3D PRINTERS FOR ALIGNERS MODELS

# TIPS FOR MASTERING INDUSTRIAL HIGH QUALITY CLEAR ALIGNERS

PRODWAYS

## 01

## USE HIGHER XY RESOLUTIONS

Use typical resolution of **50µm and below**

Check native hardware resolution vs virtual pixels derived from software tricks

## DO NOT CONFUSE RESOLUTION AND ACCURACY

Define your **Quality assurance** procedure

Ensure proper slicing and leverage sub-pixel computation **to not deviate from STL**

## 02

## DEFINE YOUR LAYER THICKNESS

Manufacturing speed is directly linked to selected thickness

Surface quality is overall “qualitative”

## BUILD LINES ARE VISIBLE ABOVE 100µm LAYERS

> Going **below 75µm** won’t improve much

> **Beyond 175µm**, it will be strongly visible

## 03

## THINK OF YOUR POST-PROCESS

IPA cleaning increases details and layer visibility

**Centrifuge cleaning** will help getting a smoother surface

Make sure your post-process complies with medical device certification procedure