

Reservoir Cleaning Protocol

To clean the resin reservoir, please follow every step exactly, and use the provided tools, otherwise there is a chance of damaging the reservoir. This protocol is applicable for ALL resin reservoirs



REQUIRED EQUIPMENT

P pro Try-in	P pro Try-in
Resin Reservoir D20 II	RS001185
Resin Reservoir D30 II/ D40 II	RS001199
Rubber Spatula	ZA000579
Sieve	RS001115
Funnel	RS001116
Gloves	RS001322
Microfiber Cloth	RS001119



Before beginning this process, you need to ensure that the area you are using is clean and prepared for this process.

IMPORTANT: Visual inspection of reservoir is recommended before each print.

To ensure that the reservoir is in proper condition for printing, assess the quality of the reservoir surface via visual inspection prior to use: Look for deep scratches, bubbling or tears in the Teflon lamination. If any of these are present, the reservoir surface may be compromised and cause failed prints to occur.

Reuse Life of a Reservoir:

The reuse life of a reservoir is approximately 250 print jobs. This number may vary based on use, care, and handling.

STEP-BY-STEP



1 Pour the remaining material out of the reservoir into the material container holding onto the reservoir handles. By using the sieve and funnel you are filtering the impurities and particles from the remaining liquid resin.



1a With the use of the rubber spatula, guide the resin out of the reservoir into the funnel. Try and remove as much resin as possible from the reservoir and thoroughly clean the spatula before the next step.



2 Apply enough isopropanol (ISP) to cover the reservoir surface, which helps to dissolve the remaining resin.



2a Use the clean spatula to gather the remaining resin and isopropanol mixture in the reservoir. Focus on the reservoir walls and corners to ensure the entire inside surface of the reservoir is cleaned.



2b Carefully pour the resin and isopropanol mixture into a waste container for appropriate disposal. Use the rubber spatula to make this process easier. **Repeat this step until all the resin has been removed from reservoir.**



3 Remove the remaining isopropanol from the reservoir by using compressed air. Be cautious not to hold the air nozzle too close to the surface of the reservoir to prevent any damage to the Teflon coating. (If compressed air is not available, a microfiber cloth can be used. Avoid applying too much pressure with the microfiber cloth to avoid damage or scratches.)



4 Visually inspect the cleaned reservoir by holding it up against a light to ensure the entire surface is clean, dry, and free of scratches and residual resin. If residual resin is identified, repeat steps 2-4

NOTE: If the reservoir appears to be scratched and/or the lamination appears damaged, consider replacing the reservoir.

LIGHT SCRATCHES

Light scratches are almost invisible and do not show a visible deformation. They are caused by sharp materials like sharp papercards or wood-based cleaning tissues in combination with too much application force when being used.

Light scratches can cause visible effects on the surfaces of transparent materials. If there are lots of light scratches, the reservoir might get milky and block portions of the exposure light.

DEEP SCRATCHES

Deep scratches are clearly visible by eye and show a visible deformation of the reservoir ground. They are caused by big fallen parts or too much force when using tools (e.g., silicon mixing tool) inside the reservoir.

Deep scratches can cause minor deviations in dimension that are usually less than 20µm and are therefore not critical

Deep scratches are caused when mixing the material or cleaning the reservoir. Our recommendation is to follow the procedure for missing. If you are unsure about a deep scratch, you can print a straight bar across the deep scratch and assess the surface quality of this bar visually, or by measuring. Use a new reservoir if there is any doubt.

STITCHES

Stitches are small, but deep deformations of the reservoir ground.

Stitches can very seldomly create small holes in the printed part. This only happens if the stitch is large and is visible with the eye.

Stitches are caused when parts break (partially) during the print job (e.g., due to insufficient supports or very thin structures) and are later pressed into the reservoir ground. We therefore recommend to clean the material on a regular basis, especially when taking off a broken print job. If you are unsure whether the stitch creates a hole, then you can print a 2mm thick baseplate in this area (e.g. 20x20mm not full area) and assess if there is a hole visible.



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