

ANNEX 1

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



Printer Manufacturer, Model	Light source	Light intensity	Operation Software	Parameter data set*
SHERAprint 20/30/50	385 nm	2.0 mW/cm ²	Netfab 2020	SHERAprint-splint taff, SHERAprint-splint flex
Asiga Max	385 nm	7.0 mW/cm ²	Composer 1.2.11	SHERAprint-splint taff, SHERAprint-splint flex
Asiga PRO 4K	385 nm	7.0 mW/cm ²	Composer 1.2.11	SHERAprint-splint taff, SHERAprint-splint flex

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

CLEANING EQUIPMENT

Cleaning unit Manufacturer, Model	Cleaning process
SHERAprint-wash pro	Use the following settings: SHERAprint-splint taff, SHERAprint-splint flex 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 ≥ 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 ≥ 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
SHERAprint-cure pro	Use the following settings: SHERAprint-splint taff, SHERAprint-splint flex
Otoflash G171 NK Optik	2 x 2000 flashes under inert gas, turnaround components after 2000 flashes



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