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	6.1 mW/cm²	Composer 1.2.11	Detax_dx model basic **COLOR**_5
	Asiga Max 2	385 nm	7.0 mW/cm²	Composer 2.0.8	Detax_dx model basic **COLOR**_5
	Asiga PRO 4K	385 nm	7.0 mW/cm²	Composer 1.2.11	Detax_dx model basic **COLOR**_5
	Asiga Ultra	385 nm	6.6 mW/cm²	Composer 2.0.8	Detax_dx model basic **COLOR**_5

*The set of parameters includes all relevant material- and printer specific information
The placeholder **COLOR** shall be replaced by **caramel, light tan**

Cleaning Equipment

Cleaning unit Manufacturer, Model	Cleaning process
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 seperate 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
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

detax GmbH
Carl-Zeiss-Str. 4 • 76275 Ettlingen • Germany
+49 7243 510 0 • post@detax.com • detax.com