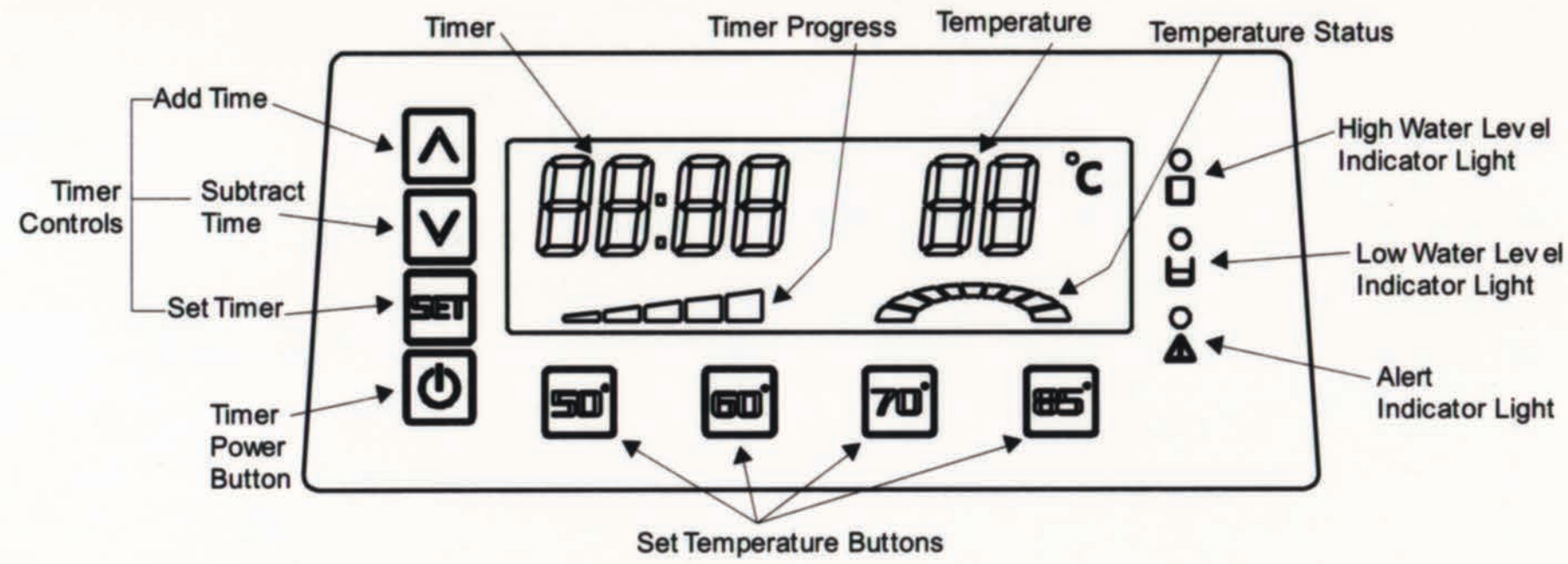


Before you begin, check that the: -SCA is filled with water & cleaning solution* -Power cord is plugged in -Power switch is ON



1

Load Parts

Place your parts into the large basket and close the basket lid.

If your parts are small use the small parts basket and put this into the large basket. This prevents parts from escaping the large basket during cleaning.

IMPORTANT: wear proper gloves and eye protection when working with cleaning solution. The addition of WaterWorks to water is a heat-releasing reaction.

2

Adjust Liquid Level

Slowly lower the basket into the liquid to avoid activating the high level alarm. If the alarm sounds and either of the liquid level lights is illuminated, adjust solution (adding to or subtracting water from tank) until both lights are off and the alarm silences.

IMPORTANT: if an alarm was activated, even if it is cleared by adjusting the liquid level, the power button must be pressed to reactivate the SCA.

3

Select Temperature

Press one of the four temperature presets to select the cleaning temperature.

See opposite page for table of recommended support dissolve temperatures.

The temperature can be changed at any time during the cleaning cycle by selecting a different preset button.

4

Set Timer

Press the power button to activate the timer set buttons. This also starts the SCA pump and heater if remaining time >0. Set the timer by first pressing the SET button and then pressing the up and down arrows to increase and decrease the number of minutes. Press the SET button again and set the number of hours using the same up and down arrows. Press the SET button again to accept the time.

5

Begin Cleaning Cycle

When the timer is set and a temperature selected, the pump and heater are engaged. The system is now fully powered ON. Illuminated bars will sweep from left to right under the temperature display until the tank water has reached the set temperature. The timer countdown is indicated by illuminated bars just below the time display. The number of lit bars decreases as time elapses.

Recommended Temperature Settings for Dissolving Soluble Support from FDM 3D Printed Parts			
Build Material	Temperature Setting	WaterWorks	EcoWorks
ABS	70°C	Yes	Yes
PC	85°C	Yes	No
Nylon	50,60 or 70°C**	Yes	Yes

** depending on part wall thickness and desired dimensional accuracy.

What cleaning solutions are used in the SCA?

The SCA tank is filled with water and a sodium hydroxide-based cleaning solution (WaterWorks) or an eco-friendly cleaning solution (EcoWorks). For fastest soluble support removal use WaterWorks; for gentler cleaning, use the EcoWorks cleaning solution. Both cleaning solutions are provided by Stratasys through their reseller network. Use only these Stratasys developed cleaning solutions in the SCA tank.

How much of the cleaning solution do I need to use?

The SCA-1200HT has a 12 gallon (46 liter) tank capacity. Use one

bottle (950g) of WaterWorks cleaning solution for each 11 gallons (41.6 liters) of water. A single bottle is sufficient for the SCA-1200HT. Use 1 package (foil bag) of EcoWorks cleaning solution for each 2 gallons (7.5 liters) of water. A single package consists of both sides A and B. The SCA-1200HT requires 6 packages of EcoWorks.

Can I fill the SCA tank with hot water to speed the heating time?

Cool (not hot) water should be used to fill the tank. The addition of WaterWorks to water is a heat-releasing reaction and if added to HOT water will result in dangerous spattering.

How long will it take to remove the support material from my 3D printed parts?

Removal time is highly variable and depends on part geometry, part size, cleaning solution used, pH of cleaning solution, and material type. Until some experience is gained, estimate four to five hours. Parts can be checked during the cleaning cycle and removed from the SCA if support is dissolved before the end of the set time.

How do I know when it is time to change the cleaning solution in my SCA?

Any of the following may indicate it is time to change the cleaning solution in the SCA:

- It seems to take longer to clean parts indicating the cleaning solution is saturated with dissolved support material and is losing effectiveness.
- The pH of the WaterWorks solution is < 11.5, or the pH of the EcoWorks solution is < 8.5. A fresh batch of WaterWorks

cleaning solution should be 12.6 – 13 pH, and a fresh batch of EcoWorks solution should be around 9.8 pH.

- The solution has a strong odor.

When can I open the lid if the SCA is in a cleaning cycle?

The lid can be opened at any time during a cleaning cycle. Use the same precautions whenever you may come in contact with the cleaning solution, i.e. wear rubber heat-resistant gloves and eye protection. The SCA will continue operating with the lid open until the cycle is complete or you press the power button.

What size hose do I need to drain the SCA?

A 1 in/25.4 mm ID hose will fit over the drain tube on the front of the SCA. Make sure to use a hose that can withstand the warm, caustic liquid being drained from the SCA tank. Always let the cleaning solution cool to 30°C or below before draining.