









## 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	7.0 mW/cm <sup>2</sup>	Composer 1.2.11	Detax_Freeprint denture flex clear_6 Detax_Freeprint denture flex pink-transparent_6	3.5 s	100 µm	0-90
	Asiga Max2	385 nm	±56 µm	7.0 mW/cm <sup>2</sup>	Composer 2.0.8	Detax_Freeprint denture flex clear_6 Detax_Freeprint denture flex pink-transparent_6	3.5 s	100 µm	0-90
	Asiga PRO 4K	385 nm	±25 µm	7.0 mW/cm <sup>2</sup>	Composer 1.2.11	Detax_Freeprint denture flex clear_6 Detax_Freeprint denture flex pink-transparent_6	3.5 s	100 µm	0-90
	Asiga Ultra	385 nm	±50 µm	6.6 mW/cm <sup>2</sup>	Composer 2.0.8	Detax_Freeprint denture flex clear_6 Detax_Freeprint denture flex pink-transparent_6	3.8 s	100 µm	0-90
	Formlabs Form 4B	405 nm	±50 µm	7.0 mW/cm <sup>2</sup>	PreForm V3.48.0.523	detax Freeprint denture flex clear V01 detax Freeprint denture flex pink V01	5.5 s	100 µm	0-90
	Heygears Ultracraft A2D	385 nm	±37.5 µm	2.1 mW/cm <sup>2</sup>	HEYGEARS Cloud V4.3.7.6	Detax Denture Flex UV pink-transparent	2.5 s	100 µm	0-90
	Heygears Ultracraft A2D HD	385 nm	±42.5 µm	1.4 mW/cm <sup>2</sup>	HEYGEARS Cloud V4.3.7.6	Detax Denture Flex UV pink-transparent	5.0 s	100 µm	0-90
	Rapidshape D10+/D20+/D30+/D40+	385 nm	±34 µm	2.0 mW/cm <sup>2</sup>	Netfabb 2020	DETAX Freeprint-denture-flex	5.0 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-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 ≥ 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 ≥ 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 denture flex clear_6; Detax_Freeprint denture flex pink-transparent_6
Dreve PCU LED N2	Intensity: 80%, 06:40 min, vacuum, nitrogen
Heygears PCU Pro	Use the following settings: Detax Denture Flex Clear UV; Detax Denture Flex Pink-Transparent UV
NK Optik Otoflash G171	2 × 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-flex