

Annex 1

DIGITAL LIGHT PROCESSING (DLP) PRINTER, OPERATION SOFTWARE AND PARAMETER

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 denture impact_5
Asiga Max 2 	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Freeprint denture impact_5
Asiga PRO 4K 	385 nm	7.0 mW/cm ²	Composer 1.2.11	Detax_Freeprint denture impact_5
Asiga Ultra 	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_Freeprint denture impact_5
Rapidshape D20+/D30+/D40+ 	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX Freeprint-denture impact

*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
NK Optik Otoflash G171	2 x 2000 flashes under inert gas, turnaround 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



Made in
 Germany
 07/2024
 3