

Cleaning Method of 3D Printed Parts for Class VI or ISO 10993 Tests

The following instructions apply to the cleaning printed parts after removal of wax support by melting in oven and cleaning with EZ Rinse-C or mineral oil (see online instructions on Post Processing by 3D Systems: [reference new post-processing document at post-processing-guide/VisiJet®-materials](#))

Supplies and Tools Needed

- Ethyl Alcohol (Ethanol) – Anhydrous Reagent HPLC/Spectro from ChemProducts, product code: C-A0445-40. Alternative grades can be (A) Ethanol Anhydrous Denatured Reagents from ChemProducts, Product code: E0285-62; or (B) Pure 190 proof, meeting USP testing specification, from Sigma-Aldrich, catalog # 493538-4L)
- Protective Clothing
- Nitrile Gloves
- 600 mL Glass Beaker



- Sonicator: Yamato 2510 by Branson or similar ultrasonic cleaner with a heated tank operating at 40kHz



- 32 oz. Ethanol Wash Bottle



- Curved Extra Fine Tip Tweezers



- VWR® Reclosable Clear Ziplock Bag (Various sizes)



- Aluminum pan or Similar Tray or Drying Rack

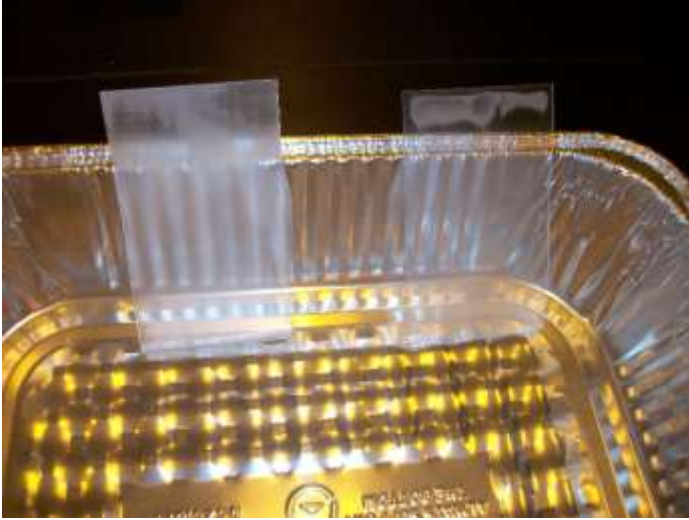


Steps for Cleaning a Part

1. Clean the glass beaker, tweezers, aluminum pan and ziplock bag by rinsing with fresh ethanol.
2. Pour approximately 580 mL ethanol into the cleaned 600 ml glass beaker, and then place it into the tank of the Sonicator. For the first sonication, the ethanol can be either fresh or used to clean similar parts just one time previously.
3. Fill tank of Sonicator to the “operating Level” mark with tap water.
4. Turn on the Sonicator, setting the temperature to 21 °C and the sonication time to 5 min.
5. Place two parts into the ethanol in the cleaned glass beaker and begin sonication for 5 min. at 21 °C. Arrange parts so that they do not touch or shadow one another during sonication.



6. Use the clean tweezers to remove one part from the beaker. Rinse the part with fresh ethanol three times on all sides of the part.
7. Repeat step 5 and step 6 for the other part that has been sonicated.
8. Using fresh ethanol, perform a second sonication following the previous steps 2 through 7, as required.
9. Use clean tweezers to place the parts on edge in a clean aluminum pan or other suitable drying tray or rack and allow to air dry for 15 to 25 minutes.



10. Use clean tweezers to move the parts into a clean ziplock bag and close the bag.

11. Label the bag with part identification number.