rapidshape

ANNEX 1

Digital light Processing (DLP) printer, operation software and parameter

Printer manufacturer	Printer type	Light source	Light intensity	Operation software	Print parameter data set*
rapidshape	ONE	385 nm	3.5 mW / cm²	Rapid Shape Print Studio	RS VIVO Denture Impact
rapidshape	PRO 20	385 nm	2.0 mW / cm²	Rapid Shape Print Studio	RS VIVO Denture Impact
rapidshape	D20 Series	385 nm	2.0 mW / cm²	Netfabb 2020	RS VIVO Denture Impact
rapidshape	PRO 30	385 nm	2.0 mW / cm²	Rapid Shape Print Studio	RS VIVO Denture Impact
rapidshape	D30 Series	385 nm	2.0 mW / cm²	Netfabb 2020	RS VIVO Denture Impact
rapidshape	D40 Series	385 nm	2.0 mW / cm²	Netfabb 2020	RS VIVO Denture Impact
rapidshape	D50+	385 nm	2.0 mW / cm²	Netfabb 2020	RS VIVO Denture Impact

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

Cleaning equipment

Device manufacturer	Device type	Cleaning process
rapidshape	RS wash, PRO wash, WASH	Use the following settings: rapidshape RS VIVO Denture Impact Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air.
Bandelin Sonorex	Ultrasonic bath	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

Device manufacturer	Device type	Curing process
rapidshape	RS cure, PRO cure, CURE	Use the following settings: rapidshape RS VIVO Denture Impact
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
www.detax.com

Rapid Shape GmbH
Roemerstr. 21
71296 Heimsheim/Germany
www.rapidshape.de

V01 2025-11-05 // DOCR000875

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11/2025