

VisiJet® SL Clear cleaning procedure for USP Class VI

ProJet® 6000

Purpose: Information on cleaning procedure used by 3D Systems when producing parts for USP Class VI testing

WARNING: Users must verify their own system, build parameters, and cleaning processes before use in an application requiring USP Class VI compliance.

Cleaning for USP Class VI

Following is the procedure 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 an application requiring USP Class VI compliance.

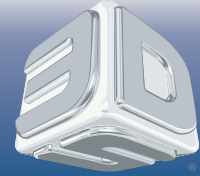
Supplies Required:

1. Parts from the ProJet 6000 system
2. 5 clean/ brand new liquid-tight containers of appropriate size for the parts
3. Fresh, clean 99%+ isopropanol
4. Nitrile gloves
5. A clean flat surface for placing parts
6. ProJet Curing Unit

Procedure:

1. **Fill all 5 containers with enough isopropanol to submerge the parts.**

Note: Use only fresh, clean 99%+ isopropanol.



2. Soak and scrub parts – 5 successive cycles using new container and new IPA each time

- a. Cycle 1: 20 minute soak
 - i. Soak the part for 20 minutes in clean IPA.
 - ii. Scrub the parts with your clean, nitrile-gloved fingers.
- b. Cycle 2 through 5: 5 minute soak
 - i. Soak the part for 5 minutes in clean IPA.
 - ii. Scrub the parts with your clean, gloved fingers
 - iii. Repeat 4 times.

Caution: use new gloves each time you handle the parts!

Caution: if parts have crevices or other geometry requiring brushes or other cleaning tools, make sure no bristles/hairs or other contaminants are left behind. No brushes were used in the cleaning protocol 3D Systems used for the Class VI testing.

3. Dry the parts.

- a. Use clean, compressed air to blow excess solvent from the surface of the part.
- b. 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.

Caution: use new gloves each time you handle the parts!

4. Post-cure the parts.

- a. Make sure the surface in the post curing apparatus is flat and completely clean.
- b. Post cure in your ProJet Curing Unit for 1 hour PER SIDE to ensure the part is completely cured.

Caution: Ensure that the lamps in the curing unit are in proper working order.

5. Inspect the parts.

- a. Verify every surface of the part to ensure no 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.