

## Standard Operating Procedure for the Support Cleaning Apparatus (SCA 1200 HT)



Hot Surface,  
Do Not Touch  
GB/T 5465.2-5041



General Warning  
ISO 7000



Danger Electricity

## 4: Safety Warnings



### READ ALL INSTRUCTIONS BEFORE OPERATING



#### WHAT TO DO

- Always wear thermal gloves and safety glasses when working near the unit or when touching any part of the unit.
- Always keep this manual near the unit.
- Always place unit on a flat, stable surface.
- Always wipe away any cleaning solution spilled near the control panel.
- Always locate the unit away from locations where it might be bumped.
- Always unplug the unit from the wall when not in regular use.
- Always use the power cord supplied by the manufacturer.
- Always make sure that the power plug receptacle is easily accessible.
- Always unplug the unit from the wall when it is being cleaned, moved or serviced in any way.
- Always connect the device to a power receptacle with a protective ground.
- Always change the cleaning solution as recommended in this manual.
- Always clean the unit with mild soap and a sponge or rag. Rinse tank completely before refilling.
- Always stand upright with your head away from the tank when opening the lid to avoid vapors.
- Always remove some liquid from the tank before adding large parts to avoid overflow.
- Always operate the unit in a well-ventilated location.
- Always operate within environmental temperature range of 10 to 30 degree C.

#### WHAT NOT TO DO

- Do not use the SCA for any purpose other than removing Soluble Support Technology (SST) material from parts created on Stratasys 3D Printers.
- Do not allow aluminum, zinc or acids to come into contact with the WaterWorks cleaning solution. WaterWorks cleaning solution contains Sodium Hydroxide.
- Do not use any liquid other than water and Stratasys cleaning solution products in the unit.
- Do not add more than the recommended amount of cleaning solution to the unit.
- Do not overfill the unit.
- Do not allow the fluid temperature to exceed 85°C (185°F).
- Do not clean the unit with solvents.
- Do not immerse the unit in liquid of any kind.
- Do not operate the device if there are *any* doubts regarding safe operation due to the outer appearance (e.g. damages) of the system or the operating environment.
- Do not operate the unit until you have read this manual and understand all aspects of the unit's operation.
- Do not move the unit until you are certain that it is cool and all liquid has been drained from the unit.
- Do not operate the unit unless the water level is above the low liquid level indicator mark.
- Do not operate the unit dry.

## 6: PLUG IN UNIT

Select the appropriate power cord, either 110V or 220V. Securely plug the supplied power cord into the receptacle on the side of the unit and then into a grounded power outlet. A GFCI outlet is highly recommended. The plug is a disconnecting device and should be easily accessible at all times. Only use a power cord provided by the manufacturer.

## 7: SWITCH UNIT ON

Press the ON/OFF rocker switch on the side of the unit just above the power plug.

## 8: FOLLOW INDICATOR LIGHTS

If any of the liquid level lights are illuminated, continue to adjust solution (adding to or subtracting water from inner tank) until both lights are off.

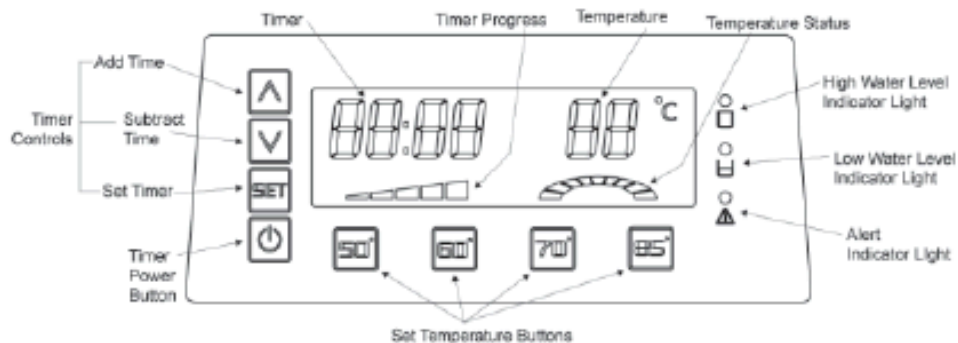
## 9: CLOSE TANK LID ON UNIT


For safety and efficiency reasons, it is important to leave the lid closed on the unit when it is operating.

## 10: SET TEMPERATURE

Select the desired temperature by pressing one of the preset temperature buttons, 50°C, 60°C, 70° or 85°C. This can be done either before or after setting the time. Use 70° (ABS parts) or 85°C (PC parts) for optimal cleaning.

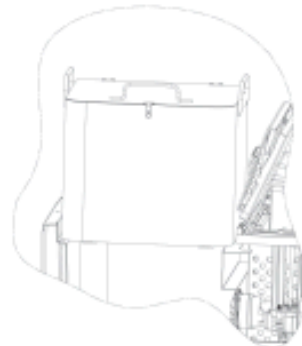
## 11: SET COUNTDOWN TIMER



Press the  button to activate the timer set buttons. Set the timer, the left side of the display control panel, 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 complete the timer setting.

## 12: START SUPPORT REMOVAL

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



### 13: REMOVE PARTS

Use Caution when opening the lid as hot vapors rise from the cleaning solution.

When cleaning is complete, remove the parts by putting on protective gloves, opening the lid, and SLOWLY lifting the basket up while tilting it toward the back to drain out most of the liquid. To drain further, turn the basket 90° and rest it on the rear support bracket and front tank ledge.

Never place your face near the tank when opening the lid as vapors from the cleaning solution may cause eye and respiratory irritation.

Let the liquid drain off of the parts for a few minutes then remove them, wash off any remaining liquid, and dry them with a clean towel or paper towels.

### 14: TURN OFF UNIT

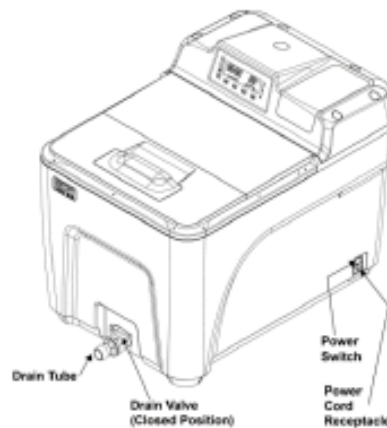
To turn off the unit, press the ON/OFF rocker switch on the side of the unit.

If draining the tank, leave the power ON to indicate the solution temperature.

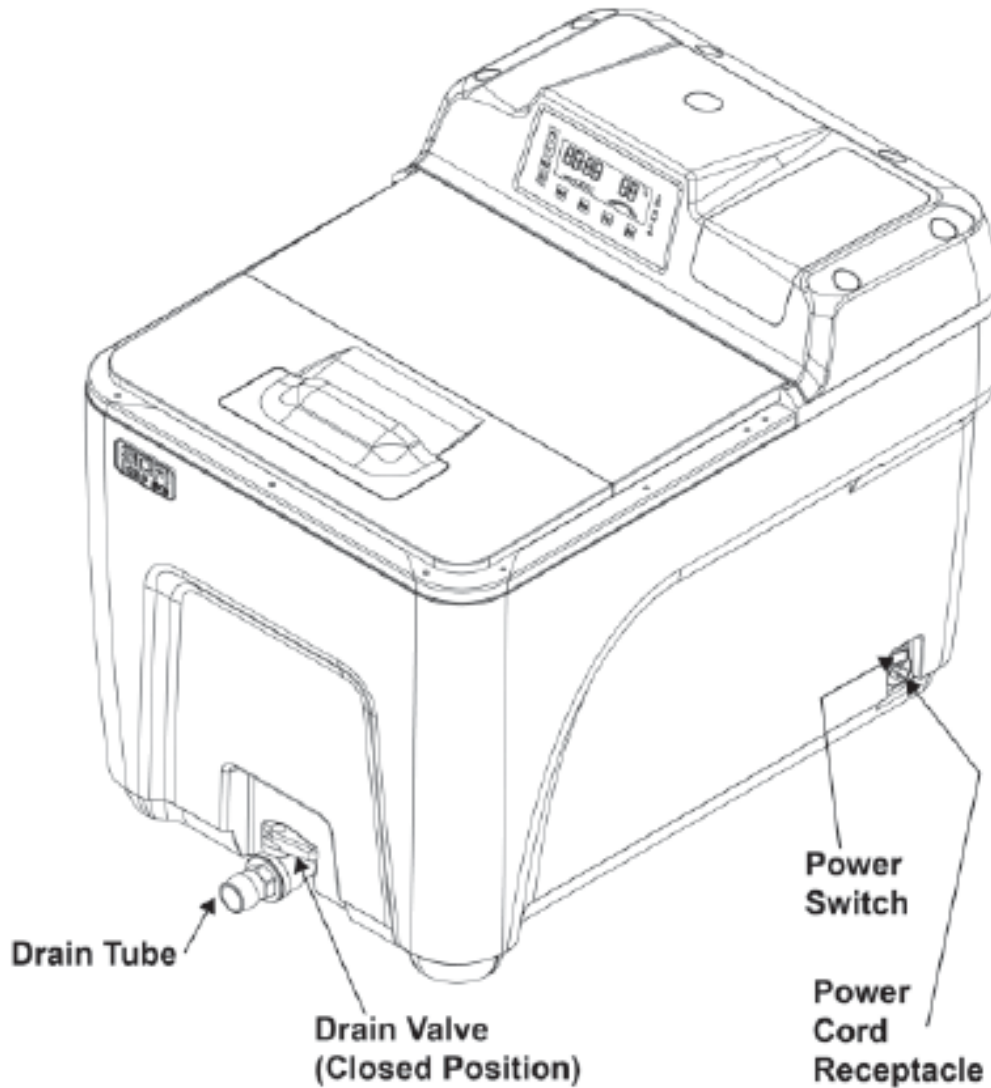
Once it has reached 30°C the system can be drained safely.

### 15: DRAIN UNIT

Verify the solution has cooled to 30°C or lower, and unplug the unit. To drain the unit, attach a hose to the end of the drain tube. Place the other end of the hose in a drain or in a stainless steel or plastic container. Turn the drain valve to the open position. Make sure it is in the closed position when you are done.



Note: a 1" inner diameter piece of PVC tubing or equivalent will fit over the drain tube. Ensure the tubing or hose is durable enough to withstand the temperature and caustic properties of the cleaning solution.



**Warning:**  
Proper PPE must be worn when  
loading/unloading parts from the SCA.

PPE: gloves, face shield, apron.