



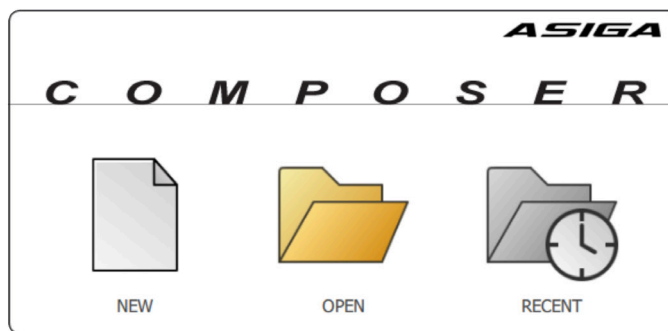
trūsana™

Validated on

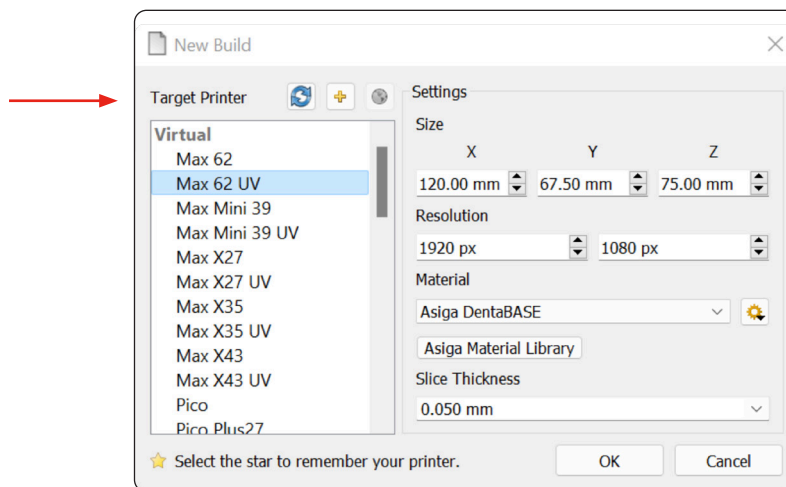
ASIGA

Asiga Composer Validated Workflow

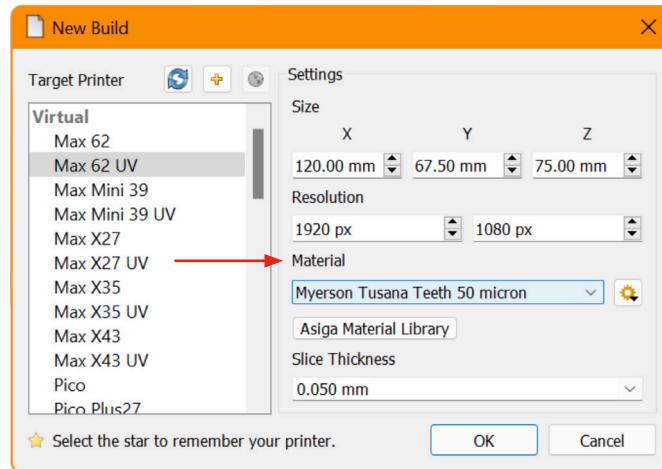
Select **New Build**



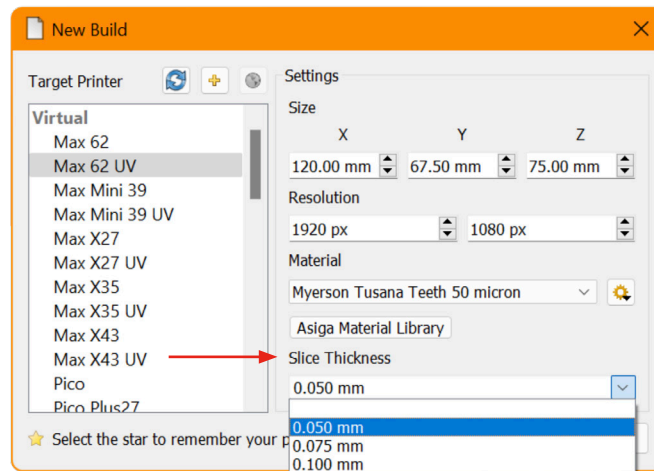
Select your printer in **Target Printer**



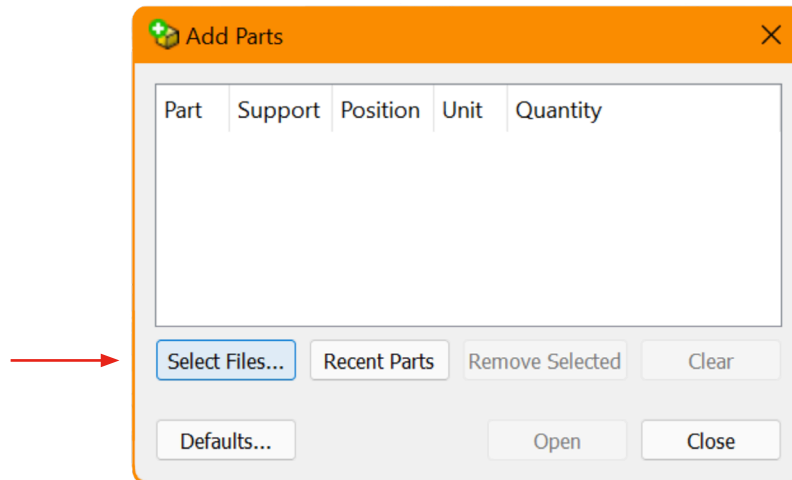
Select **Myerson Trusana Teeth 50 micron** in **Material**



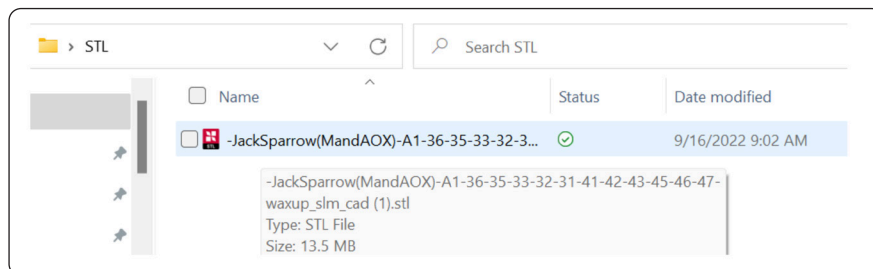
Select **0.050 mm** in **Slice Thickness** and click **OK**



On the **Add Parts** screen, choose **Select Files** and navigate to where your objects are stored

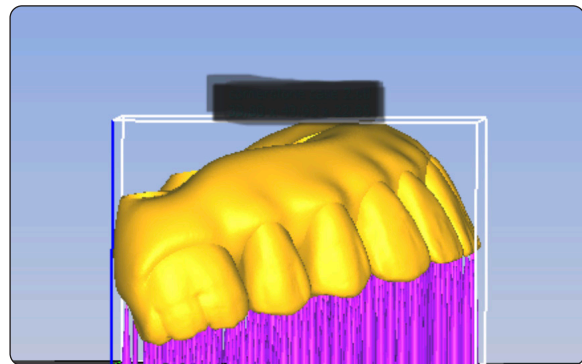
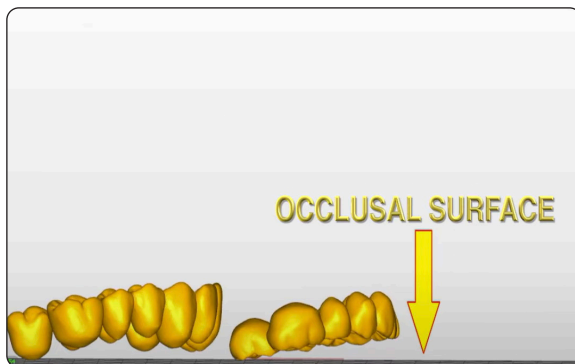


Select your files and click **Open** to import



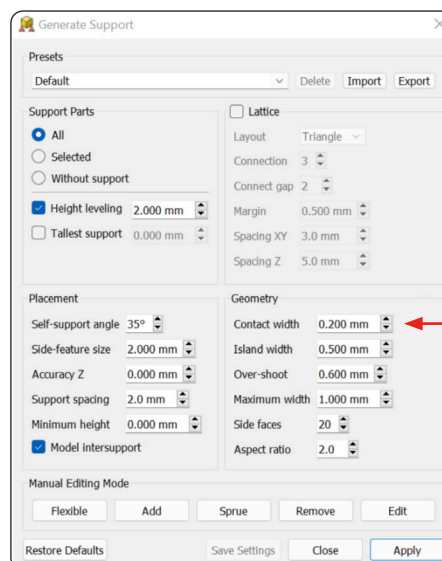
Always have the occlusal surface facing the build plate

- To move the objects, left click and hold.
- To rotate the objects, right click and hold.
- Full arch implant cases must be oriented at a 20 degree angle or more, making sure the access holes are at an angle.

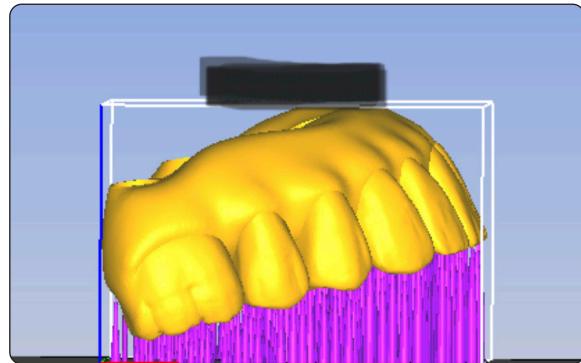
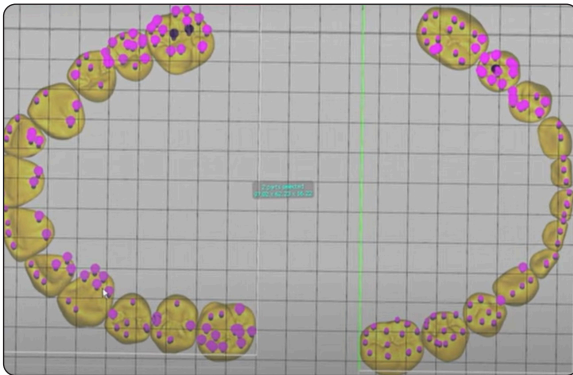


To attach supports, go to **Generate Support**

- Make sure the **Contact width** value is set to **0.200 mm**
- To customize supports Click **Add** or **Remove**. Click **Apply**



Supports Added

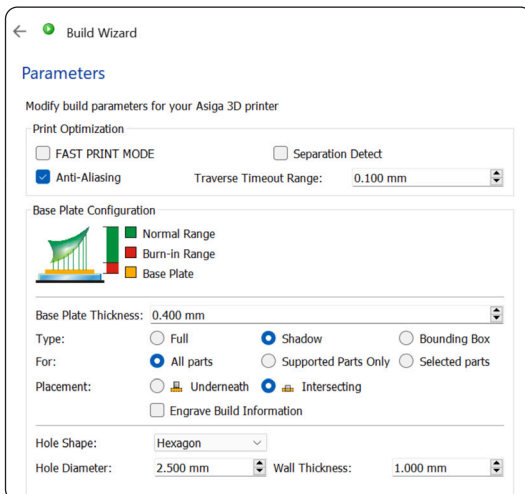


Select **Build** to open **Build Wizard**

In the **Parameters** window, use setting **A** for *Full Arch Implant Cases* or setting **B** for *Denture Teeth*.

Then, click **Next** and **Next** again.

A



Build Wizard

Parameters

Modify build parameters for your Asiga 3D printer

Print Optimization

☐ FAST PRINT MODE ☐ Separation Detect

☒ Anti-Aliasing Traverse Timeout Range: 0.100 mm

Base Plate Configuration

☒ Normal Range ☐ Burn-In Range ☐ Base Plate

Base Plate Thickness: 0.400 mm

Type: ☐ Full ☒ Shadow ☐ Bounding Box

For: ☒ All parts ☐ Supported Parts Only ☐ Selected parts

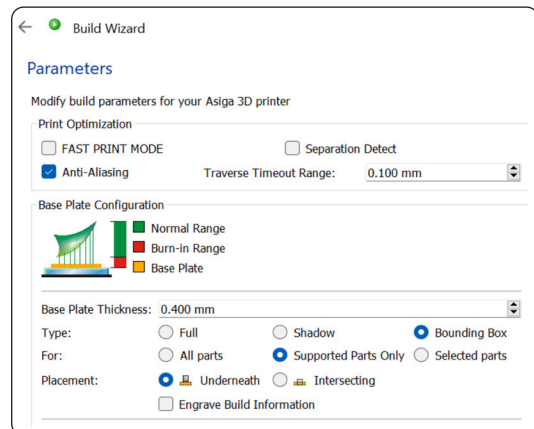
Placement: ☐ Underneath ☒ Intersecting

☐ Engrave Build Information

Hole Shape: Hexagon

Hole Diameter: 2.500 mm Wall Thickness: 1.000 mm

B



Build Wizard

Parameters

Modify build parameters for your Asiga 3D printer

Print Optimization

☐ FAST PRINT MODE ☐ Separation Detect

☒ Anti-Aliasing Traverse Timeout Range: 0.100 mm

Base Plate Configuration

☒ Normal Range ☐ Burn-In Range ☐ Base Plate

Base Plate Thickness: 0.400 mm

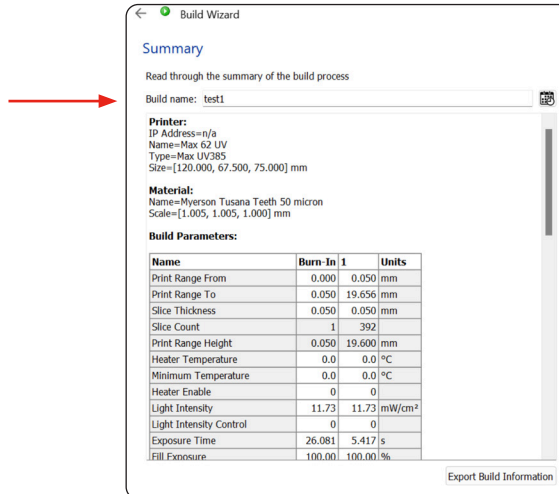
Type: ☐ Full ☐ Shadow ☒ Bounding Box

For: ☐ All parts ☒ Supported Parts Only ☐ Selected parts

Placement: ☒ Underneath ☐ Intersecting

☐ Engrave Build Information

Name the Build, then click **Send Build**



Build Wizard

Summary

Read through the summary of the build process

Build name: test1

Printer:
IP Address=n/a
Name=Max 62 UV
Type=Max UV385
Size=[120.000, 67.500, 75.000] mm

Material:
Name=Myerson Tusana Teeth 50 micron
Scale=[1.005, 1.005, 1.000] mm

Build Parameters:

Name	Burn-In	1	Units
Print Range From	0.000	0.050	mm
Print Range To	0.050	19.656	mm
Slice Thickness	0.050	0.050	mm
Slice Count	1	392	
Print Range Height	0.050	19.600	mm
Heater Temperature	0.0	0.0	°C
Minimum Temperature	0.0	0.0	°C
Heater Enable	0	0	
Light Intensity	11.73	11.73	mW/cm²
Light Intensity Control	0	0	
Exposure Time	26.081	5.417	s
Fill Exposure	100.00	100.00	%

Export Build Information

View slices, and if there are no anomalies, start the print job from the **Printer Web Interface**

