



3DSYSTEMS™

3D SYSTEMS CORPORATION
REGULATORY INFORMATION SHEET

VisiJet® Stoneplast Plastic Material

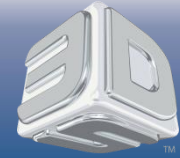
USP Class VI Certification

VisiJet Stoneplast material has met the requirements of USP Class VI testing. Based on these results, 3D Systems expects that similar articles made from this material will meet the compliance requirements of USP Class VI when the produced parts are cleaned using the methods described in the attached Customer Information Bulletin.

It is the responsibility of each customer to independently determine that use of VisiJet Stoneplast material for their specific application is safe, lawful and technically suitable. Customers should conduct their own testing to ensure compliance with any specific requirements. 3D Systems recommends that customers re-verify material suitability for applications requiring USP Class VI compliance no less frequently than every two years from the date of this publication due to potential changes in the law, regulations, material formulation or manufacturing methods.

For additional information about VisiJet Stoneplast material, please contact your local sales representative or Derek Johnson, Director of Product Management at derek.johnson@3dsystems.com.

Dated: June 11, 2012



VisiJet® Stoneplast Material Cleaning Procedure for USP Class VI Applications

ProJet™ 3500 3D Printers

Cleaning for USP Class VI

The following procedure was used by 3D Systems to produce the sample parts for our USP Class VI tests. **Customers must verify their own system, build parameters and cleaning processes produce the desired results prior to use in a particular application requiring USP Class VI compliance.**

Supplies Required:

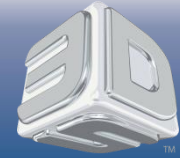
1. Test Parts ready to clean
2. ProJet Finisher Oven or other industrial oven with temperature control
3. 5 clean/ brand new liquid-tight containers of appropriate size for the parts
4. Fresh, clean 99%+ isopropanol (IPA)
5. Absorbent Towels
6. Nitrile Gloves

Procedure:

NOTE: Handle test parts with gloved hands ONLY. Direct contact with test parts could contaminate the samples and invalidate test results.

1. Melt Bulk Support Material

- Remove parts from build platform and place inside ProJet Finisher oven heated to 60 C.
- Leave parts in oven until all the support has melted off the part.
- Take parts out and wrap in absorbent towel. Place back in over for 10 minutes.



2. Remove Residual Support Material

- Fill all 5 containers with enough isopropanol to submerge the parts. Note: Use only fresh, clean 99%+ isopropanol.
- Remove parts from oven and place parts into 1st container of IPA
- Let parts soak in 1st IPA bath for 20 minutes. Periodically wipe parts with a gloved hand to rub residual support material off part.
- Repeat the process in the other four containers but reduce soak time to 5 minutes each. Periodically wipe parts with a gloved hand to rub residual support material off part.

Caution: Use new gloves each time you handle the parts to prevent introducing contaminants onto the test parts.

Caution: The normal process of using corn or mineral oil in an ultrasonic cleaner **SHOULD NOT** be used for testing purposes.

3. Dry the parts.

- Use clean, compressed air to blow excess IPA from the surface of the part.
- Allow the part to dry in a ventilated area overnight (6 hours minimum) on the flat surface. This allows the solvent to evaporate completely.
- Flip the parts often to ensure thorough drying.

5. Inspect the parts.

- a. Verify every surface of the part to ensure no support material or contaminants of any kind are left behind. Re-clean or rebuild and re-clean parts as needed.

6. Package the parts.

- a. Parts should be placed in clean, sealed plastic bags for storage and/or shipment.