






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 splintmaster taff_5 Detax_Freeprint splintmaster flex_5
	Asiga Max 2	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Freeprint splintmaster taff_5 Detax_Freeprint splintmaster flex_5
	Asiga PRO 4K	385 nm	7.0 mW/cm ²	Composer 1.2.11	Detax_Freeprint splintmaster taff_5 Detax_Freeprint splintmaster flex_5
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_Freeprint splintmaster taff_5 Detax_Freeprint splintmaster flex_5
	Formlabs Form 4B	405 nm	7.0 mW/cm ²	PreForm V3.48.0.523 PreForm V3.44.0.471	detax Freeprint splintmaster taff V01 detax Freeprint splintmaster flex V01

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

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	Heygears Ultracraft A2D	385 nm	2.1 mW/cm ²	HEYGEARS Cloud V4.3.7.6	Detax Splintmaster Taff UV Detax Splintmaster Flex UV
	Heygears Ultracraft A2D HD	385 nm	1.4 mW/cm ²	HEYGEARS Cloud V4.3.7.6	Detax Splintmaster Taff UV
	Heygears Ultracraft A3D	385 nm	2.1 mW/cm ²	HEYGEARS Cloud V4.3.7.6	Detax Splintmaster Taff UV
	Ivoclar PrograPrint PR5	388 nm	16 mW/cm ²	PrograPrint CAM11.10.1	Detax FREEPRINT Splintmaster taff Detax FREEPRINT Splintmaster flex
	Miicraft Alpha	385 nm	6.0 mW/cm ²	Utility 6.4.4	DETAX Freeprint splintmaster taff DETAX Freeprint splintmaster flex

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Model (Picture)	Printer Manufacturer, Model	Light source	Light intensity	Operation Software	Parameter data set*
	Rapidshape ONE	385 nm	3.5 mW/cm ²	Print Studio 1.2.	DETAX freeprint-splintmaster-taff DETAX freeprint-splintmaster-flex
	Rapidshape D10+/D20+/D30+/D40+	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-splintmaster-taff DETAX Freeprint-splintmaster-flex
	Rapidshape D50+	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-splintmaster-taff
	Rapidshape PRO20 (Dental)/PRO30 (Dental)	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-splintmaster-taff DETAX Freeprint-splintmaster-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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Ivoclar PrograPrint Clean	<p>Clean the parts with isopropyl alcohol (purity $\geq 98\%$) for 3 minutes. Then thoroughly clean the openings, cavities and gap areas with compressed air.</p> <p>The main cleaning is performed in a separate vessel with fresh isopropyl alcohol (purity $\geq 98\%$) for 3 minutes.</p> <p>Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air.</p>
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Rapidshape RS wash	<p>Use the following settings: DETAX Freeprint-splintmaster-taff; DETAX Freeprint-splintmaster-flex.</p> <p>Prior to post-exposure, check the openings, cavities and gap areas for residues.</p> <p>Then blow off with compressed air.</p>
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Ultrasonic bath Bandelin Sonorex	<p>Clean the parts with isopropyl alcohol (purity $\geq 98\%$) for 3 minutes. Then thoroughly clean the openings, cavities and gap areas with compressed air.</p> <p>The main cleaning is performed in a separate vessel with fresh isopropyl alcohol (purity $\geq 98\%$) for 3 minutes.</p> <p>Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air.</p>
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Light curing Equipment

Light Curing unit

Manufacturer, Model	Curing process
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Dreve PCU LED N2	Intensity: 80%, 06:40 min, vacuum, nitrogen (splintmaster taff only)
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Ivoclar PrograPrint Cure	Post curing A: Wavelength = 405 nm; Intensity = 100 %; Duration = 90 s Post curing B: n/a
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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-splintmaster-taff; DETAX Freeprint-splintmaster-flex
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Rapidshape RS cure XL	Use the following settings: DETAX Freeprint-splintmaster-taff; DETAX Freeprint-splintmaster-flex
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Mechanical finishing

Polishing unit

Manufacturer, Model

Polishing process

Otec ECO-Maxi wet

Step 1: Media: DZS 10/10 Ceramic grinding wheel (50 %), ZSS 4/10 Ceramic grinding wheel (50 %), Compound: SC 15 Compound, Runtime: 60 min, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 4 l/h

Step 2: Media: KM 10 plastic abrasive media (70 %), PM 10 plastic abrasive media (30 %), Compound: SC 15 Compound, Runtime: 60 min, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 4 l/h

Step 3: Media: ZSP 4/5 Porcelain polishing body, Compound: SC 5 Compound, Runtime: 60 min, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 4 l/h

Otec CF 1x18-I without sieve unit

Step 1: Media: DZS 10/10 Ceramic grinding wheel (50 %), ZSS 4/10 Ceramic grinding wheel (50 %), Compound: SC 15 Compound, Runtime: 60 min, Rib shape: standard, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 11 l/h

Step 2: Media: KM 10 plastic abrasive media (70 %), PM 10 plastic abrasive media (30 %), Compound: SC 15 Compound, Runtime: 60 min, Rib shape: standard, Splitting system: Wet splitting, Speed: 280 U/min, Compound content: 3 %, Water flow: 11 l/h

Step 3: Media: ZSP 4/5 Porcelain polishing body, Compound: SC 5 Compound, Runtime: 60 min, Rib shape: round, Splitting system: Wet splitting, Speed: 240 U/min, Compound content: 3 %, Water flow: 11 l/h



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Mechanical finishing

Manual polishing process

Polishing recommendation

Step 1: Roughly remove the rough support structures with Scotch Brite rough.

Step 2:

- Use sandpaper to process the entire splint, in order to remove any major impurities.
- Alternatively: Further finely refine the surface of the splint with Scotch Brite fine.
- Alternatively: Use a commercially available rubber polisher.

Step 3: Use a fine goat hair brush with pumice stone on the polishing machine for pre-polishing.

Step 4:

- For the final high-gloss polish, use a cotton buffing pad for the handpiece with Oropol (universal polishing paste for plastic and metal) or PoliStar high-gloss polishing emulsion.
- Alternatively: Use the cotton buff on your polishing machine in conjunction with Oropol polishing paste or PoliStar emulsion.
- for flex: **First** use a cotton buff in combination with Oropol (universal polishing paste for plastic and metal) and **then** a cotton buff with PoliStar high-gloss polishing emulsion.

Step 5 (optional): Use a fresh cotton buff without polish to remove polish residue and apply a final shine.



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