






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 clear_6 Detax_Freeprint denture flex pink-transparent_6
	Asiga Max 2	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Freeprint denture flex clear_6 Detax_Freeprint denture flex pink-transparent_6
	Asiga PRO 4K	385 nm	7.0 mW/cm	Composer 1.2.11	Detax_Freeprint denture flex clear_6 Detax_Freeprint denture flex pink-transparent_6
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_Freeprint denture flex clear_6 Detax_Freeprint denture flex pink-transparent_6
	Formlabs Form 4B	405 nm	7.0 mW/cm ²	PreForm V3.48.0.523 PreForm V3.44.0.471	detax Freeprint denture flex clear V01 detax Freeprint denture flex pink V01

*The set of parameters includes all relevant material- and printer specific 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*
	Heygears Ultracraft A2D	385 nm	2.1 mW/cm ²	HEYGEARS Cloud V4.3.7.6	Detax Denture Flex UV pink-transparent
	Heygears Ultracraft A2D HD	385 nm	1.4 mW/cm ²	HEYGEARS Cloud V4.3.7.6	Detax Denture Flex UV pink-transparent
	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

Cleaning Equipment

Cleaning unit

Manufacturer, Model	Cleaning process
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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.
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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
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Asiga Cure	Use the following settings: Detax_Freeprint denture flex clear_6; Detax_Freeprint denture flex pink-transparent_6
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Dreve PCU LED N2	Intensity: 80%, 06:40 min, vacuum, nitrogen
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Heygears PCU Pro	Use the following settings: Detax Denture Flex Clear UV; Detax Denture Flex Pink-Transparent UV
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Light curing Equipment

Light Curing unit

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