

# Customer Information Bulletin

5/4/2023

Advisory

Safety Alert

**Subject: Accura ClearVue Cleaning Procedure for USP Class VI Compliance**

**SLA 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.**

## Required Supplies

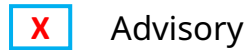
1. Printed parts
2. Five clean or brand-new liquid-tight containers of appropriate size for the parts
3. Fresh, clean 99%+ isopropanol
4. Nitrile gloves
5. A clean flat surface for placing parts
6. PostCure 1050 or comparable curing unit

## Procedure:

1. Fill all five containers with enough isopropanol to submerge parts.

 **NOTE: Use only fresh, clean 99%+ isopropanol (IPA).**

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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. Wearing nitrile gloves, scrub the parts with your fingers.
  - b. Cycles 2-5: 5-minute soak
    - i. Soak the part for five minutes in clean IPA.
    - ii. Wearing nitrile gloves, scrub the parts with your fingers.
    - iii. Perform steps i and ii four 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 compressed, clean, dry air to blow excess solvent from the surface of the part.
  - b. Allow the part to dry in a ventilated area 6-10 hours (depending on geometry) on a flat surface. This allows the solvent to evaporate completely. You may need to flip the part several times throughout the drying process to ensure thorough drying.

**CAUTION: Use new gloves each time you handle the parts!**

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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 PostCure 1050 per the Clearvue material recipe. Or cure in comparable curing unit for one hour PER SIDE to ensure the part is completely cured. Soak the part for five minutes in clean IPA.



**CAUTION: Ensure that the lamps/LEDS in the curing unit are in proper working order.**

5. Inspect the parts: 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: Parts should be placed in clean, sealed, non-reactive plastic bags for storage and/or shipment.