

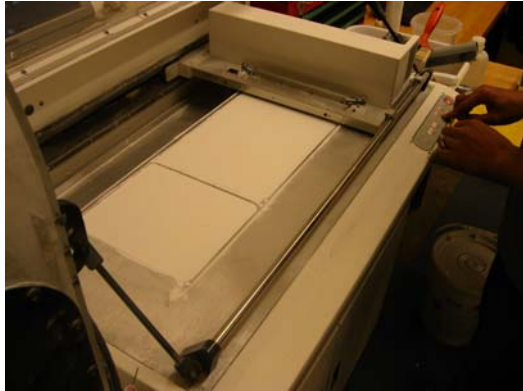
# ZCorp 3 D Printer

Instructions

Wednesday, February 18, 2004

## Process of removing a model from the ZCORP 3D Printer

Step 1 – Lifting build tray



Step 2 – Model Removal Tools



Step 3 – Use brushes to find top of model



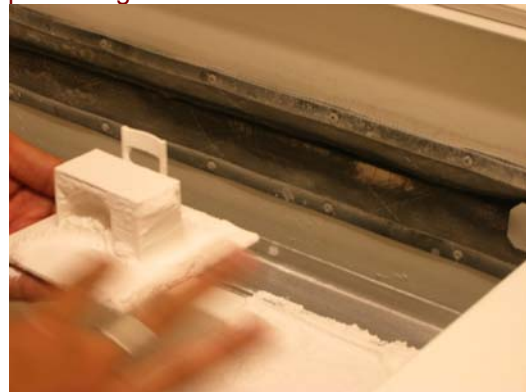
Step 4 – Lightly brush from the build to the feed



Step 5 – Use squeegee to remove large areas of plaster



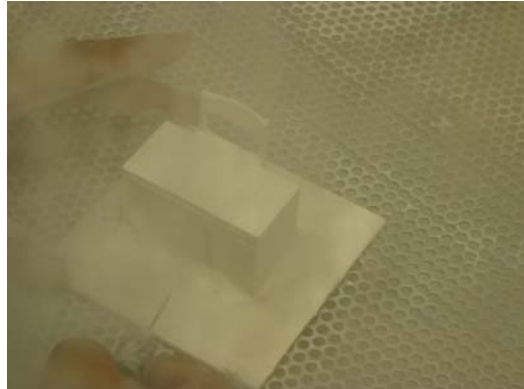
Step 6 – Take model from printer to de-powdering machine



Step 7 – Remove large areas of plaster in the de-powdering box.



Step 8 – Never completely clean model



Step 9 – Place model in oven for drying



Step 10 – Let dry for 30-60 min then de-powder again



Step 11 – Dip model in wax after de-powder let dry on shelf for 1 hour



Step 12 – Reset machine, place powder from over flow into the feed



Step 13 – Two scoops of plaster then pack with scoop “make sure the build is all the way up



Step 14 – Return overflow



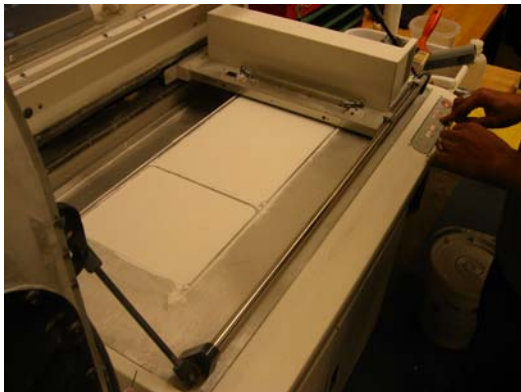
Step 15 – Pack powder with mesh tool



Step 16 – Vacuum the entire machine and floor



Step 17 – Set surfaces for feed and build.  
\* The build must be at the top (Empty)



Step 18 – Vacuum computers and table for dust

