














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/cm ²	Composer 1.2.11	Detax_Freeprint tryin 385_5	2.5 s	100 µm	0-90
	Asiga Max2	385 nm	±62 µm	7.0 mW/cm ²	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/cm ²	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/cm ²	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/cm ²	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/cm ²	Composer 2.0.8	Detax_Freeprint tryin 385_5	2.4 s	100 µm	0-90
	Formlabs Form 4B	405 nm	±50 µm	7.0 mW/cm ²	PreForm V3.44.0.471	detax_Freeprint tryin V01	2.86 s	100 µm	0-90
	Microlay Versus	385 nm	±65 µm	4.3 mW/cm ²	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/cm ²	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/cm ²	Netfabb 2020	DETAX Freeprint-tryin 385	3.8 s	100 µm	0-90
	Rapidshape Pro20 (Dental)/Pro30 (Dental)	385 nm	±34 µm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-tryin 385	3.8 s	100 µm	0-90
	Way2Production SolFlex Series	385 nm	±50 µm	8.0 mW/cm ²	Netfabb 2020	Freeprint tryin 385	1.8 s	100 µm	0-90
	Way2Production SolLab Series	385 nm	±50-70 µm	8.0 mW/cm ²	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 $\geq 98\%$) 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.

Light curing Equipment

Light Curing unit Manufacturer, Model	Curing process
Asiga Cure	Use the following settings: Detax_Freeprint tryin 385_6
Dentalfarm Photopol	2 x 3 min, progressive + N ₂ , turnaround components after 3 min
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-tryin 385
Rapidshape RS cure XL	Use the following settings: DETAX Freeprint-tryin 385

