

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)
	Asiga Max	385 nm	±62 µm	6.1 mW/cm²	Composer 1.2.11	Detax_Freeprint tryin 385_5	2.5 s	100 µm	0-90
	Asiga Max 2	385 nm	±62 µm	7.0 mW/cm²	Composer 2.0.8	Detax_Freeprint tryin 385_5	2.3 s	100 µm	0-90
	Asiga Pico 2	385 nm	±39 µm	20 mW/cm²	Composer 1.2.11	Detax_Freeprint tryin 385_5	0.9 s	100 µm	0-90
	Asiga PRO 2	385 nm	±39 µm	5.7 mW/cm²	Composer 1.2.11	Detax_Freeprint tryin 385_5	2.7 s	100 µm	0-90
	Asiga PRO 4K	385 nm	±65 µm	7.0 mW/cm²	Composer 1.2.11	Detax_Freeprint tryin 385_5	2.3 s	100 µm	0-90
	Asiga Ultra	385 nm	±50 µm	6.6 mW/cm²	Composer 2.0.8	Detax_Freeprint tryin 385_5	2.4 s	100 µm	0-90
	Microlay Versus	385 nm	±65 µm	4.3 mW/cm²	Microform 1.0.3.7	DETAX Freeprint Tryin 385 100 microns v5.3	3.0 s	100 µm	0-90
	Miicraft Ultra Series	385 nm	±65 µm	5.7 mW/cm²	Utility 6.3.0	Detax_Freeprint tryin 385_100	2.5 s	100 µm	0-90
	Rapidshape D10+/D20+/ D30+/D40+	385 nm	±34 µm	2.0 mW/cm²	Netfabb 2020	DETAX Freeprint-tryin 385	3.8 s	100 µm	0-90
	Way2Produc- tion SolFlex Series	385 nm	±50 µm	8.0 mW/cm²	Netfabb 2020	Freeprint tryin 385	1.8 s	100 µm	0-90
	Way2Produc- tion SolLab Series	385 nm	±50-70 µm	8.0 mW/cm²	Netfabb 2020	Freeprint tryin 385_SL	1.8 s	100 µm	0-90

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

Cleaning Equipment

Cleaning unit Manufacturer, Model	Cleaning process
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 + N ₂ , turnaround components after 3 min
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