

# Annex 1

## Digital light Processing (DLP) printer, operation software and parameter

Model (Picture)	Printer Manufacturer	Light source	Light intensity	Operation Software	Parameter data set*
	Asiga Max	385 nm	7.0 mW/cm <sup>2</sup>	Composer 2.0.8	Detax_dx direct aligner_5
	Asiga Max 2	385 nm	7.0 mW/cm <sup>2</sup>	Composer 2.0.8	Detax_dx direct aligner_5

## Cleaning Equipment

Cleaning unit Manufacturer, Model	Cleaning process
<b>Ultrasonic bath</b> <b>Bandelin Sonorex</b>	<p>Clean the parts with isopropyl alcohol (purity <math>\geq 98\%</math>) 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 <math>\geq 98\%</math>) 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>

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

## Light curing Equipment

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### Light Curing unit

Manufacturer, Model	Curing process
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NK Optik Otoflash G171	2 x 2000 flashes under inert gas, turn around components after 2000 flashes
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