

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	385 nm	2 mW/cm ²	Netfab 2020	SHERAprint-ortho plus UV
Asiga Max	385 nm	6.1 mW/cm ²	Composer 1.2.11	SHERAprint-ortho plus UV
Asiga Pico 2	385 nm	20 mW/cm ²	Composer 1.2.11	SHERAprint-ortho plus UV
Asiga PRO 2	385 nm	5.7 mW/cm ²	Composer 1.2.11	SHERAprint-ortho plus UV
Asiga PRO 4K	385 nm	7.0 mW/cm ²	Composer 1.2.11	SHERAprint-ortho plus UV
Microlay Versus	385 nm	4.3 mW/cm ²	Microform 10.3.7	SHERAprint-ortho plus UV
Miicraft Prime Series	385 nm	6.2 mW/cm ²	Utility 6.3.0	SHERAprint-ortho plus UV
Miicraft Ultra Series	385 nm	5.7 mW/cm ²	Utility 6.3.0	SHERAprint-ortho plus UV

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



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Printer Manufacturer, Model	Light source	Light intensity	Operation Software	Parameter data set*
Rapidshape D70+/D90+	385 nm	5.0 mW/cm ²	Netfabb 2020	SHERAprint-ortho plus UV
Way2Production SolFlux Series	385 nm	8.0 mW/cm ²	Netfabb 2020	SHERAprint-ortho plus UV

*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-ortho plus UV Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow o 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
SHERAprint-cure pro	Use the following settings: SHERAprint-ortho plus UV
NK Optik Otoflash G17l	2 x 2000 flashes under inert gas, turnaround components after 2000 flashes
NK Optik Otoflash 250/500	4000 flashes under inert gas @15 Hz



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