

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 tray 2.0 385_5
	Asiga Max 2	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Freeprint tray 2.0 385_5
	Asiga Pico 2	385 nm	20 mW/cm ²	Composer 1.2.11	Detax_Freeprint tray 2.0 385_5
	Asiga PRO 2	385 nm	5.7 mW/cm ²	Composer 1.2.11	Detax_Freeprint tray 2.0 385_5
	Asiga PRO 4K	385 nm	7.0 mW/cm ²	Composer 1.2.11	Detax_Freeprint tray 2.0 385_5
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_Freeprint tray 2.0 385_5

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

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Model (Picture)	Printer Manufacturer, Model	Light source	Light intensity	Operation Software	Parameter data set*
	Ivoclar Progra-Print PR5	388 nm	16 mW/cm ²	PrograPrint CAM 1.1.10.1	Detax FREEPRINT Tray 2.0 - 100 µm
	Microlay Versus	385 nm	4.3 mW/cm ²	Microform 1.0.3.7	DETAX Freeprint Tray 2.0 385 100 microns v5.3
	Miicraft Alpha	385 nm	6.0 mW/cm ²	Utility 6.4.4	DETAX freeprint tray 2.0
	Miicraft Prime Series	385 nm	6.2 mW/cm ²	Utility 6.3.0	Detax_Freeprint tray UV 2.0_100_PH
	Miicraft Ultra Series	385 nm	5.7 mW/cm ²	Utility 6.3.0	Detax_Freeprint tray UV 2.0_100
	Rapidshape D10+/D20+/D30+/D40+	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-tray 385

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Model (Picture)	Printer Manufacturer, Model	Light source	Light intensity	Operation Software	Parameter data set*
	Rapidshape Pro20 (Dental)/ Pro30 (Dental)	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-tray 385
	W2P SolFlex 250 UHD	385 nm	5.0 mW/cm ²	SolFab	Detax FREEPRINT tray 2.0 385
	Way2 Production SolFlex Series	385 nm	8.0 mW/cm ²	Netfabb 2020	Freeprint tray 2.0 385

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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-tray 385. 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

**Dentalfarm
Photopol** 2 × 3 min, progressive + N₂, 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

Rapidshape RS cure Use the following settings: DETAX Freeprint-tray 385

**Rapidshape RS
cure XL** Use the following settings: DETAX Freeprint-tray 2.0 385



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