

STEP 1: Getting Started

Part Loading: Using a basket or fixture, load parts into the system in a fixture/basket; orientate parts to optimize detergent exposure for challenging geometries.

PostProcess Solution: **SVC DEMI Series**

Recommended Detergent(s): **PLM-403-SUB**

Software Mode: AUTOMATED

STEP 2: Processing Parameters/ Resin Removal

 5-6 min.

Software Mode: AUTOMATED

Temperature: 90°F - 95°F (32°C - 35°C)

Ultrasonics: 100% (AGA 4)

Pump Agitation / Speed: 100% (AGA 4)

STEP 3: Part Rinse

 1-2 min.

Rinse Solvent: IPA

Temperature: 65°F -75°F (18°C - 24°C)

Agitation: Mechanically agitate parts for optimal rinsing

STEP 4: Part Drying Process

Method: Dry parts with compressed air (Recommended) 15 - 30 Seconds. Further air dry until parts are no longer soft and or tacky, 60 minutes.

Optionally - Dry in a forced air oven at 50°C until parts are no longer soft and or tacky 60 minutes.

STEP 5: Part Curing

Method: UV Cure and or Thermal Cure - Follow Manufacturer's Recommendations

* Recommended starting point. Parts may be washed for less time if sufficiently clean

* Adjust cleaning time as necessary for increased number of parts and complex part geometries