

# 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	7.0 mW/cm <sup>2</sup>	Composer 1.2.11	Detax_Freeprint denture flex clear_6 Detax_Freeprint denture flex pink-transparent_6
	Asiga Max 2	385 nm	7.0 mW/cm <sup>2</sup>	Composer 2.0.8	Detax_Freeprint denture flex clear_6 Detax_Freeprint denture flex pink-transparent_6
	Asiga PRO 4K	385 nm	7.0 mW/cm	Composer 1.2.11	Detax_Freeprint denture flex clear_6 Detax_Freeprint denture flex pink-transparent_6
	Asiga Ultra	385 nm	6.6 mW/cm <sup>2</sup>	Composer 2.0.8	Detax_Freeprint denture flex clear_6 Detax_Freeprint denture flex pink-transparent_6
	Rapidshape D10+/D20+/ D30+/D40+	385 nm	2.0 mW/cm <sup>2</sup>	Netfabb 2020	DETAX Freeprint- denture-flex

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

## Cleaning Equipment

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Cleaning unit Manufacturer, Model	Cleaning process
<b>Rapidshape RS wash</b>	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.
<b>Ultrasonic bath Bandelin Sonorex</b>	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

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Light Curing unit Manufacturer, Model	Curing process
<b>NK Optik Otoflash G171</b>	2 x 2000 flashes under inert gas, turn around components after 2000 flashes
<b>NK Optik Otoflash 250/500</b>	4000 flashes under inert gas @15 Hz
<b>Rapidshape RS cure</b>	Use the following settings: DETAX Freeprint-denture-flex



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