



## Usage Guidelines

### Introduction:

Ecoworks cleaning agent is designed to remove support materials from models built using the FDM® process with SR-10 (P400-SR), SR-20, or SR-30 soluble support materials. The cleaning agent is both user- and eco-friendly. No personal protection equipment is required when handling the cleaning agent and disposal of the used solution requires only dilution with clean water to meet generally acceptable world-wide disposal standards\*.

Several factors impact support removal effectiveness and time:

- Agitation/Circulation (varies by tank type and manufacturer).
- Temperature.
- Part Geometry and Amount of Support Material.
- pH Level.
- Time.

Results will vary based on the above factors. Below are recommended guidelines for using Ecoworks.

### Temperature:

**Water temperatures between 70°C and 75°C are most effective** for dissolving support materials. Temperatures above 75°C may cause models to distort. Dissolve times with temperatures below 70°C will take longer.

### Ecoworks Amounts:

To optimize support removal and meet generally acceptable pH levels for waste water disposal, the following amount (number of packages) of Ecoworks should be used:

**One package (foil bag) for every 2 gallons (7.5 liters) of water.** The entire contents of the package (both sides A and B) should be used.

For each additional two gallons (7.5 liters) of water, add an additional package of Ecoworks. For example, an 8 gallon (30 liters) tank requires 4 packages of Ecoworks.

With the above ratio of Ecoworks and water, the pH level of clean solution will be approximately 9.8.

**Solution Life:**

How often you change the solution is dependent on the tank you use, how you maintain it, and the complexity of your parts. As support materials are dissolved over time, the pH level will decrease and dissolve times will increase.

For optimal effectiveness, the **solution should be changed after 1.5 lbs. (0.68 kg) or approximately 40 cu. in. (655 cu. cm) of support material has been dissolved.**

**Solution Disposal\*:**

Waste Water Profiles are available for each of the three soluble support materials – SR-10 (P400-SR), SR-20, and SR-30. These profiles are based on the **dilution of used solution with an equal amount of fresh water.** For example, when disposing of 4 gallons (15 liters) of used solution, dilute with 4 gallons (15 liters) of fresh water.

\*Check your local, state, and/or international regulatory statutes for what pH level is acceptable for disposal. Stratasys recommends that disposal procedures be verified by the proper authorities in your region. Stratasys cannot anticipate local, state, or international regulatory statutes. Stratasys cannot be held liable if the solution is not handled and disposed of properly. You may need to document how you dispose of the used solution.