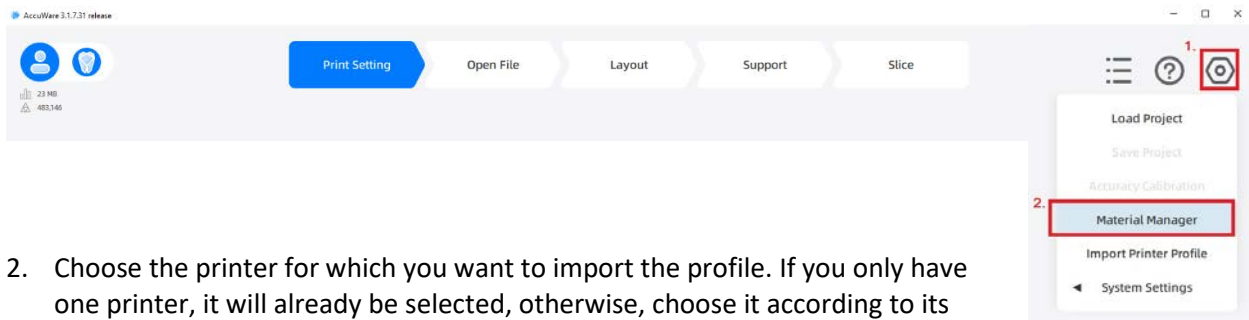
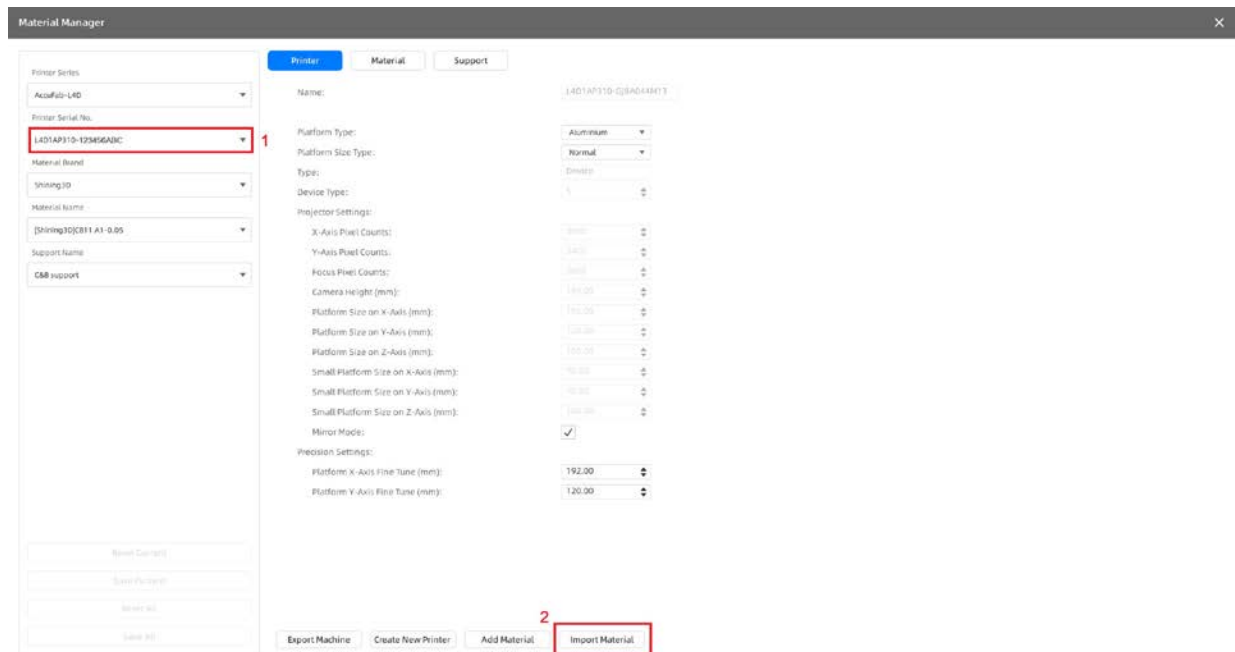


IMPORTANT : Accuware must be version 3.2.0.48 or higher.

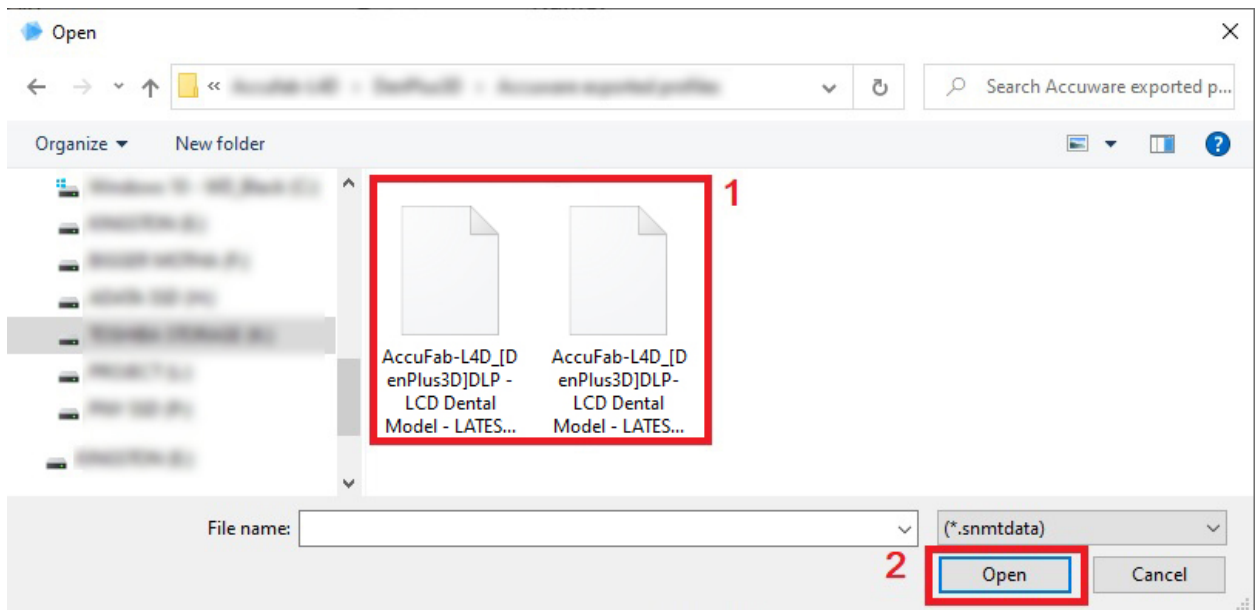
1. Access the **Material Manager** from the Settings:



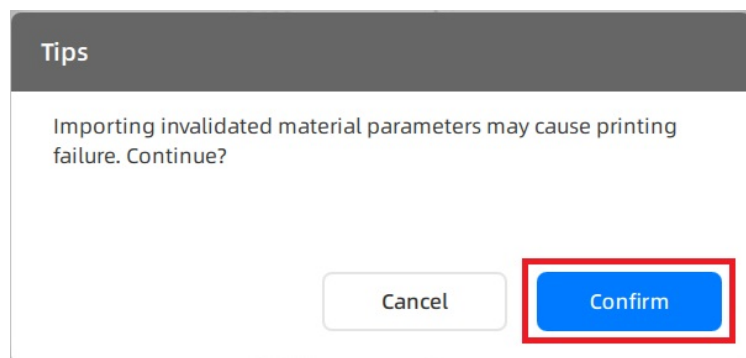
2. Choose the printer for which you want to import the profile. If you only have one printer, it will already be selected, otherwise, choose it according to its serial number. Then click on Import Material:



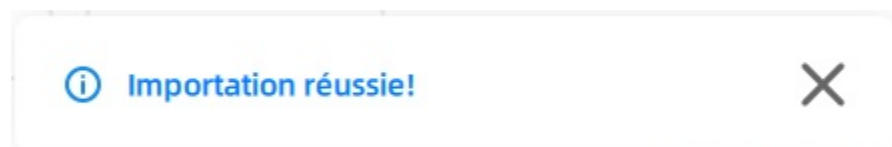
3. Navigate to where you extracted the contents of the .zip document that you downloaded from the DenPlus site, then select the **DenPlus3D Cast Green** material profile, and click **Open** (below image shown as example only):



4. A warning will appear. Simply click **Confirm** :



5. A pop-up will inform you that the operation was successful.



7. To validate that the materials have been added, click on **Material** at the top:

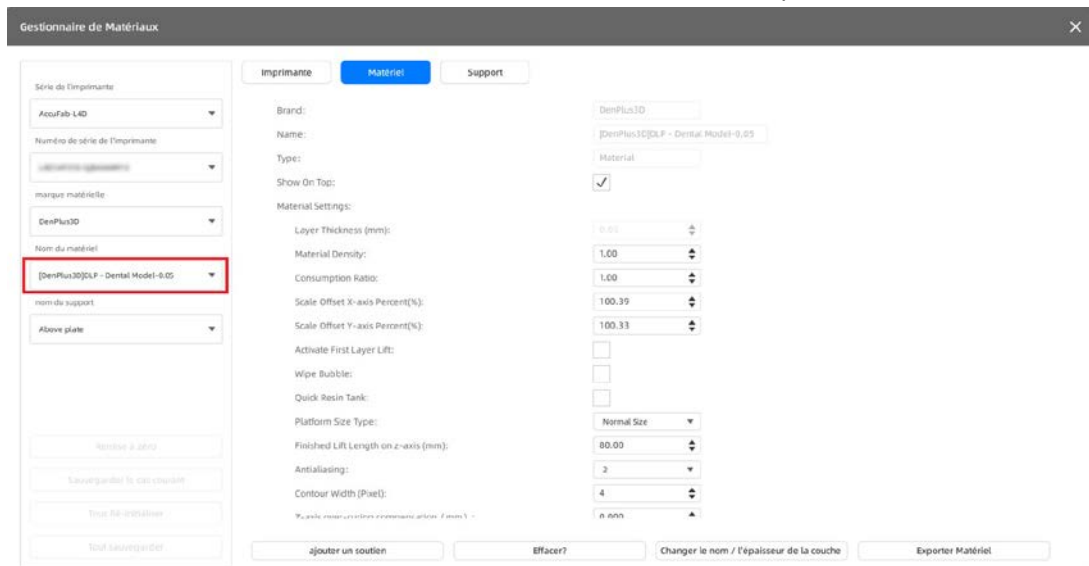
The screenshot shows the 'Gestionnaire de Matériaux' window. At the top, there are three tabs: 'Imprimante', 'Matériel', and 'Support'. The 'Matériel' tab is selected and highlighted with a red box. On the left, there are dropdown menus for 'Série de l'imprimante' (set to 'AccuFab-L4D'), 'Numéro de série de l'imprimante', 'marque matérielle' (set to 'Ligcreate'), 'Nom du matériel' (set to '[Ligcreate]Strong-X-0.05'), and 'nom du support' (set to 'Regular'). Below these are buttons for 'Remettre à zéro', 'Sauvegarder la configuration', 'Tous les paramètres', and 'Tout sauvegarder'. The main area displays various settings for the material, including 'Name' (L4D1AP310-Q|BA044M13), 'Platform Type' (Aluminium), 'Platform Size Type' (Normal), 'Type' (Device), and 'Device Type' (0). There are also 'Projector Settings' with values for X-Axis Pixel Counts, Y-Axis Pixel Counts, Focus Pixel Counts, Camera Height (mm), Platform Size on X-Axis (mm), Platform Size on Y-Axis (mm), Platform Size on Z-Axis (mm), Small Platform Size on X-Axis (mm), Small Platform Size on Y-Axis (mm), and Small Platform Size on Z-Axis (mm). At the bottom, there are buttons for 'Export machine', 'Créer une Nouvelle Imprimante', 'ajouter du matériel', and 'Importer Matériel'.

8. Select **DenPlus3D** from the **Material Brand** menu:

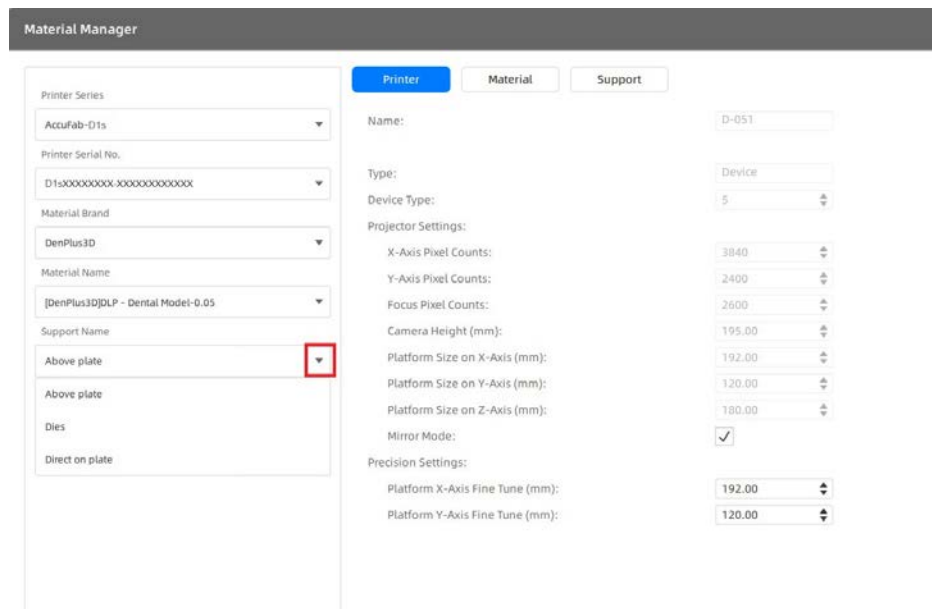
The screenshot shows the 'Gestionnaire de Matériaux' window. At the top, there are three tabs: 'Imprimante', 'Matériel', and 'Support'. The 'Matériel' tab is selected. On the left, there are dropdown menus for 'Série de l'imprimante' (set to 'AccuFab-L4D'), 'Numéro de série de l'imprimante', 'marque matérielle' (set to 'Shining3D' and highlighted with a red box), 'Nom du matériel' (set to '[Shining3D]DC12-0.05'), and 'nom du support'. The main area displays various settings for the material, including 'Brand' (Shining3D), 'Name' ([Shining3D]DC12-0.05), 'Type' (Material), 'Show On Top' (checked), and 'Material Settings' with values for Layer Thickness (mm) (0.05), Material Density (1.00), Consumption Ratio (1.00), Scale Offset X-axis Percent(%) (100.52), and Scale Offset Y-axis Percent(%) (100.52).

The screenshot shows the 'Gestionnaire de Matériaux' window. At the top, there are three tabs: 'Imprimante', 'Matériel', and 'Support'. The 'Matériel' tab is selected. On the left, there is a dropdown menu for 'marque matérielle' with a list of brands: Shining3D, BASF, Bego, DETAX, DMG, DenPlus3D (highlighted with a red box), Dreve, GorkyLiquid, Graphy, HARZ Labs, and Wuxi. The main area displays various settings for the material, including 'Brand' (Shining3D), 'Name' ([Shining3D]DC12-0.05), 'Type' (Material), 'Show On Top' (checked), and 'Material Settings' with values for Layer Thickness (mm) (0.05), Material Density (1.00), Consumption Ratio (1.00), Scale Offset X-axis Percent(%) (100.52), and Scale Offset Y-axis Percent(%) (100.52).

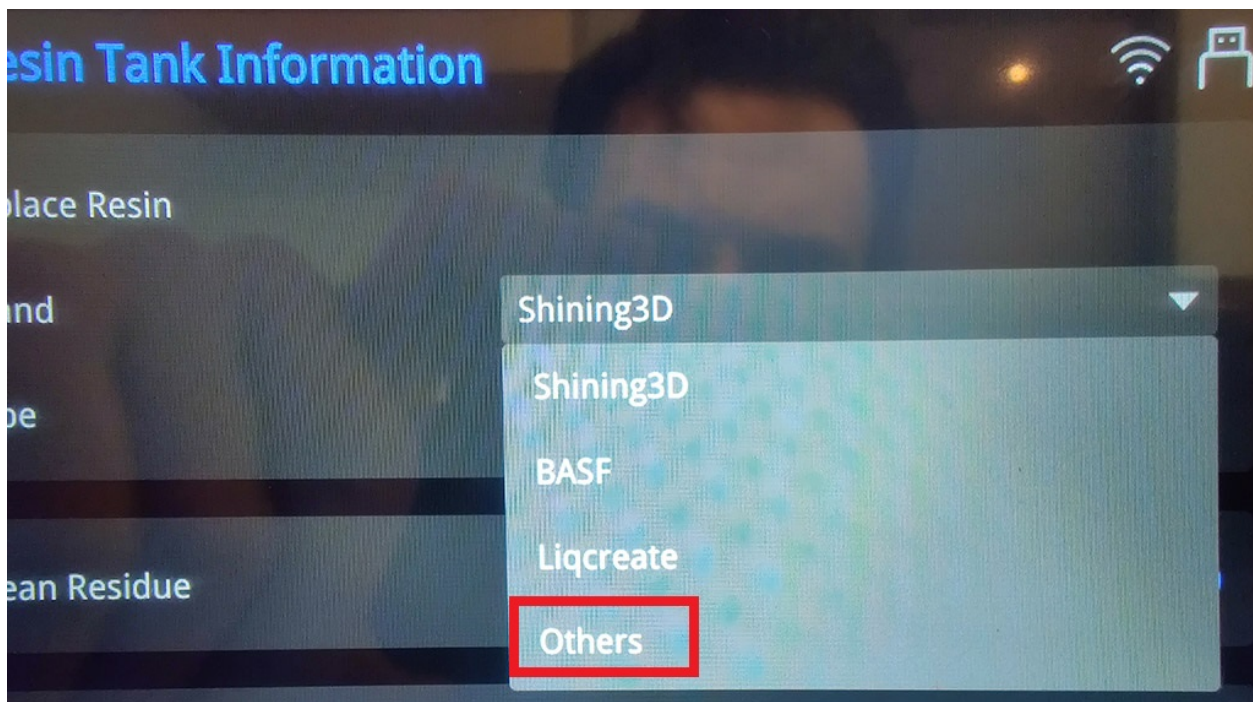
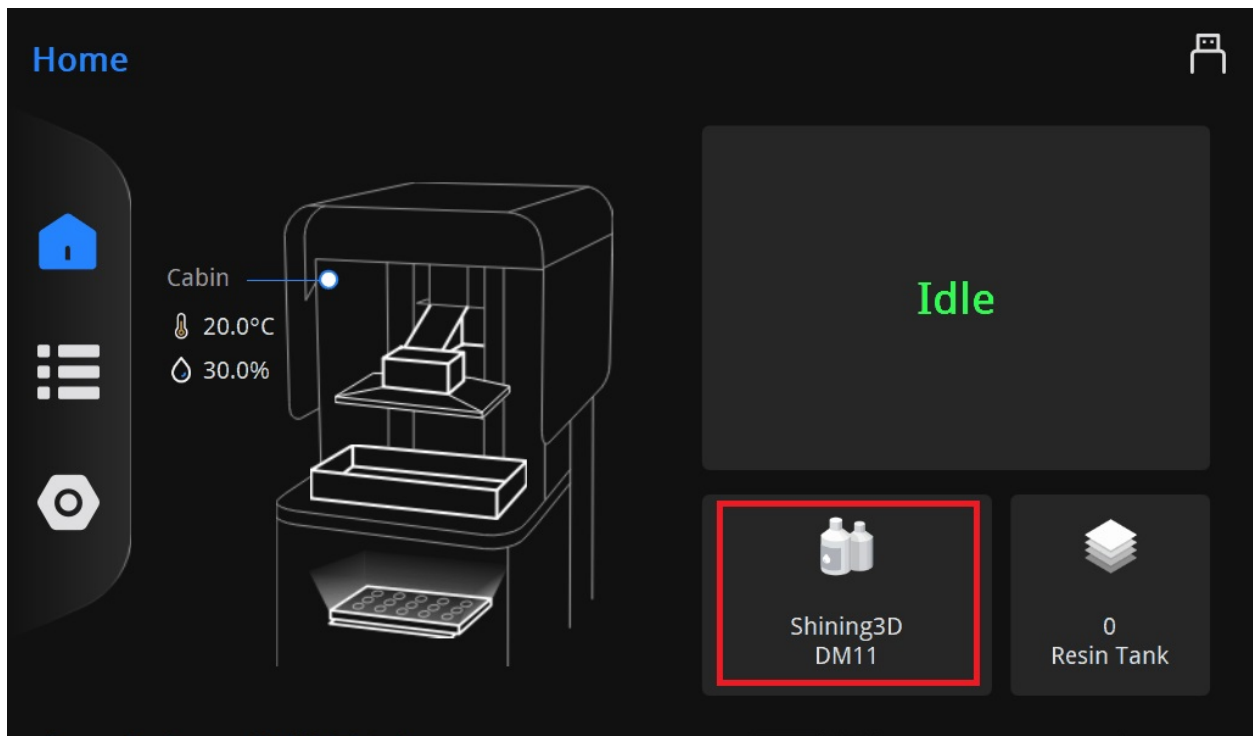
Then, under the **Material Name** menu, the DenPlus3D Cast Green-0.05 profile should be found:



The DenPlus3D material profile includes a selection of support (visible in the Support Name menu) adapted according to their application (below image as example only).



IMPORTANT: Be sure to set your printer's resin tank to **Others**. This is done from the touch screen of your printer as shown in the images below:



You are now ready to use the DenPlus3D Green Casting resin with your AccuFab-L4D printer.

Accuracy Calibration

The profile parameters of DenPlus3D model resin are the result of rigorous testing. These parameters were subsequently validated on several AccuFab-L4Ds before being published. We are confident in the results you will obtain, in terms of precision, by using these material profiles as is. However, we cannot assume that 100% of users will obtain the same results. Accuware has a resin profile calibration feature called **Accuracy Calibration**.

This function allows you to automatically calibrate three parameters whose values may differ from one AccuFab-L4D to another. Those are:

- **X and Y Scaling Compensation (%)**
- **Contour Compensation (mm)** for General Layers

The screenshot displays the 'Accuracy Calibration' interface. At the top, there are fields for 'Série de l'imprimante' (AccuFab-L4D), 'Numéro de série de l'imprimante' (L4D1AP310-GJBA044M13), 'Type de plateforme' (Taille normale selected), 'Matériel' (DenPlus3D and Dental Model (dental model)), and 'Mode' (0.05). Below these is a 'Plus Réglages' section. The 'Angle de rotation' section shows X, Y, and Z rotation values all set to 0 degrees. The 'Compensation d'échelle' section shows X and Y scaling compensation values of 100.75% and 100.78% respectively. The 'Compensation des contours' section shows a contour compensation value of -0.013 mm. The 'Compensation d'échelle' and 'Compensation des contours' sections are highlighted with a red box.

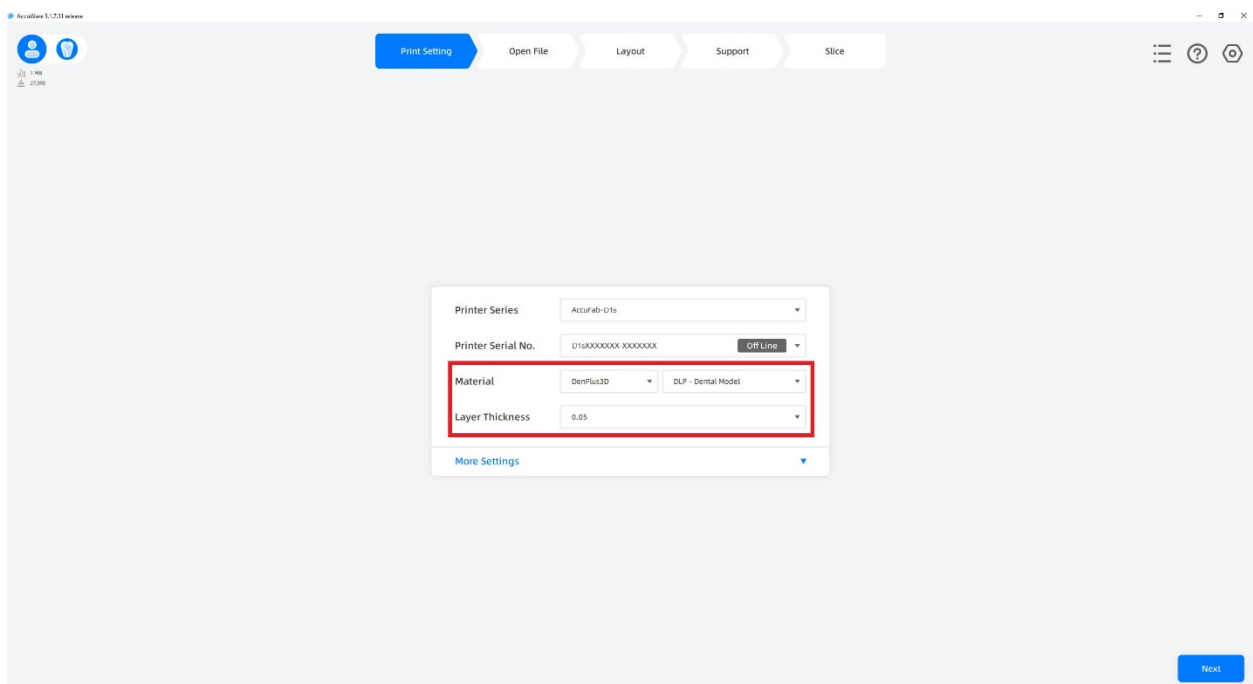
If your **printed parts** do not fit your models as intended, then use this function to fine-tune these parameters for your own AccuFab-L4D.

You will need a digital caliper, as shown here, set to mm.

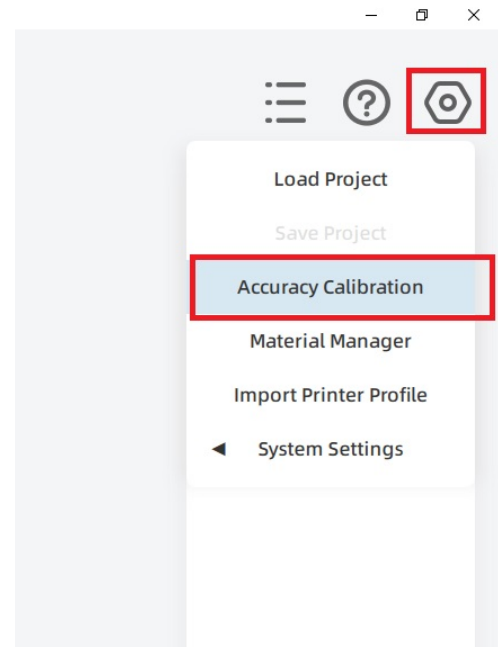


Before proceeding, make sure to fill your printer tank with DenPlus3D Casting Green resin. The resin bottle should have been shaken well and the resin allowed to sit in the tank until it is free of air bubbles.

1. Launch Accuware and make sure the DenPlus3D Casting Green material is selected, then click **Next**:



2. Open the **Settings** menu and click on **Accuracy Calibration**.



3. This will open the **Accuracy Calibration Guide**. Click **Print Calibration Model**:

Accuracy Calibration Guide

Printer Serial No.:
D1sXXXXXXX-XXXXXXX

Material Name:
[DenPlus3D]DLP - Dental Model

1
Print

2
Measure

3
Result

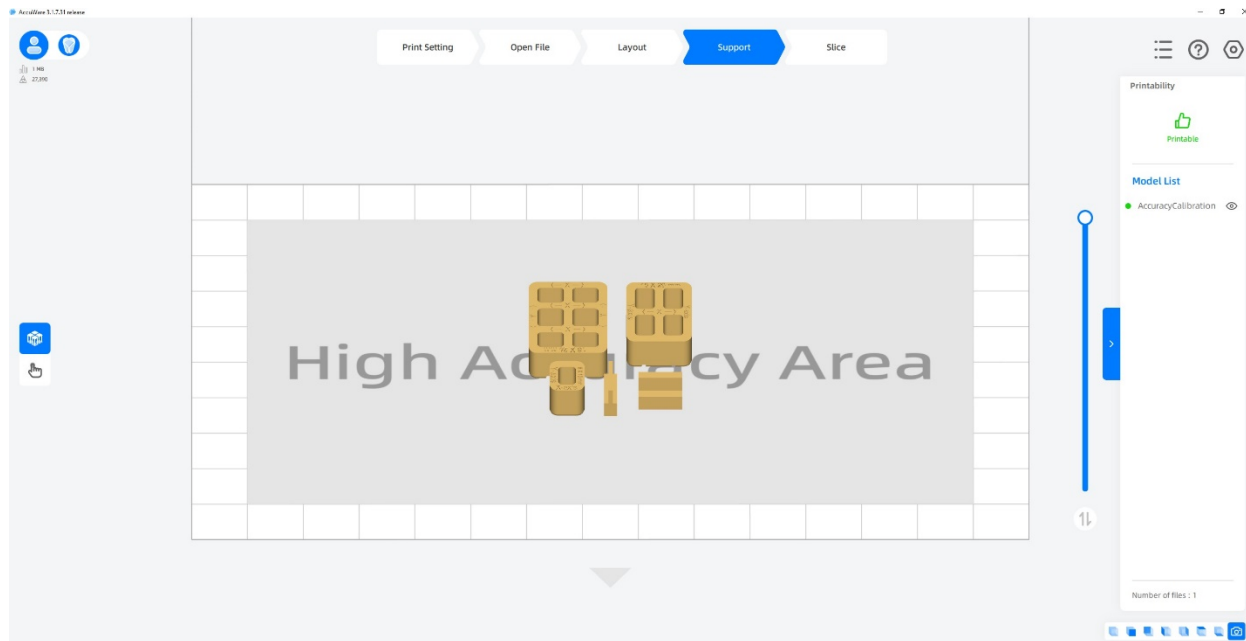
This wizard will take you through appropriate steps to compute the optimal scale and offset configurations in both X and Y directions. Please ensure that the current select printer and material are the desired printer and material for calibration. You can click the "Print Calibration Model" button to slice and print parts. After the proper post-processing (wash and cure), please check "Calibration Model Print Finished" and go to the next step.

Print Calibration Model

☐ Calibration Model Printed

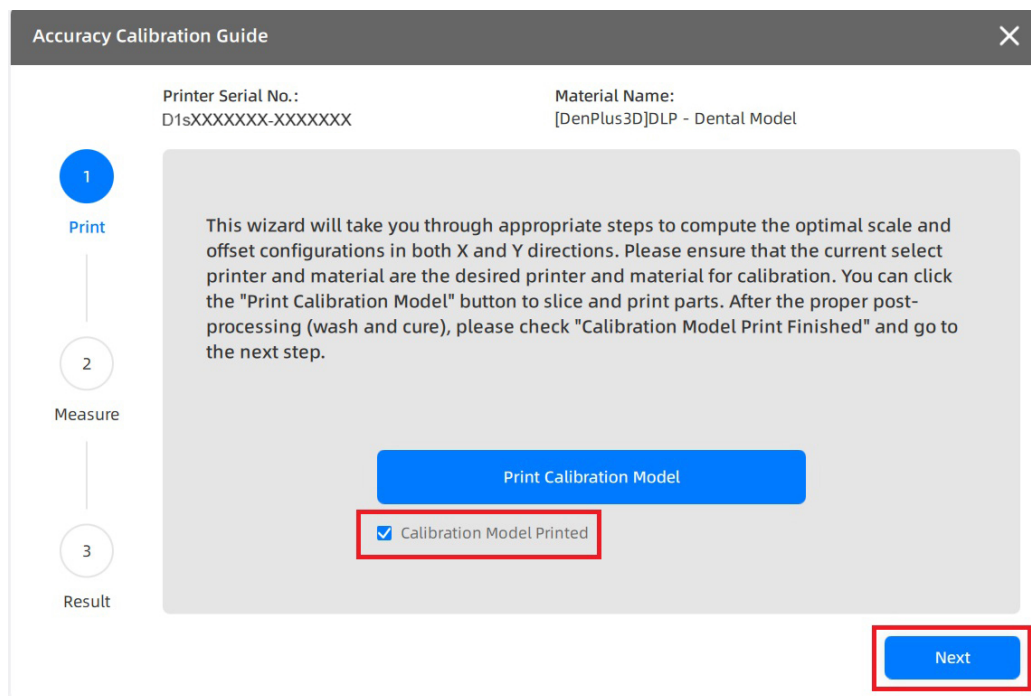
Next

- This will instantly load and slice a set of parts in the center of the plate. Go ahead and print these parts.



Once printed, parts must be adequately washed, dried and post-cured for 10 minutes in FabCure 1 (or equivalent), then allowed to cool to room temperature.

- Run **Accuracy Calibration** again, but this time check the **Calibration Model Printed** check box and click **Next**:



6. This will open the following table:

Accuracy Calibration Guide

×

Printer Serial No.:
D1sXXXXXX-XXXXXX

Material Name:
[DenPlus3D]DLP - Dental Model

Unit: mm

	Axis	Standard	Average	Measure 1	Measure 2	Measure 3
<div>1</div> <div>Print</div>	X	18	0.000	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>
	Y	24	0.000	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>
<div>2</div> <div>Measure</div>	X	15	0.000	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>
	Y	20	0.000	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>
<div>3</div> <div>Result</div>	X	8	0.000	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>
	Y	10	0.000	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>
	X	1	0.000	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>
	Y	2	0.000	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>	<input type="text" value="0.000"/>

* Fill in the measurement

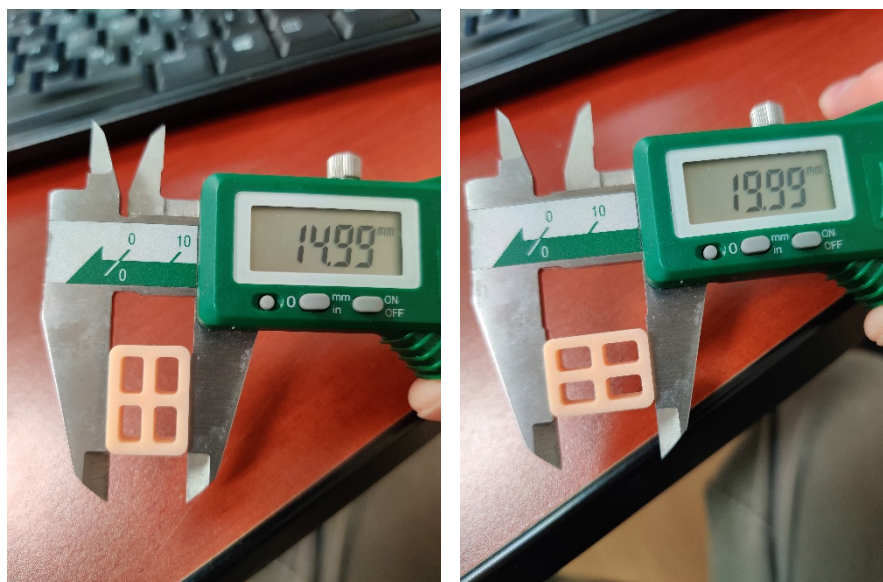
* When "Average" is red, please check the measurements and completeness of the part.

Prev Step

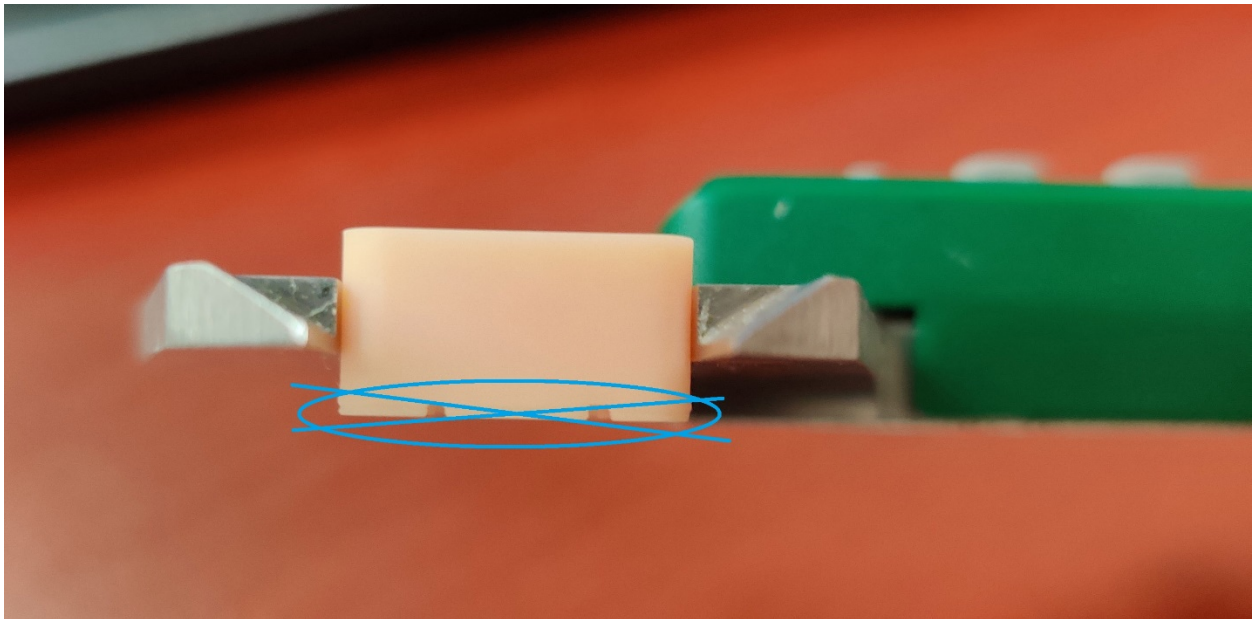
Next

7. Measure each of the X and Y dimensions of the corresponding parts, three times, and fill in each of the Measure fields. Make sure you enter the values in the correct boxes. Your three measurements may be the same, that's okay.

IMPORTANT: When measuring, make sure the part is lying flat against the thickest area of the caliper forks:



Also, do not take your measurements at the bottom of the parts (which is attached to the build plate) as these areas are naturally wider due to the longer exposure time of the first 20 layers:



8. Once the three columns are completed, click **Next** at the bottom right:

Accuracy Calibration Wizard

Printer Serial No.:
D1sXXXXXXXX-XXXXXXX

Material Name:
[DenPlus3D]DLP - Dental Model

Unit: mm

	Axis	Standard	Average	Measure 1	Measure 2	Measure 3
<div>1</div> <div>Print</div> <div></div>	X	18	17.970	<input type="text" value="17.970"/>	<input type="text" value="17.970"/>	<input type="text" value="17.970"/>
	Y	24	23.937	<input type="text" value="23.940"/>	<input type="text" value="23.940"/>	<input type="text" value="23.930"/>
<div>2</div> <div>Measure</div> <div></div>	X	15	14.970	<input type="text" value="14.980"/>	<input type="text" value="14.970"/>	<input type="text" value="14.960"/>
	Y	20	19.990	<input type="text" value="19.980"/>	<input type="text" value="19.990"/>	<input type="text" value="20.000"/>
<div>3</div> <div>Result</div> <div></div>	X	8	7.997	<input type="text" value="8.000"/>	<input type="text" value="8.000"/>	<input type="text" value="7.990"/>
	Y	10	10.007	<input type="text" value="10.010"/>	<input type="text" value="10.000"/>	<input type="text" value="10.010"/>
	X	1	1.027	<input type="text" value="1.020"/>	<input type="text" value="1.030"/>	<input type="text" value="1.030"/>
	Y	2	1.997	<input type="text" value="1.980"/>	<input type="text" value="2.000"/>	<input type="text" value="2.010"/>

* Fill in the measurement

* When "Average" is red, please check the measurements and completeness of the part.

Prev Step

Next

Accuware will calculate the values for **X and Y Scale Compensation (%)** and **Contour Compensation (mm)**. The values shown below are for example purposes only:

Accuracy Calibration Guide

Printer Serial No.:
D1sXXXXXX-XXXXXX

Material Name:
[DenPlus3D]DLP - Dental Model

1
Print

2
Measure

3
Result

Click "Apply" to update the parameter of the current printer.

X Scale Factor: 100.44%

Y Scale Factor: 100.24%

Contour Compensation: -0.003mm

Prev Step

Apply

9. By clicking **Apply**, these values will automatically be set in your DenPlus3D material profile.

Repeat steps 4 to 7 to validate if your results are closer to the standard measurements and repeat the calibration process again if your results are still too far from the standard measurements. It is not out of the ordinary to repeat this process three times. Note that it is almost impossible to obtain the exact X and Y dimensions on all calibration parts. What you are looking to get are measurements to within +/- 0.05mm.

Tips:

1. If your parts fall off the printing plate or partially separate from the plate during printing, there are several possible causes and common sense should be used to find the cause.
 - The most common cause is an incorrectly leveled printing plate. It may have been well leveled for a while, but over time it will gradually shift. Significant changes in ambient temperature can also affect the leveling. It is important to re-level your plate from time to time.
 - If you've been printing for a while, it's likely that your printing plate has become smoother due to frequent scraping and cleaning. To give it a more adherent surface, you can either scratch the surface with 80-grit abrasive paper, or micro-sand it with 50 μ m aluminum oxide. In the second case, make sure to only expose the printing area of the plate and clean it carefully afterwards.

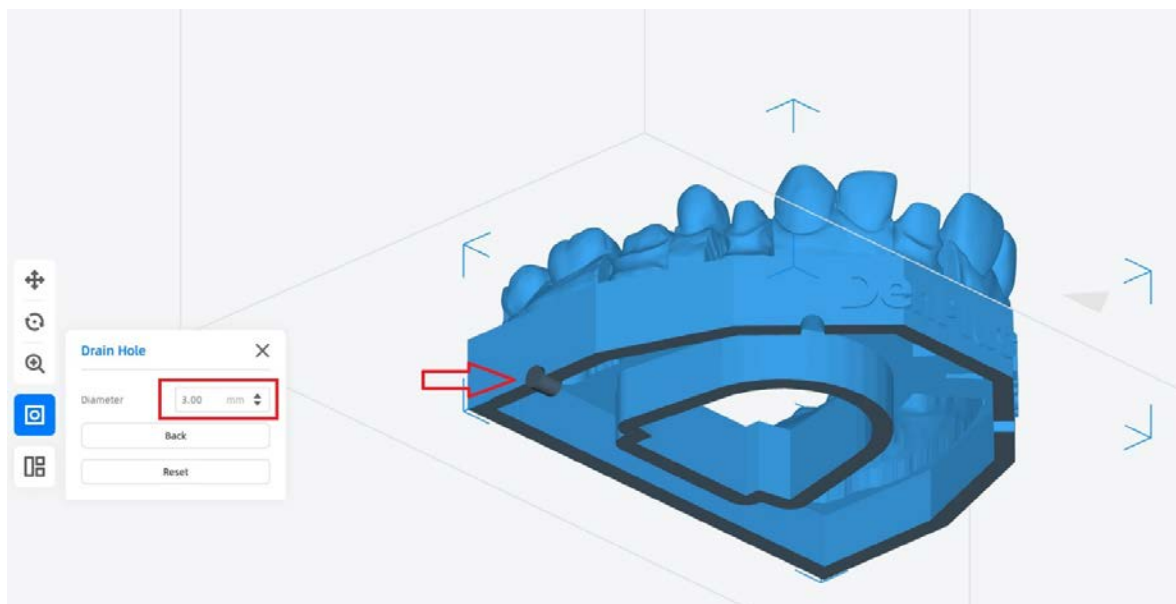
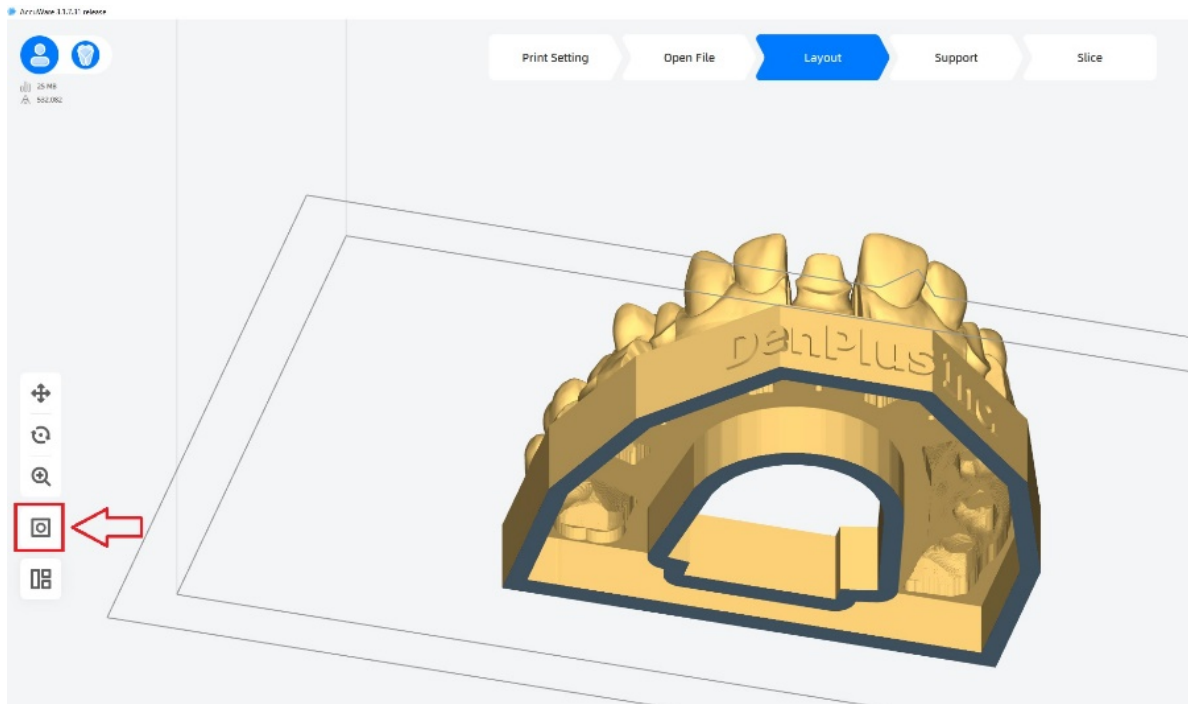
- If your printing plate is leveled and the surface is in good condition, you may need to increase the three **Enhanced Layers** values: **Fill Exposure Time**, **Boundary Exposure Time**, and **Support Exposure Time** by a few seconds (values in below image shown as example only):

	Enhanced Layer	Medium Layer	General Layer
Layer Counts:	3	16	0
Exposure Level:	Mid Power Mode	Mid Power Mode	Mid Power Mode
Fill Exposure Time (s):	14.00	6.20	4.30
Boundary Exposure Time (s):	14.00	6.20	4.30
Support Exposure Time (s):	14.00	6.20	4.30
Wait Time on Top (s):	1.00	1.00	0.00
Wait Time before Exposure (s):	2.00	2.00	2.00
Wait Time after Exposure (s):	0.00	0.00	0.00
Slow Lift Length on z-axis (mm):	2.0	2.0	1.5
Slow Lift Speed on z-axis (mm/min):	60	60	60

If, on the other hand, your parts are too difficult to remove from the plate, decrease the same settings in 1 second increments.

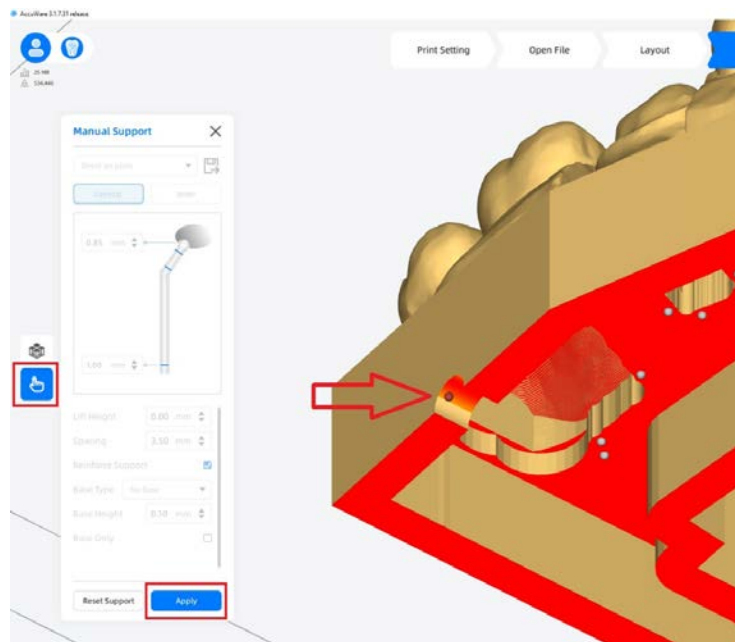
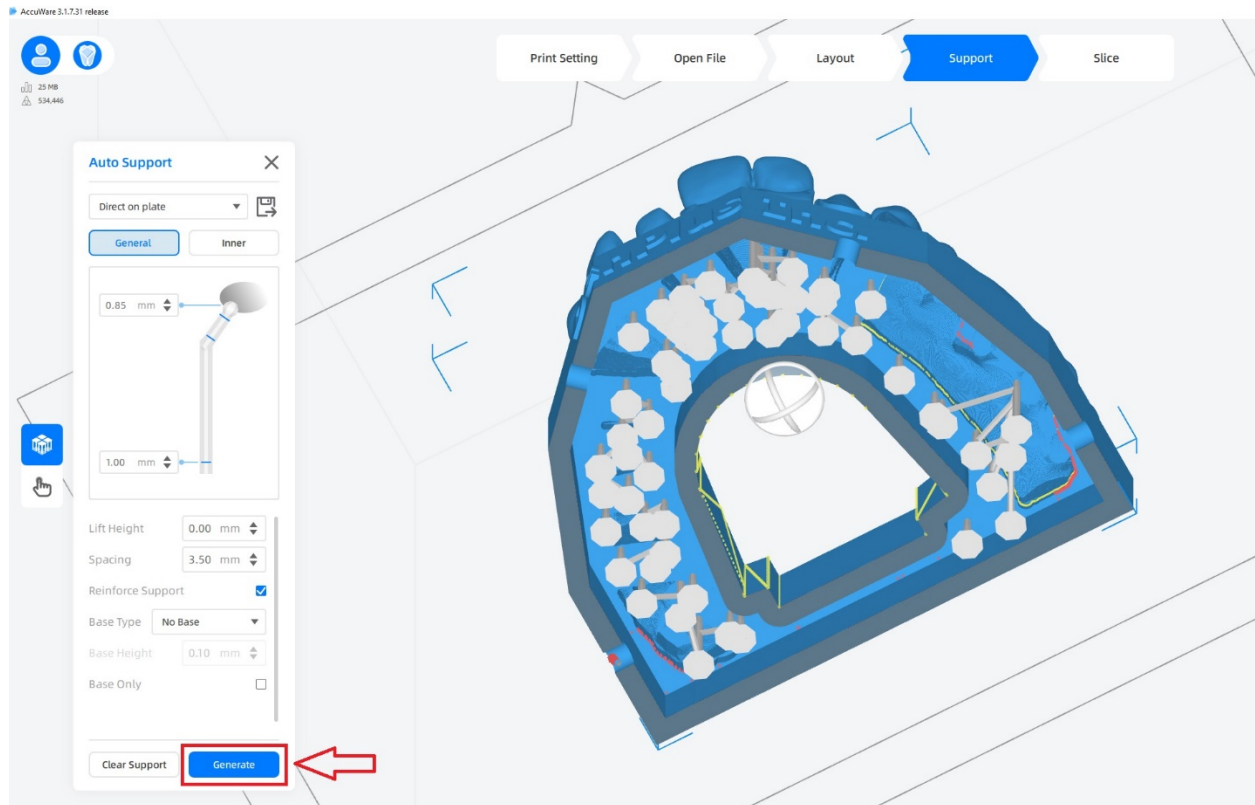
Note that these settings, accessible via the **Accuware Materials Manager**, are only visible if **Engineer mode** is enabled. Contact your Shining 3D representative to find out how to enable it.

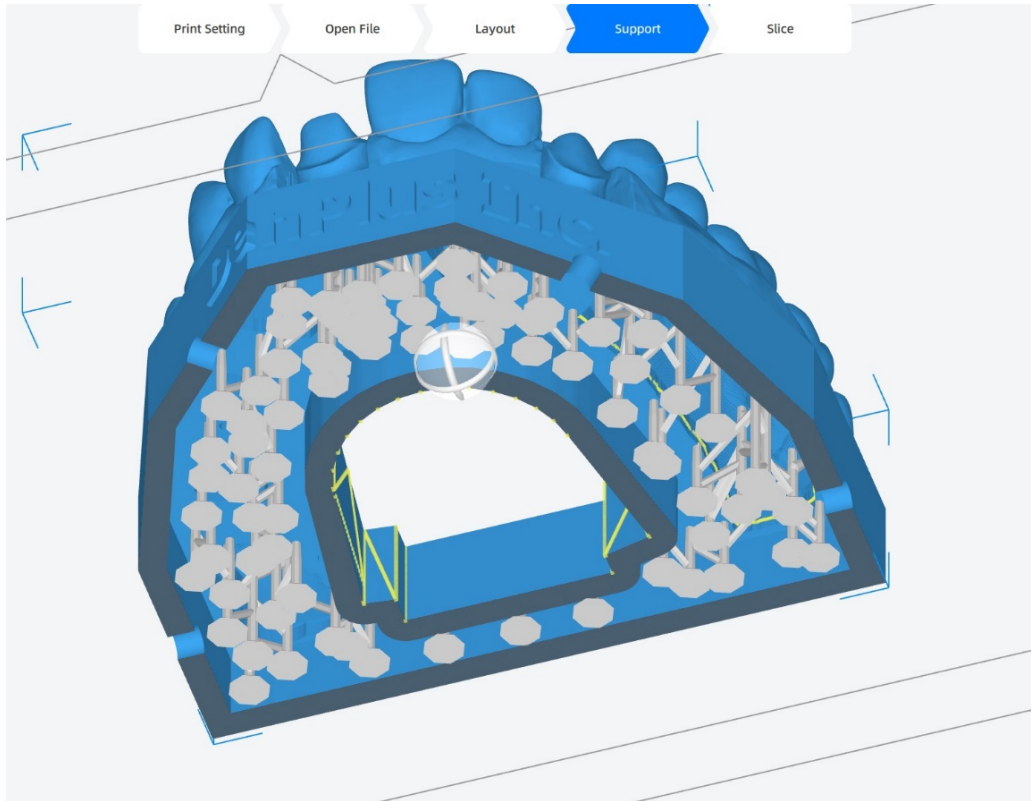
2. If you print hollow models directly on the plate, it is imperative to place drain holes (minimum 6 for a full arch) at the base of the models. A diameter of 3 mm is generally sufficient.



3. Hollow models require supports. In Accuware, select our **Direct on plate** support profile and, first, use **Auto Support** to generate them.

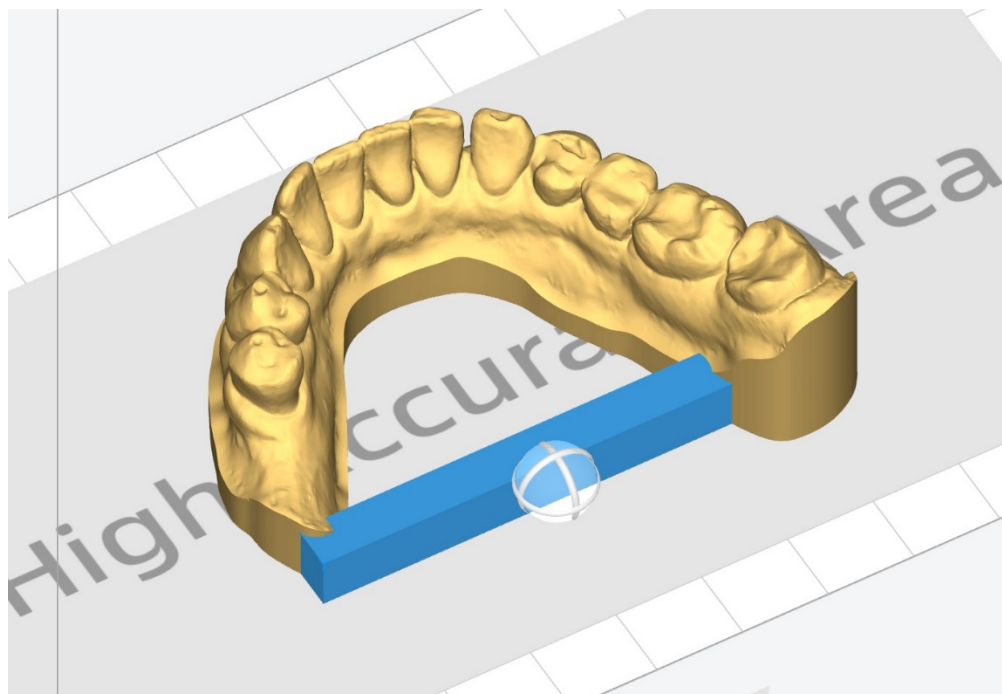
Next, switch to **Manual Support** to add additional supports in the red areas, if necessary, and remove unnecessary supports in the drain holes.





4. Use common sense when designing your models:

- Hollow models must have a minimum thickness of 2.5 mm.
- Lower arches may warp inward. To avoid this, place a bar at the bottom that connects the two posterior ends:



5. When designing a complete top model with arch, which will be printed directly on the plate, add enough height to the model so that the lowest part of the arch is at least 6mm from the ground. This ensures that no part of the palate is made up of Reinforced Layers or Medium Layers, but also reduces the risk of experiencing a printing error or distortion in the palate. As mentioned above, an internal honeycomb structure is recommended for this type of model rather than a shell or solid model.

