

Overview PrograPrint[®] post-processing

PrograPrint Clean

Overview of cleaning times for PrograPrint compatible materials

The PrograPrint Stage with the printed objects is removed from the PrograPrint and placed in the build platform holder of the PrograPrint Clean. Perform the rough cleaning first, followed by fine cleaning (at 850 rpm) according to the specified cleaning parameters below.



The objects remain on the PrograPrint Stage during the entire cleaning process and are only removed after post-curing in the PrograPrint Cure (except for BEGO materials, see BEGO Instructions for Use for VarseoSmile Temp and VarseoSmile Crown plus).

Ivoclar Materials	Rough Cleaning	Fine cleaning
ProArt Print Splint	10 min	5 min
ProArt Print Model NewFormula	5 min	5 min
ProArt Print Wax	2 min	2 min

DETAX Materials	Rough Cleaning	Fine cleaning
FREEPRINT [®] temp	3 min	3 min
FREEPRINT [®] cast 2.0	3 min	3 min
FREEPRINT [®] gingiva	5 min	5 min
FREEPRINT [®] crown	3 min*	2 min
FREEPRINT [®] splint 2.0	3 min	3 min
FREEPRINT [®] splintmaster taff & flex	3 min	3 min
FREEPRINT [®] tray 2.0	3 min	3 min

BEGO Materials	Rough Cleaning	Fine cleaning
VarseoSmile Temp	3 min**	3 min
VarseoSmile Crown plus	3 min**	3 min

Keystone Materials	Rough Cleaning	Fine cleaning
KeyPrint [®] KeySplint Soft	3 min***	3 min***

* Before rough cleaning, blast off excess resin with compressed air. Please follow the original DETAX Instructions for Use.

** Between rough and fine cleaning, remove excess resin with a brush and Isopropyl alcohol. After fine cleaning, rinse again with gooseneck bottle and Isopropyl alcohol. Please follow the original BEGO Instructions for Use.

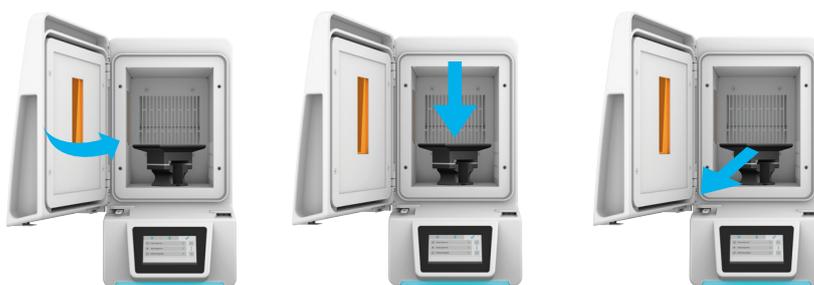
*** Magnetic stirrer setting: 1000 rpm

Overview PrograPrint[®] post-processing

PrograPrint Cure

Overview of curing parameters for PrograPrint compatible devices

The completely cleaned and dried objects are placed in the polymerization chamber of the PrograPrint Cure on the PrograPrint Stage. The preset curing program for the respective material type is selected and started via the user interface of the device.



The objects remain on the PrograPrint Stage during the entire cleaning process and are only removed after post-curing in the PrograPrint Cure (except for BEGO materials, see BEGO Instructions for Use for VarseoSmile Temp and VarseoSmile Crown plus).

Ivoclar Materials	Program
ProArt Print Splint	ProArt Print Splint
ProArt Print Model NewFormula	ProArt Print Model NewFormula / ProArt Print Model NewFormula LTP
ProArt Print Wax	ProArt Print Wax

DETAX Materials	Post Curing A	Post Curing B
	Wavelength Intensity Duration	Wavelength Intensity Duration
FREEPRINT [®] temp	405 nm 100% 2 min	460 nm 100% 2 min
FREEPRINT [®] cast 2.0	405 nm 100% 2 min	460 nm 100% 2 min
FREEPRINT [®] gingiva	405 nm 100% 2 min	460 nm 100% 2 min
FREEPRINT [®] crown	405 nm 45% 5 min	460 nm 45% 5 min
FREEPRINT [®] splint 2.0	405 nm 100% 2 min	460 nm 100% 2 min
FREEPRINT [®] splintmaster taff & flex	405 nm 100% 90 s	460 nm 0% 0 s
FREEPRINT [®] tray 2.0	405 nm 100% 2 min	460 nm 100% 2 min

BEGO Materials*	Post Curing A	Post Curing B
	Wavelength Intensity Duration	Wavelength Intensity Duration
VarseoSmile Temp	405 nm 25% 2 min	460 nm 25% 2 min
VarseoSmile Crown plus	405 nm 25% 2 min	460 nm 25% 2 min

Keystone Materials	Post Curing A	Post Curing B
	Wavelength Intensity Duration	Wavelength Intensity Duration
KeyPrint [®] KeySplint Soft	405 nm 100% 14 min	460 nm 100% 14 min

* Please note: For BEGO Materials, the program must be applied twice per object. After the first cycle, turn the objects on the object tray of the PrograPrint Cure.