

CCW EasyCast HD Cleaning & Post Curing Instructions

Cleaning your printed part(s)

Required Items:

Isopropyl alcohol (IPA) 99% or methyl hydrate and compressed Air

- Step 1. Remove printed parts(s) from build plate.
- Step 2. Submerge part(s) in IPA 99% or Methyl hydrate bath.
- Step 3. Shake vigorously in bath solution for 30 to 40 seconds. Remove and inspect part(s) for residual resin.
- Step 4. If part(s) still have residual resin, repeat step 3 as necessary, until all residue is removed.
- Step 5. Take part(s) and rinse under HOT WATER for about 30-40 seconds and then under COLD WATER.
- Step 6. Use compress air to blow dry part(s). Inspect part(s) for shiny patches. Repeat Step 3 and Step 5 if you see shiny patches. ALL AREAS OF PARTS SHOULD HAVE A MATTE FINISH

*****DO NOT LEAVE PART(S) IN METHYLHYDRATE OR IPA BATH FOR LONG TIMES AS IT MAY CAUSE CRACKS IN THE PART*****

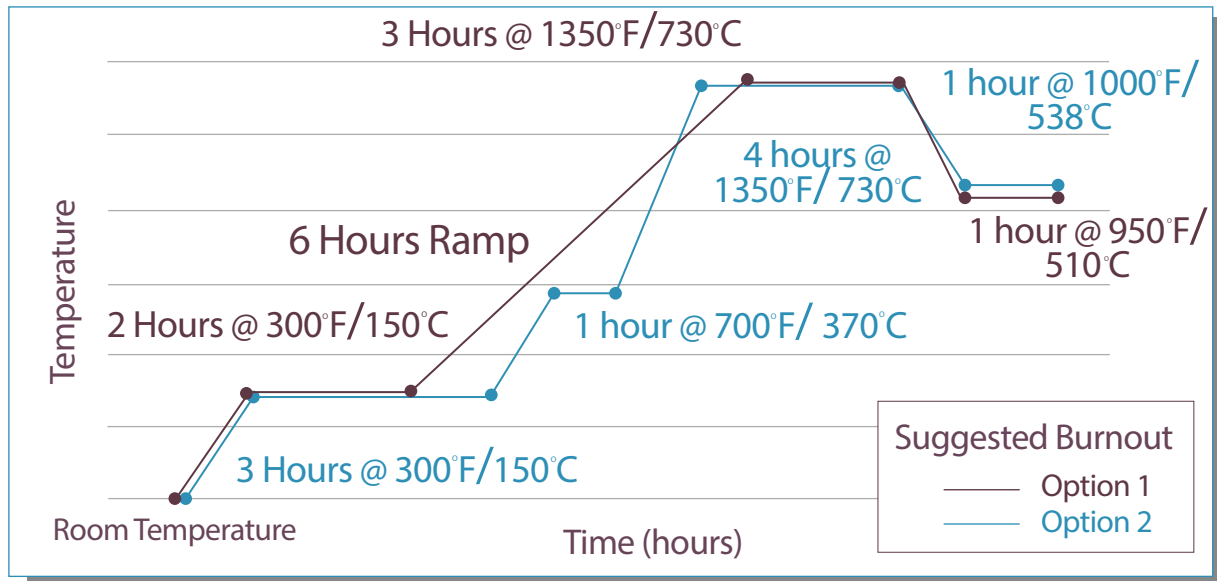
Curing your printed part(s)

Required Items:

Glass Bowl, glycerin and a minimum 60 watt 390-405 UV curing chamber.

- Step 1. Place part(s) in a glass bowl
- Step 2. Fill glass bowl with glycerin covering the printed part(s).
- Step 3. Place bowl of glycerin with printed part(s) in UV curing chamber
- Step 4. Turn on UV chamber for approx. 30 to 40 minutes. Curing times may vary based on type of curing chamber used and part density.
- Step 5. Turn part(s) every 10 minutes so that the UV light can be absorbed by all surface areas.
- Step 6. Part(s) should be extremely rigid and brittle. Squeeze part(s) in a variety of directions to ensure the parts are full cured. If the part(s) are still soft, place back into the UV curing chamber and cure for an additional 10 minutes.
- Step 7. Repeat step 6 to achieve desired stiffness.
- Step 8. Wash part(s) in HOT WATER and then COLD WATER and then use compressed air to completely dry off part(s).
- Step 9. Submerge part(s) in CLEAN IPA for 30 seconds and dry.

Two Recommended Burnout Schedules



*All ramp rates set at 28 F / 2 C per minute

*Burnout schedule based on phosphate investment and verified by Resinworks3D. Exact schedule may vary slightly based on casting equipment used.