

Tech Tip

Cleaning procedures for preparing parts for USP Class VI applications

Instructions

To clean WaterShed® XC 11122 parts, use the following procedures*

1. **Use only fresh, clean 99% (or better) isopropanol.** Solvent should be contaminant free to assure no residues will be left behind after cleaning.
2. **Soak parts for a minimum of 20 minutes.** This will allow adequate time for the solvent to breakdown the liquid resin surrounding the part.
3. **Use clean towels to scrub any excess resin from the clean parts.** This should be done multiple times to ensure there is no liquid resin remaining on the part.
4. **The parts must be dried.** Use dry, compressed air to blow excess solvent from the surface of the part. Afterwards allow the part to dry in a ventilated area for a minimum of 6 hours. Overnight would be better. This will allow adequate time for the excess solvent to evaporate.
5. **The parts need to be postcured.** The normal postcure time for SLA parts is 30 minutes per side. We recommend 1 hour per side to ensure the part is completely cured. Keep in mind that post cure apparatus lamps need to be in good working and changed every 2000 hours.
6. **Parts should then be inspected to make sure any traces of contaminants are removed.** Then they should be placed in clean, sealable plastic bags for storage and shipping

For technical service questions, please contact:

<http://www.dsmsomos.info/forms/techservice/index.htm>

*DSM Somos testing of SL parts produced under typical parameters and treated as above met the USP Class VI standard. It is the responsibility of the part producer to ensure adequate build, cure and cleaning procedures have met the USP Class VI standard.

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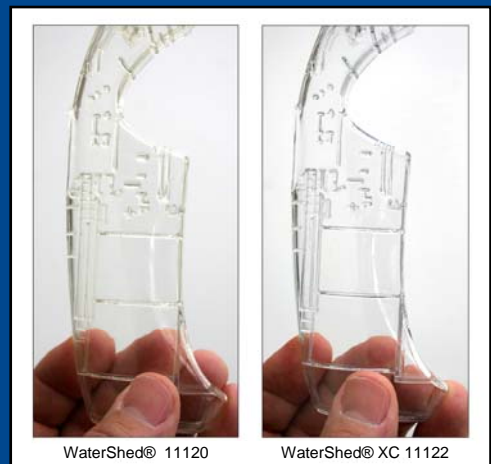


Photo courtesy of Spectrum Plastics™ Group

Steps

- Use fresh IPA
- Soak parts 20 minutes
- Dry with clean towels
- Dry parts further with compressed air
- PCA parts for appropriate time
- Inspect parts to ensure they are clean
- Contact Somos with any problems