

Wax Post-Processing Guide

Support removal

The after-processing guide is the standard guide of removing support material. Please prepare some The actual results may be somewhat different from the following process. Please prepare the items in the next column before the procedure. Also, make sure that the room where the execution is performed is well ventilated or that the ventilation cover is placed.

- Magnetic agitators
- Isopropanol
- Protective glasses
- Beaker
- Dust masks
- Wire mesh basket
- Waterless ethanol
- rubber gloves

1. Place the build plate on the heated platform of the magnetic agitator. Remove the model one by one when the support material is softened.



Note: there are a lot of thin printed objects on the build plate, please start heating from the all around to the center and remove the model carefully.

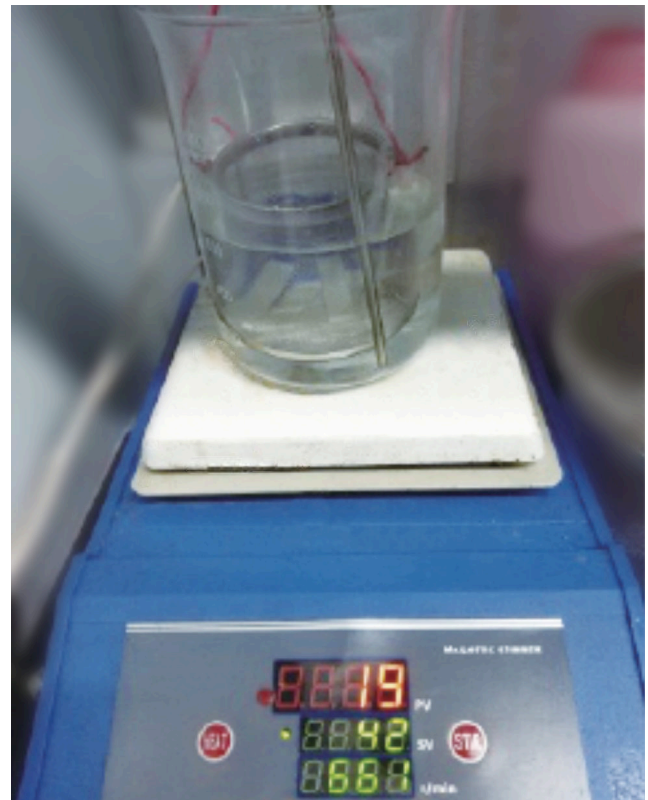


Note: please wear protective glasses, dust masks and rubber gloves before removing the support.

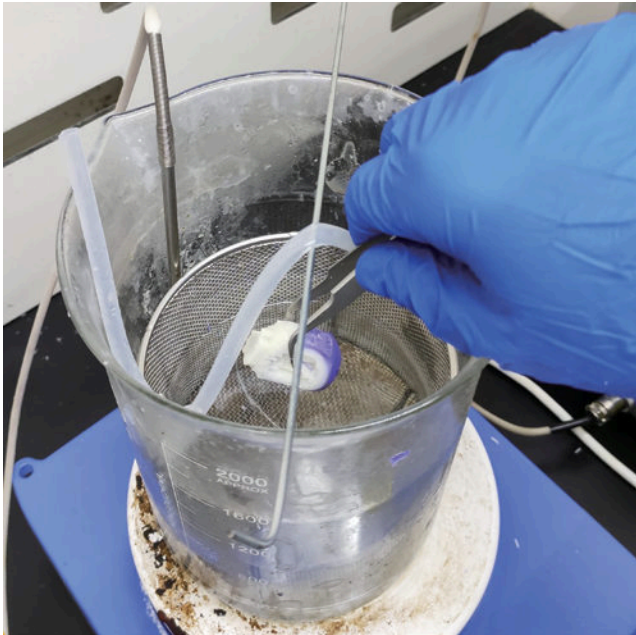
2. Prepare separate 3 baths of 99% isopropl alcohol in 3 separate beakers with a heated magnetic stirrer.

The alcohol temperature in all three baths should be set to 37 degrees Celsius

The first bath is used to remove all of the support material from your models. The second and third baths are used to rinse and clean the models.



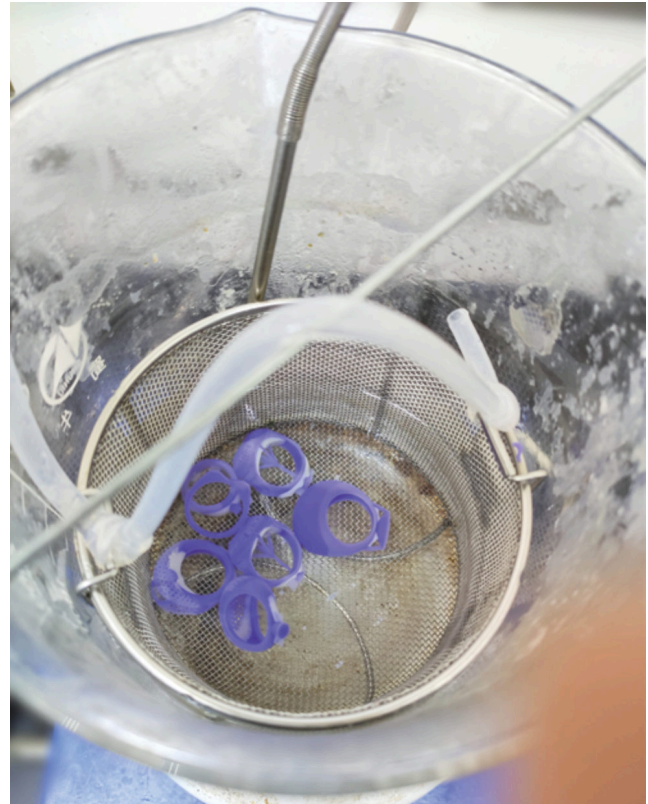
3. Put the models into the mesh basket. Do not put too many models in the basket at once time to avoid collision.



4. Put the mesh basket into the beaker and adjust its height to keep a distance from the stirrer.

5. Turn on the stirring and gradually increase the rotating speed (the fast stirring speed is beneficial to the cleaning), and the speed shall not too fast to shake the models.

6. Check the degree of dissolving of the support material every 1 minute.



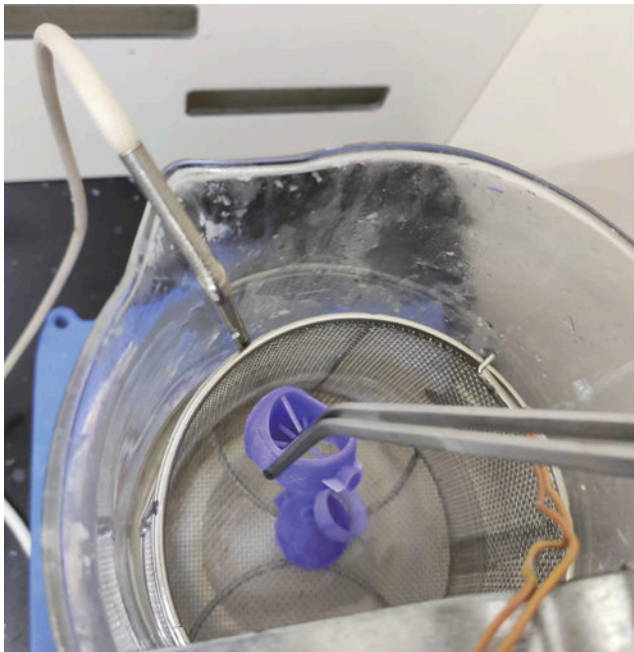
⚠ Note: The dissolving effect of solvents decreases with the increase in the number of uses, will not easily to remove the support materials. It is recommended that no more than 100-120 grams of supporting material dissolved per liter of dissolved solvent.

7. Please take out the models on which the support material has been removed; do not let the models be immersed into the solvent for a long time.

8. Clean the solvent on the surface of the model via dissolved solvent II for 2-10min.



9. Remove the model from the mesh basket in dissolved solvent III for 20 seconds.



Note: The wax objects can be picked up with a thin wire, or it can be picked up with a tweezers wrapped with a hose at the front.

10. The finished models can be dry in the air on absorbent papers or things alike.

Clean up build plate

After each removal of the model, it's necessary to clean up the build plate and plug it back into the printer. Follow these steps to clean up the build plate.

Before proceeding, prepare the following items:

- Magnetic stirrer
- Dust-free paper
- High temperature-resistant gloves.

1. Wear high-temperature gloves.
2. Preheat the build plate with a magnetic stirrer.
3. Wipe with dustless paper after surface residue material is softened.
4. When cleaning the printing platform, make sure that both sides and surroundings of the build plate are cleaned.



Note: The build plate should remain clean before installing and using the build plate. Keep room temperature steady.