

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 impact_5
	Asiga Max 2	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Freeprint denture impact_5
	Asiga PRO 4K	385 nm	7.0 mW/cm ²	Composer 1.2.11	Detax_Freeprint denture impact_5
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_Freeprint denture impact_5
	Formlabs Form 4B	405 nm	7.0 mW/cm ²	PreForm V3.44.0.471	detax Freeprint denture impact V01
	Heygears UltraCraft A2D	385 nm	2.1 mW/cm ²	Heygears Cloud V4.3.7.6	Detax Denture Impact

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

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	Heygears UltraCraft A2D HD	385 nm	1.75 mW/cm ²	Heygears Cloud V4.3.7.6	Detax Denture Impact
	Phrozen Sonic 4K 2022	405 nm	2.0 mW/cm ²	Phrozen DS Slicer V4.0.1	Detax Freeprint denture impact
	Rapidshape ONE	385 nm	3.5 mW/cm ²	Print Studio 1.2.	DETAX Freeprint- denture impact
	Rapidshape D20+/D30+/ D40+/D50+	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint- denture impact
	Rapidshape PRO20 (Dental)/ PRO30 (Dental)	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint- denture impact

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	Rayshape Edge E2	405 nm	5.0 mW/cm ²	ShapePanel	DETAX FREEPRINT denture impact
	Shining 3D AccuFab CEL	405 nm	4.0 mW/cm ²	AccuWare V3.2.1.109	DETAX FREEPRINT denture impact-0.1
	Shining 3D AccuFab L4D	405 nm	2.0 mW/cm ²	AccuWare V3.2.1.108	DETAX FREEPRINT denture impact-0.1
	W2P SolFlex 250 UHD	385 nm	5.0 mW/cm ²	SolFab	Detax FREEPRINT denture impact 385

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Cleaning Equipment

Cleaning unit

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

Asiga Cure

Use the following settings: Detax_Freeprint denture impact_6

Dreve PCU LED N2

Intensity: 40%, 10:00 min, vacuum, nitrogen

Heygears PCU 3.0

Use the following settings: Detax Denture Impact UV

Heygears PCU Pro

Use the following settings: Detax Denture Impact UV

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-denture impact



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