

POST-PROCESSING INSTRUCTIONS REQUIRED TO PASS ISO 10993-5 AND ISO 10993-10

MIXING INSTRUCTIONS

This material has a pigment that settles very slowly over time before printing. For best results mix material in the bottle:

1 kg bottle for Figure 4 Standalone

- Roll bottle for 1 hour on 3D Systems LC-3D Mixer for first use
- Roll for 10 minutes before subsequent uses

2.5 kg cartridge for Figure 4 Modular

- Vigorously shake the bottle for 2 minutes before installing cartridge

Use the Resin Mixer to stir material in the tray for 30 seconds between print jobs.

MANUAL CLEANING INSTRUCTIONS

- Manual cleaning with 2 containers of IPA (wash and rinse)
- Clean in 'wash' IPA for 5 minutes while agitating part
- Rinse in 'clean' IPA for 5 minutes while agitating part
 - DO NOT EXCEED more than 10 minutes total exposure to IPA to preserve mechanical properties
- Manual agitation and/or a soft brush can be used to aid cleaning
- Refresh IPA when cleaning becomes ineffective

DRYING INSTRUCTIONS

- Ambient air dry > 1 hour before post cure

UV CURE TIME

- 3D Systems LC-3DPrint Box UV Post-Curing Unit or Figure 4 UV Cure Unit 350 : 90 minutes

More details can be found in the Figure 4 User Guide available at <http://infocenter.3dsystems.com>

Figure 4 Standalone: <http://infocenter.3dsystems.com/figure4standalone/node/1546>

Figure 4 Modular: <http://infocenter.3dsystems.com/figure4modular/node/1741>

