



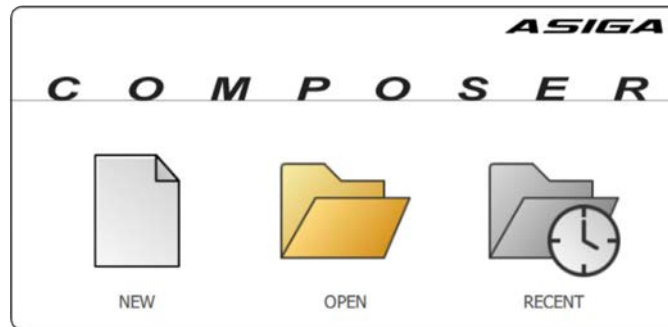
trūsana™

Validated on

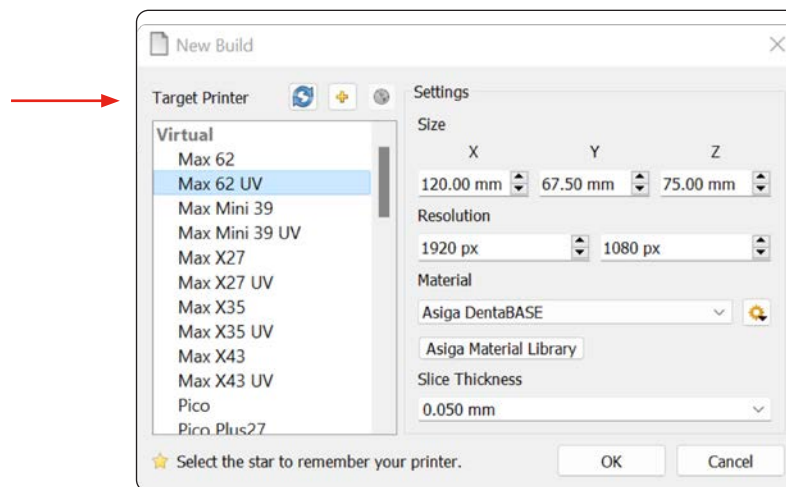
ASIGA

Asiga Composer Validated Workflow

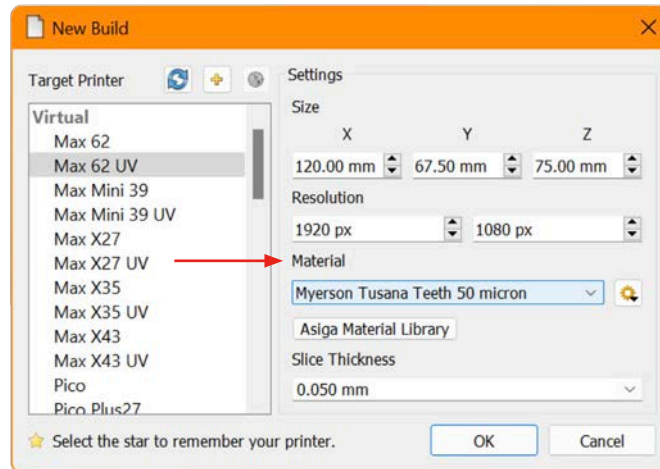
Select **New Build**



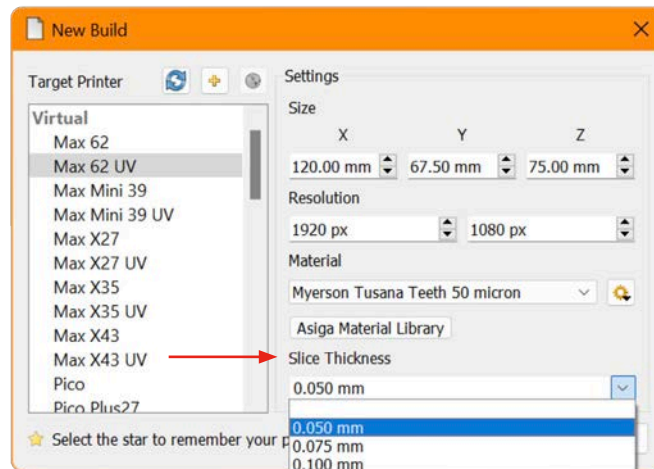
Select your printer in **Target Printer**



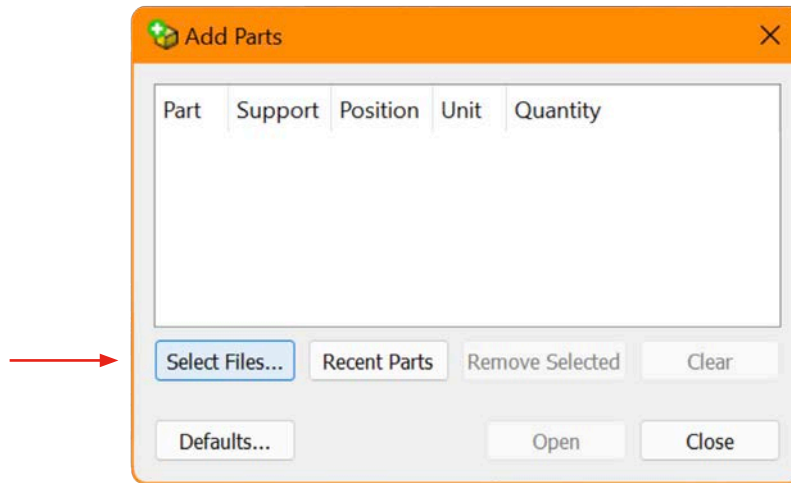
Select **Myerson Trusana Teeth 50 micron** in **Material**



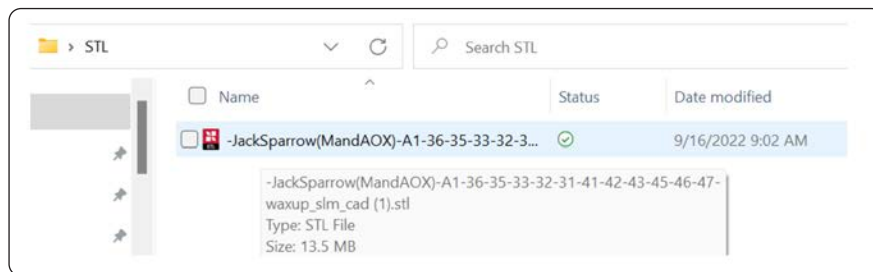
Select **0.050 mm** in **Slice Thickness** and click **OK**



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

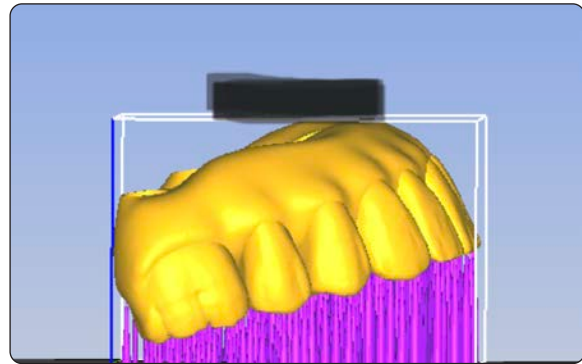
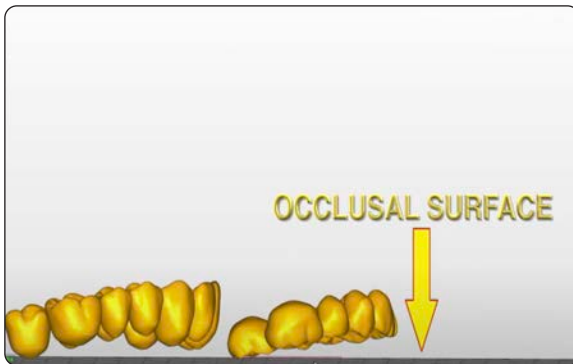


Select your files and click **Open** to import



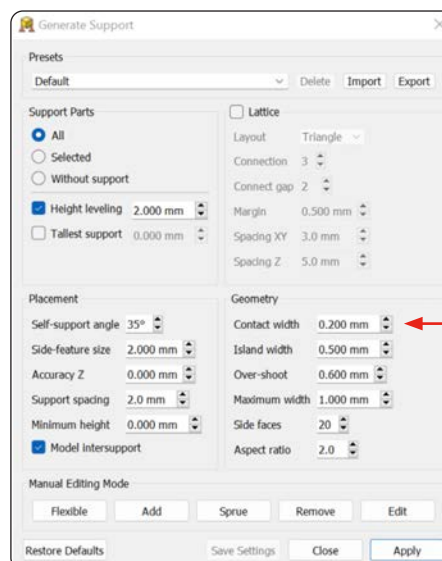
Always have the occlusal surface facing the build plate

- 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.

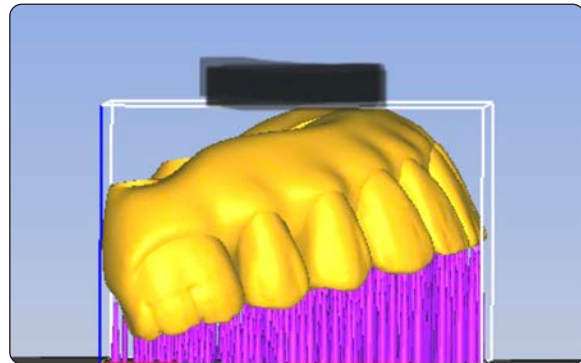
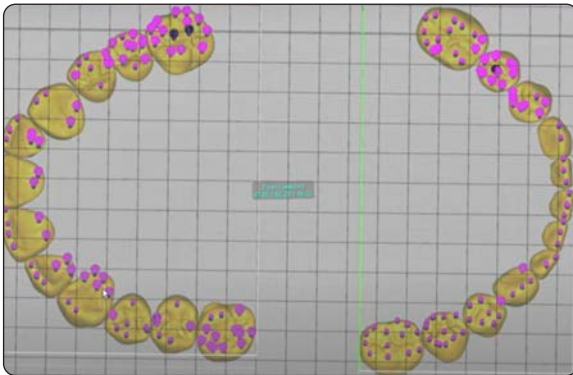


To attach supports, go to **Generate Support**

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



Supports Added

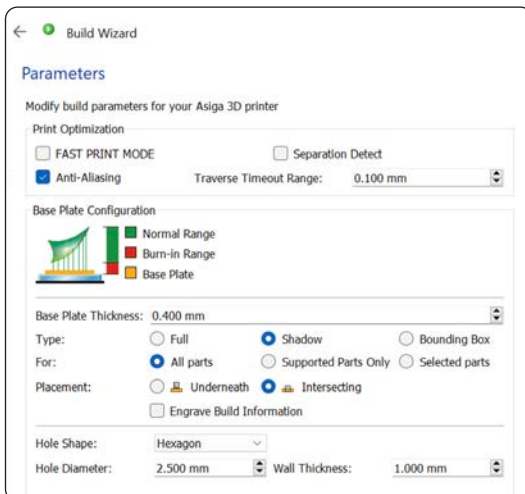


Select **Build** to open **Build Wizard**

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

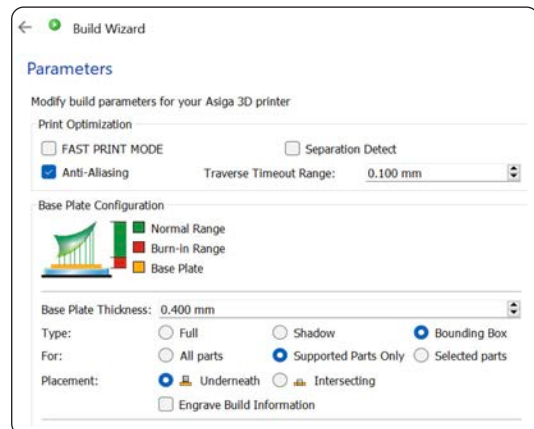
Placement: Underneath Intersecting

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

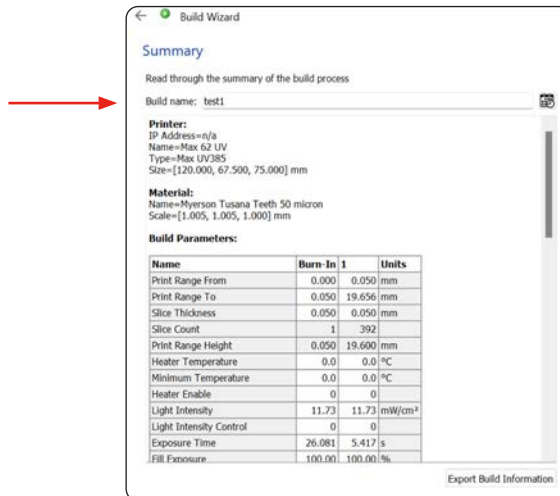
Type: Full Shadow Bounding Box

For: All parts Supported Parts Only Selected parts

Placement: Underneath Intersecting

Engrave Build Information

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



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

