STEP 1

3D Print the .stl file

Select the 3D Model .stl file
Set up suitable setting printer parameters
Add proper support structure keeping keeping
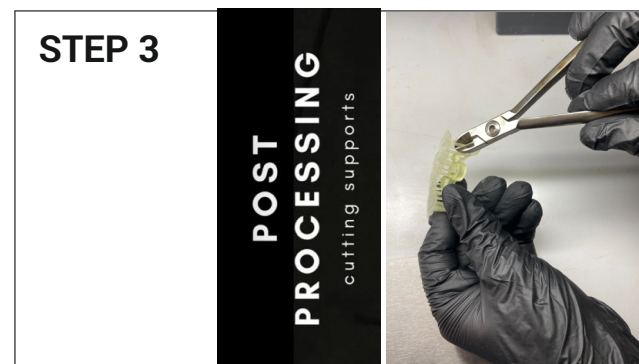intaglio free of supports
3D print the part

STEP 2

Wash the print
Wash the printed part in a cleaning chamber
filled with IPA (96%)
Wash the print in "1st wash " for 1.5 minutes
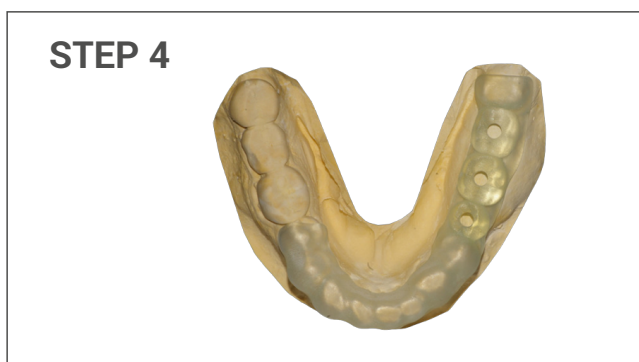After that wash in "2nd Wash "for another 1.5
minutes for extra cleaning

Note: Both washing chambers are filled with IPA (96%)

STEP 3

Support Removal
After printing is done, cut the support by using a
Flash cutter .

STEP 4

Check the fitting on a corresponding model
Check the fitment of printed Surgical Guide on
the corresponding dental model.
If it fits properly , go to the next step.

STEP 5

Insert sleeves at this time (Before post curing)

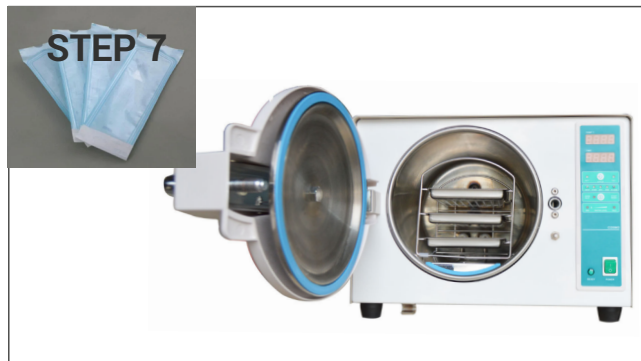Ensure a proper fit for the sleeves and guide

STEP 6

Post Cure
Put the printed part in a glass beaker / Glass pot filled with glycerol (50%) +water (50%) and post cure in a curing chamber. This allows the oxygen inhibited layer to cure.Set curing time based on machine power
1. 30-50 watt- Cure for 20 mins
2. 60-80 watt -Cure for 10 mins
3. >100 watt- Cure for 3-5 mins

*Curing under nitrogen or vacuum will improve results

STEP 7

Sterilize via Autoclaving before use
Insert the post cured guide in a sterilization pouch & seal the pouch

Put the sterilised pouch in an autoclave machine Dental 3D printed surgical guide must be sterilised with autoclave at 121° C for 15 minutes
If sterilization is sufficient the guide turns colourless

Please refer to these colour changes in your Surgical guide 3D printing process using D Tech Accuprint SG resins !!

YELLOW ON FIRST WASH AFTER PRINTING

ORANGE TINGED WHEN CURED

TRANSPARENT ON AUTOCLAVING

*Actual case images using D Tech 3D Accuprint Surgical Guide resin