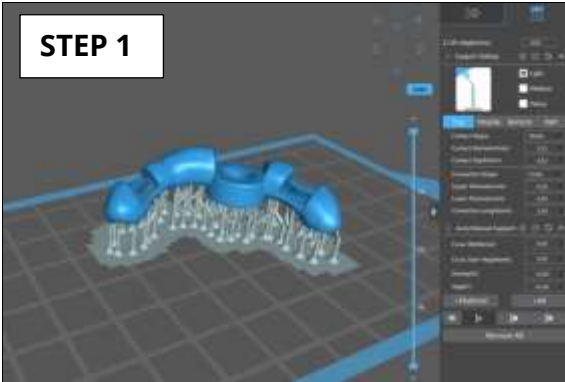


STEP 1



3D Print the .stl file

Select the 3D Model
Set up suitable setting parameters
Add proper support structure
Check the resin expiry date
Ensure that the printers VAT is clean
Start the print

Tip: Do not place the supports on seating side/area

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%)

POST PROCESSING

STEP 3



Support Removal

After printing is done, cut the support by using a Flash cutter , Needle nose pliers

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



Polishing & Finishing

Polish with a rotary tool / brush applying light to moderate pressure

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

Put the sterilised pouch in an autoclave machine

Dental 3D printed surgical guide must be sterilised with autoclave at 121°C for 15 minutes

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