

PRINTING GUIDE

Elos Accurate®
Open Digital Solutions

Carbon

Model by Carbon with Elos Accurate® Analog for Printed Models

A model analog specifically created for 3D printers

The new analog is available for the major implant platforms and colour coded according to the implant manufacturer.

The Elos Accurate Analog for Printed Models can only be installed in the correct position, has a press fit and is automatically centered in the model socket. If you still want to have an extra insurance of the safe seating, there is an optional special screw available for this purpose.

For a good result with the combination of this 3D printer and the Elos Accurate Analog for Printed Models, please follow the information in the chart:



Printer	Material	Layer thickness	Support material	Post curing	Cleaning Method	Analog offset recommendation	Recommendations
M2 Printer	DPR 10	50µm	N/A	Please see step 3 and 4 below.	Please see step 1 and 2 below.	R 0.010-0.015 mm or Ø 0.02-0.03 mm	N/A

* The information in the table should be used as a guideline. Always take into account the printer's condition and other aspects that may affect the quality of the print.

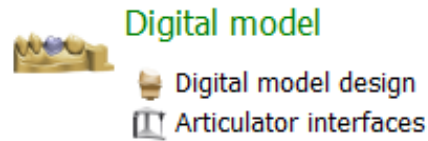
Post processing steps:

1. Wash for 5 minutes at 120 rpm on orbital shaker. Move parts to a container of fresh IPA, wash again for 5 minutes at 120 rpm.
2. Air dry for 30 minutes.
3. Cure parts on the top shelf for 30 seconds on each side in 6 seconds increments. Flip parts between exposures in the Dymax ECE 5000.
4. Cure parts for 2 minutes at 90% intensity, under vacuum in the DREVE PCU LED.

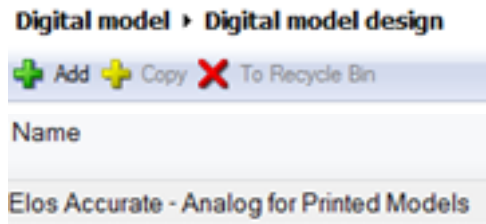
How to setup "Analog offset recommendation" in 3shape and Dental Wings



In the 3shape Dental System Control Panel, under Digital Model - Select Digital Model Design



In Digital Model Design – select an existing or create a new file to add the desired values for your printer



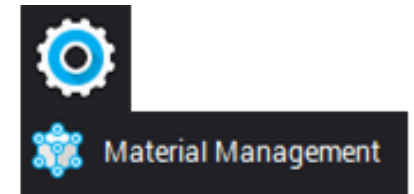
Under the Model and Manufacturing tab, the relevant setting for the Elos Accurate Analog for Printed Models are the ones listed below.

- Number of Analog Friction Bars = Always "0"
- Analog to Model Spacing (mm) = the value suited for your printer
- Protect Analog (soft tissue) = Always "True"
- Protect Analog Distance (mm) = No less than 0.6mm

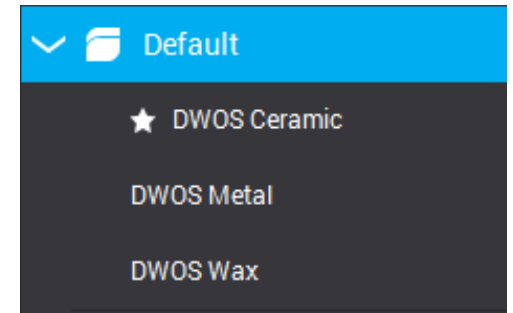
Number of Analog Friction Bars	Analog to Model Spacing (mm)	Protect Analog (soft tissue)	Protect Analog Distance (mm)
0	0.020	True	1.000



In the DWOS Client software, click on the settings icon to access the material management

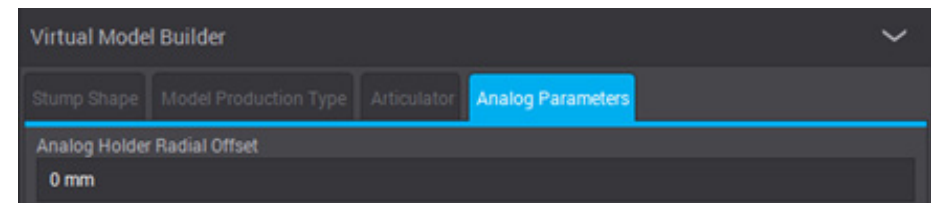


In the Material management select the material file you wish to add the settings to or create your own



In the selected material file, select the Virtual Model Builder section and click on the Analog Parameters tab.

In the Analog Holder Radial Offset enter the desired value to suit your printer.



For further information, please contact your local software reseller for support.