

## ProJet Part Cleaning

TEMPERATURE SETTINGS: make sure all temperatures are stable before starting.

\*Oven: 60C

\*Ultra Sonic Cleaner oil: 50 - 60C

PLACE PART IN OVEN: to melt the wax support. (Average Time: 10 - 60 mins)

\*Check part periodically to monitor progress. Turning the part will help the wax drip out of complex geometry faster. You can also expedite the wax removal by scooping off the soft wax instead of waiting for it to completely liquefy.

\* Leave part in oven until ALL of the wax support material has liquefied.

PUT PART IN THE ULTRA SONIC CLEANER: Do not let the part cool. (Time: 5 mins)

\*Place the part in the Ultra Sonic Cleaner oil. **IMPORTANT:** Be sure to quickly move the part from the Crock Pot to the Ultra Sonic Cleaner to minimize cooling of the part and wax!

\*Turn on the Ultra Sonic Cleaner and set timer for 5 minutes.

\*Remove the part after 5 minutes and allow the oil to drain and the part to air cool.

REMOVE OIL FROM THE PART: (Average Time: 5 minutes)

\*Rinse the part in the sink with warm water and gently rub the part to remove as much oil as possible.

\*Use a brush and a tub of warm water with a generous amount of dish soap (choose a brush depending on the part's geometries) to remove the remaining oil.

\*Brush the part to build up lather, brush every surface of the part.

\*Rinse the part in the sink to remove the soap and oil.

\*Lather and rinse parts a few times.

\*Isopropyl alcohol (IPA) can also be used to remove any wax/oil residue.

DRY THE PART

---

If desired, use adhesives and paint labeled as appropriate for plastics.

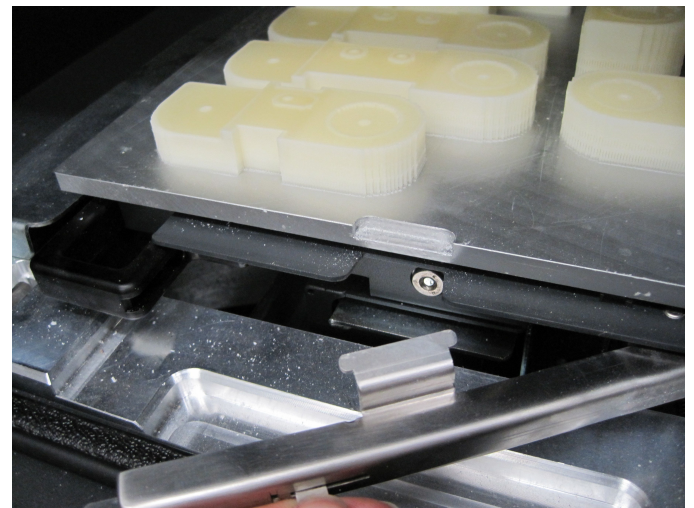
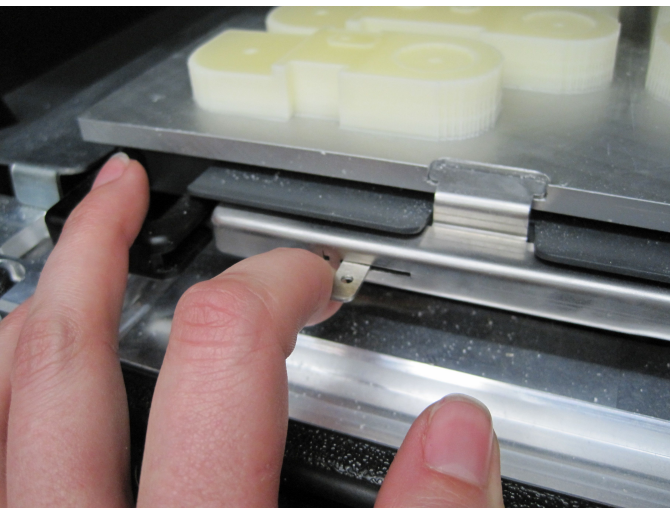
1. Turn on the oven. Flip up both black switches on the left of the large oven (POWER and HEATER). Do not adjust the temperature settings. They are pre-set at 60C.



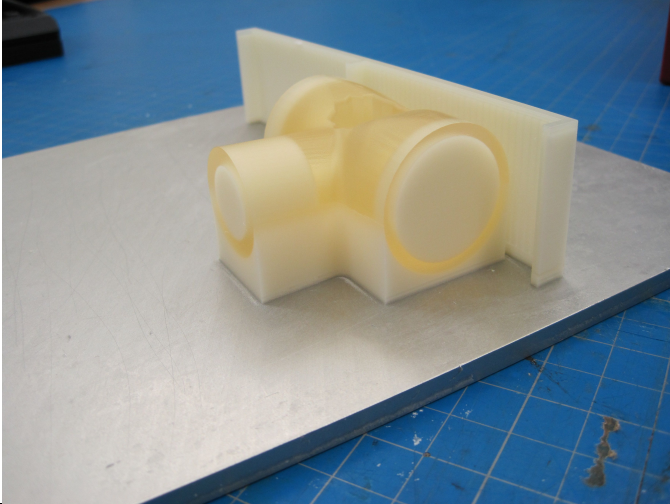
2. Turn on the heater for the ultrasonic cleaner chamber. The switch is on the back of the chamber. The chamber temperature should be set at 50-60C.



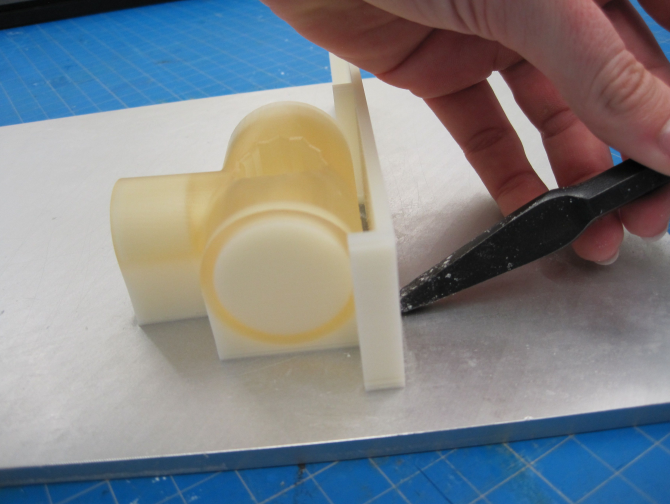
3. Remove the aluminum platform from the ProJet machine. Slide the small lever to the right and allow the latch to swing open.



4. Lay the aluminum platform on a stable table. Get a chisel and wooden mallet.



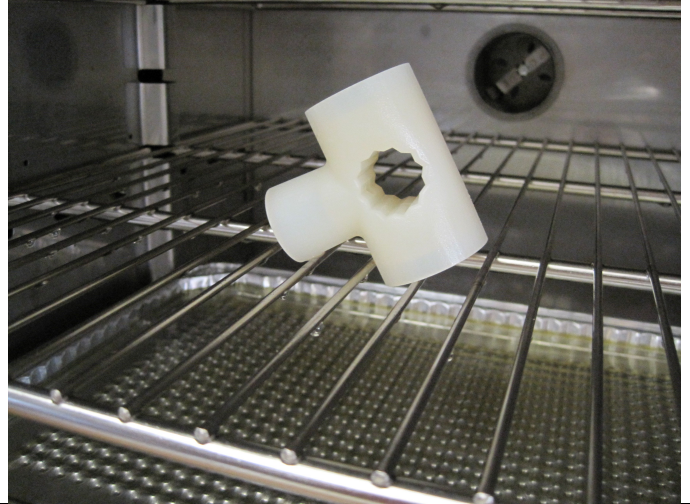
5. Place the chisel at a LOW angle against the base of each part. Tap the chisel GENTLY with the mallet. Some parts may need to be tapped in several locations. Be especially careful with thin and delicate parts.



6. Place the part in the oven. Ensure that the wax-catching tray is in place below your part. The part will sit in the oven for awhile (~10-60 mins, depending on part geometry).



7. As the wax liquefies, you can move the part around to allow the liquid wax to drip off/out of your part.



8. Quickly move the part into the ultrasonic cleaner basket. Use the blue arrows to put 5 mins on the timer, and then press the green Start button.



9. Lift the basket and allow the oil to drip off your part.



10. Begin the soap and water washing process to remove all of the oil from the part.