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/cm²	Composer 1.2.11	Detax_Freeprint tryin 385_5
	Asiga Max 2	385 nm	7.0 mW/cm²	Composer 2.0.8	Detax_Freeprint tryin 385_5
	Asiga Pico 2	385 nm	20 mW/cm²	Composer 1.2.11	Detax_Freeprint tryin 385_5
	Asiga PRO 2	385 nm	5.7 mW/cm²	Composer 1.2.11	Detax_Freeprint tryin 385_5
	Asiga PRO 4K	385 nm	7.0 mW/cm²	Composer 1.2.11	Detax_Freeprint tryin 385_5
	Asiga Ultra	385 nm	6.6 mW/cm²	Composer 2.0.8	Detax_Freeprint tryin 385_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 tryin
	Microlay Versus	385 nm	4.3 mW/cm²	Microform 1.0.3.7	DETAX Freeprint Tryin 385 100 microns v5.3
	Miicraft Ultra Series	385 nm	5.7 mW/cm²	Utility 6.3.0	Detax_Freeprint tryin 385_100
	Rapidshape D10+/D20+/ D30+/D40+	385 nm	2.0 mW/cm²	Netfabb 2020	DETAX Freeprint-tryin 385
	Way2-Production SolFlex Series	385 nm	8.0 mW/cm²	Netfabb 2020	Freeprint tryin 385

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

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