DETAX Freeprint-temp uv