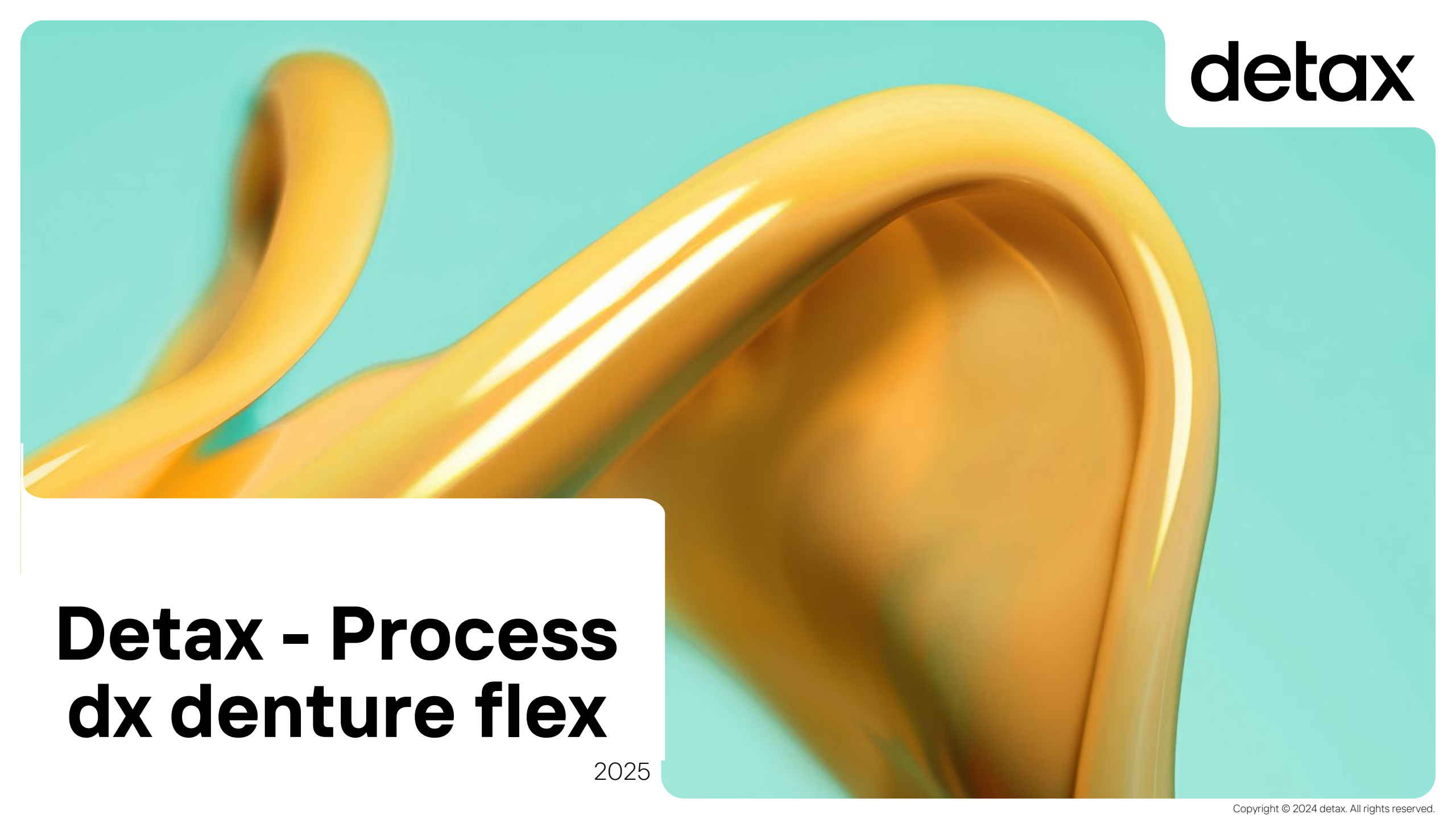




detax

Detax - Process dx denture flex

2025

General Information



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	7.0 mW/cm ²	Composer 1.2.11	Detax_Freeprint denture flex_5
	Asiga Max 2	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Freeprint denture flex_5
	Asiga PRO 4K	385 nm	7.0 mW/cm	Composer 1.2.11	Detax_Freeprint denture flex_5
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_Freeprint denture flex_5
	Rapidshape D10+/D20+/D30+/D40+	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-denture-flex

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

General Information

dx



Cleaning Equipment

Cleaning unit Manufacturer, Model	Cleaning process
Rapidshape RS wash	Use the following settings: DETAX Freeprint-denture-flex 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

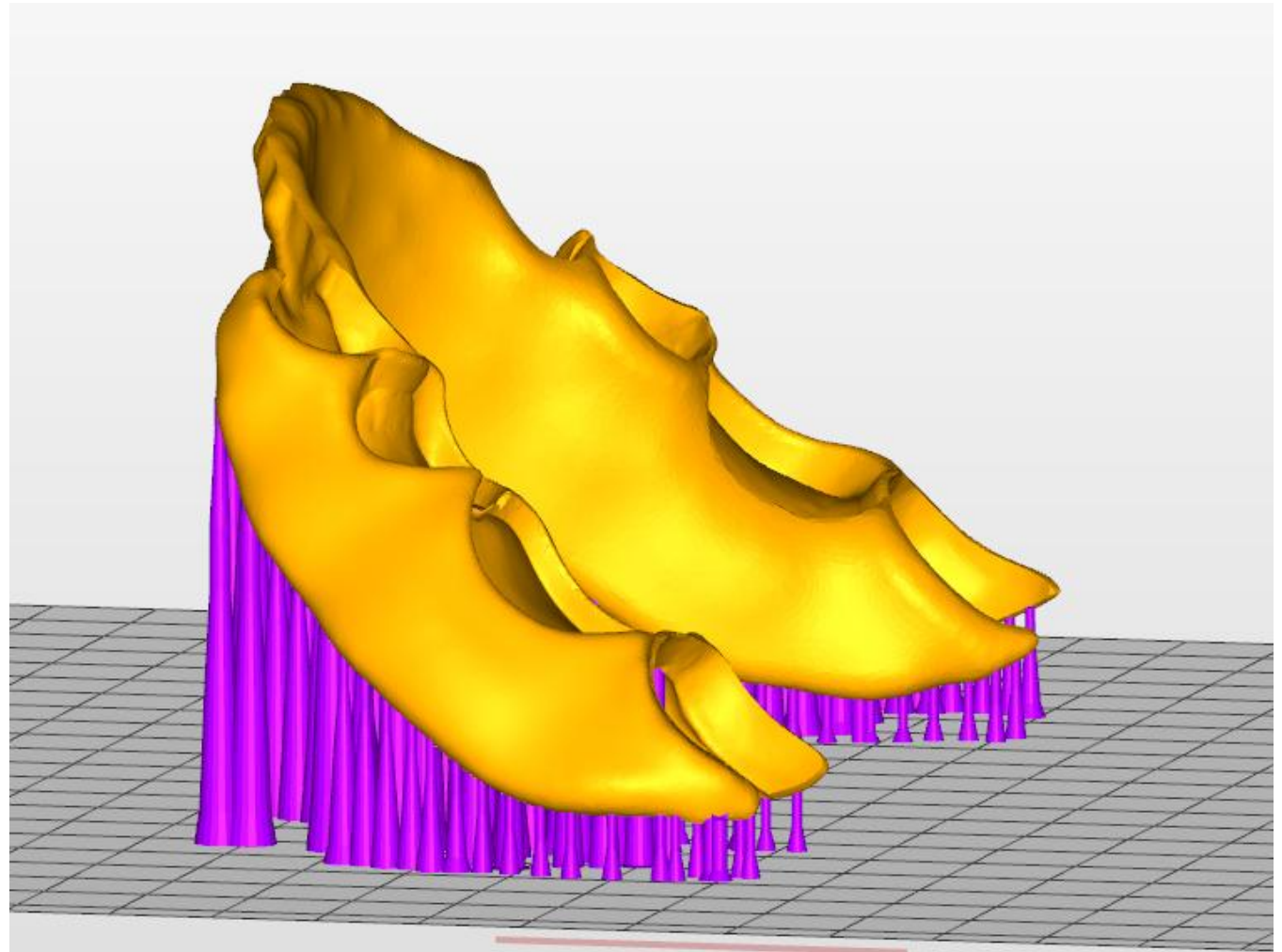
Light Curing unit Manufacturer, Model	Curing process
NK Optik Otofash G171	2 x 2000 flashes under inert gas, turn around components after 2000 flashes
NK Optik Otofash 250/500	4000 flashes under inert gas @15 Hz
Rapidshape RS cure	Use the following settings: DETAX Freeprint-denture-flex

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12/2024
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Design - exocad - 3Shape dx denture flex

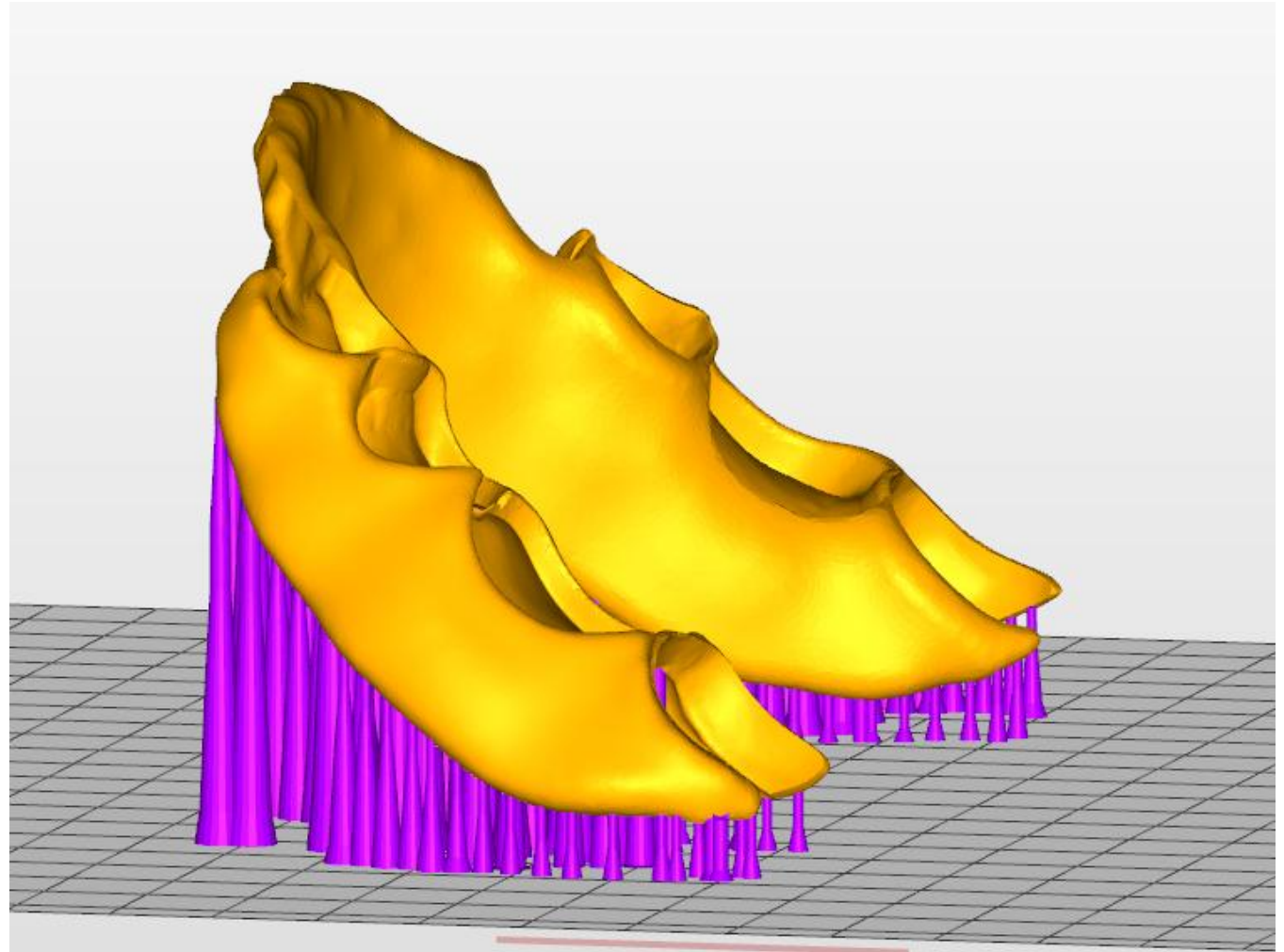
- **Clasps:** Tapered to approx. 0.8 mm, but ideally 1–1.5 mm.
- **Sublingual bars:** Preferably 5 mm, in a teardrop shape.
- **Palatal plates:** 2–3 mm thickness.
- Add a crossbar
- **Minimum thickness of tooth pockets:** 0,8-1mm
- **Bonding gap for the teeth**
150-200 μm



Nesting

dx denture flex - orientation

- Orientation
 - 45 degrees
- Slicing thickness
 - 100 μ m

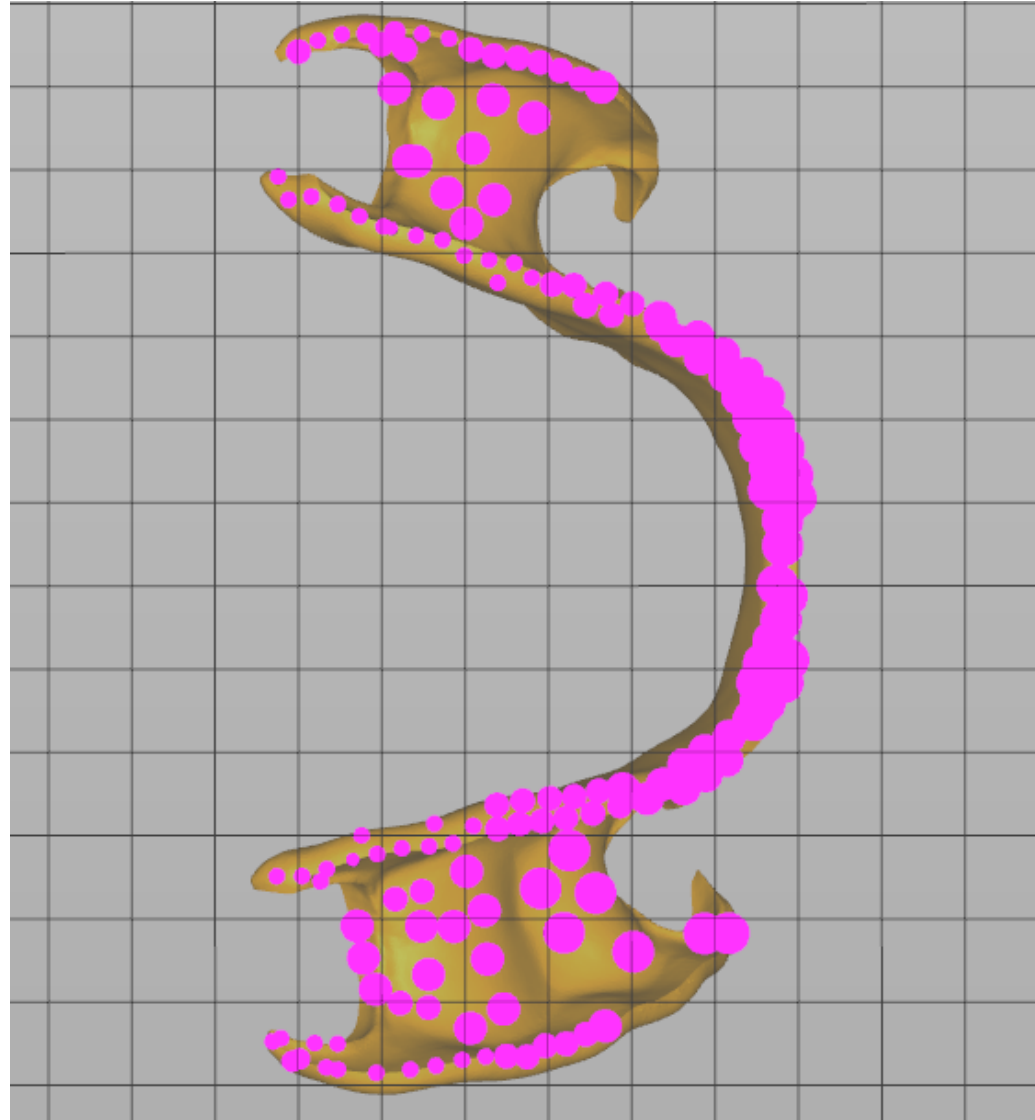


dx

Nesting

dx denture flex - orientation

- Supports only at the margins of the partial denture, only a few on the basal surfaces

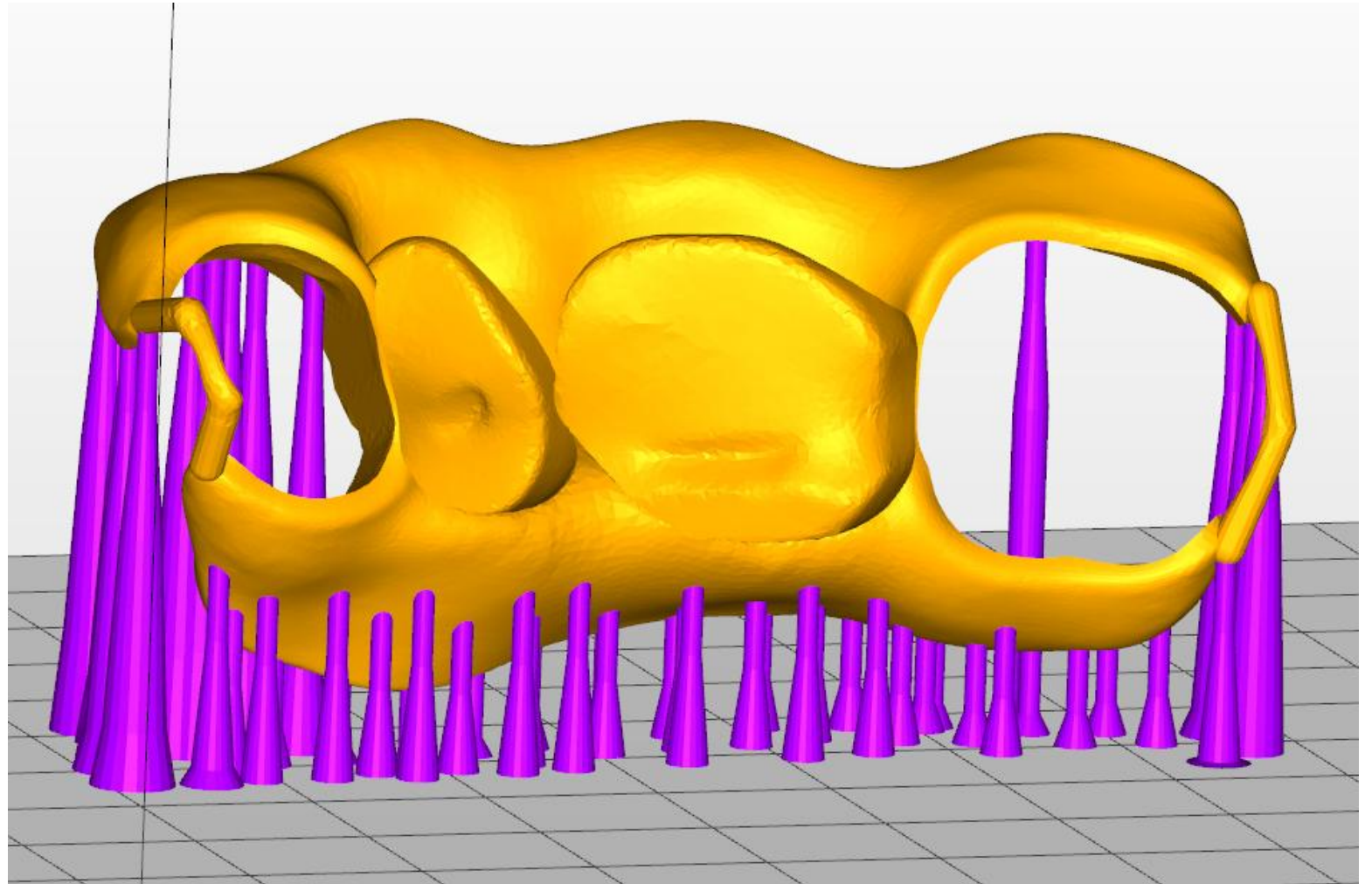


Nesting

dx denture flex -
orientation - flippers

- Orientation
- Slicing thickness
 - 100 μ m

dx



Materials that matter

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