

# 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	7.0mW/cm <sup>2</sup>	Composer1.2.11	Detax_Freeprint denture impact_5	1.9 s	100 µm	0-90
	Asiga Max 2	385 nm	±62 µm	7.0 mW/cm <sup>2</sup>	Composer 2.0.8	Detax_Freeprint denture impact_5	1.9 s	100 µm	0-90
	Asiga PRO 4K	385 nm	±56 µm	7.0 mW/cm <sup>2</sup>	Composer 1.2.11	Detax_Freeprint denture impact_5	1.9 s	100 µm	0-90
	Asiga Ultra	385 nm	±50 µm	7.0 mW/cm <sup>2</sup>	Composer 2.0.8	Detax_Freeprint denture impact_5	1.9 s	100 µm	0-90
	Formlabs Form 4B	405 nm	±50 µm	7.0 mW/cm <sup>2</sup>	PreForm V3.44.0.471	detax Freeprint denture impact V01	4.5 s	100 µm	0-90
	Heygears UltraCraft A2D	385 nm	±37.5 µm	2.1mW/cm <sup>2</sup>	Heygears Cloud V4.3.7.6	Detax Denture Impact	2.5 s	100 µm	0-90
	Heygears UltraCraft A2D HD	385 nm	±42.5 µm	1.75 mW/cm <sup>2</sup>	Heygears Cloud V4.3.7.6	Detax Denture Impact	3.25 s	100 µm	0-90
	Phrozen Sonic 4K 2022	405 nm	±35 µm	2.0 mW/cm <sup>2</sup>	Phrozen DS Slicer V4.0.1	Detax Freeprint denture impact	12 s	100 µm	0-90
	Rapidshape ONE	385 nm	±34 µm	3.5 mW/cm <sup>2</sup>	Print Studio 1.2.	DETAX Freeprint-denture impact	2.4 s	100 µm	0-90
	Rapidshape D20+/D30+/D40+/D50+	385 nm	±34 µm	2.0 mW/cm <sup>2</sup>	Netfabb 2020	DETAX Freeprint-denture impact	3.0 s	100 µm	0-90
	Rapidshape PRO20 (Dental)/PRO30 (Dental)	385 nm	±34 µm	2.0 mW/cm <sup>2</sup>	Netfabb 2020	DETAX Freeprint-denture impact	3.0 s	100 µm	0-90
	Rayshape Edge E2	405 nm	±34.4 µm	5.0 mW/cm <sup>2</sup>	ShapePanel	DETAX FREEPRINT denture impact	6.0 s	100 µm	0-90
	Shining 3D AccuFab CEL	405 nm	±35 µm	4.0 mW/cm <sup>2</sup>	AccuWare V3.2.1.109	DETAX FREEPRINT denture impact-0.1	3.5 s	100 µm	0-90
	Shining 3D AccuFab L4D	405 nm	±50 µm	2.0 mW/cm <sup>2</sup>	AccuWare V3.2.1.108	DETAX FREEPRINT denture impact-0.1	6.5 s	100 µm	0-90
	W2P SolFlex 250 UHD	385 nm	±50 µm	5.0 mW/cm <sup>2</sup>	SolFab	Detax FREEPRINT denture impact 385	2.8 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 impact 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
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

