



# Form Wash and Form Cure Station Maintenance

Learn how to swap the IPA in the Form Wash and clean both the wash and cure stations.

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## Introduction

In this guide, you will learn how to check and swap the IPA in the wash station with a Hydrometer and a Siphon Pump. You will also learn how to clean and maintain the wash and cure station.

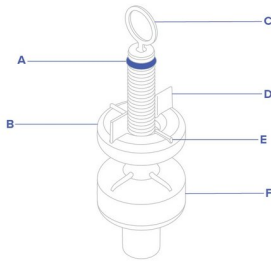
**Images by:** TW, Formlabs



### TOOLS:

- [Hydrometer](#) (1)
  - [Siphon Pump](#) (1)
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## Step 1 — Measuring the Resin Concentration of IPA Pt. 1



⚠ Before starting, put on gloves to protect you skin from any resin

- The Resin concentration should be assessed on a monthly basis
- The hydrometer located in the Form Wash's storage unit is used for checking the concentration of the IPA
- To calibrate the hydrometer, have it float in a pure IPA bath.
- The red O-ring should be level with the short wings of the hydrometer
- If the red ring is above the tall wings, then the IPA needs to be changed

## Step 2 — Measuring the Resin Concentration of IPA Pt. 2

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- After calibrating the hydrometer, place it in the Form Wash bath
- ① If the O-ring is above the hydrometer's tall wings, the IPA needs to be replaced.

## Step 3 — Draining Wash Bucket Pt. 1

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- To replace the Form Wash's IPA, you will need a siphon, located in a box on the top shelf above the Formlabs Form 2
- Two empty IPA jugs, which can usually be found in the clean room
- You will also need enough fresh IPA to refill between the min and max fill lines of the wash bucket.
- Raise the platform mount.
- ☒ To isolate the wash bucket from the Form Wash, please watch the video carefully. Once extracted bring the wash bucket to a Chem table in the lab. Lastly, remove the inner lid and set it to the side.

## Step 4 — Draining Wash Bucket Pt. 2



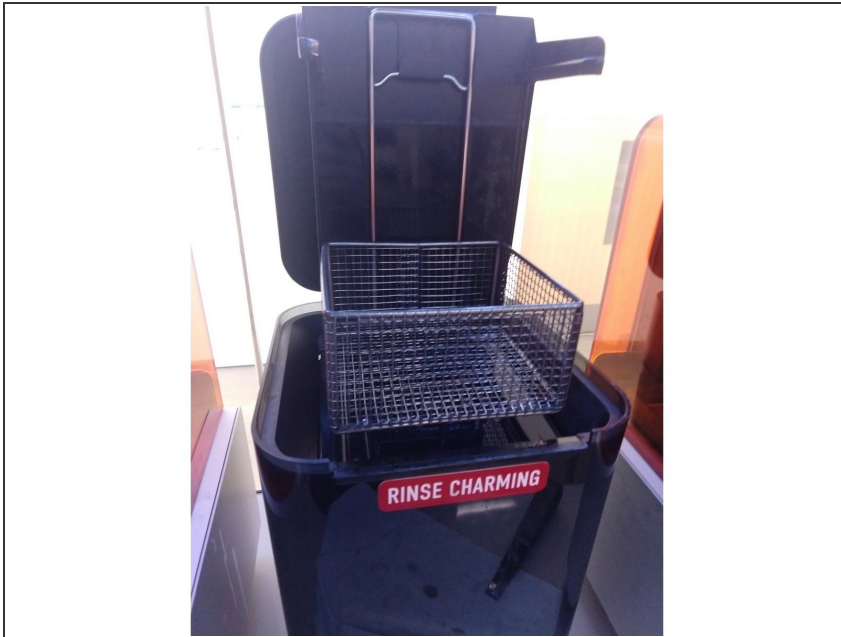
ⓘ Before using the siphon pump, be sure to place an empty IPA jug on a stool so that the wash bucket is elevated above it.

- Place the rigid end of the siphon into the wash bucket and the flexible tube into the empty jug.
- Squeeze the pump's handle until IPA begins to flow freely into the jug. Once it is flowing freely you can prop up the siphon pump and let physics do the rest.

⚠ The wash bucket contains more IPA than one jug can hold. Monitor the IPA level in the jug and remove the **RIGID** end of the siphon **BEFORE** the jug is (amount) full.

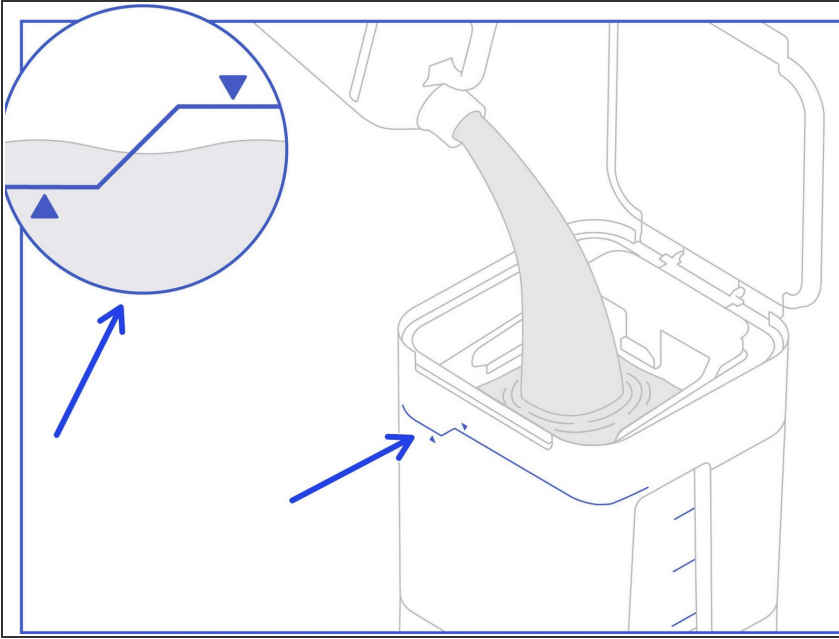
- After having removed the rigid end, remove the flexible hose from the jug and cap it. Repeat the above steps with the second jug, allowing the bucket to drain the rest of the way.

## Step 5 — Cleaning the Form Wash



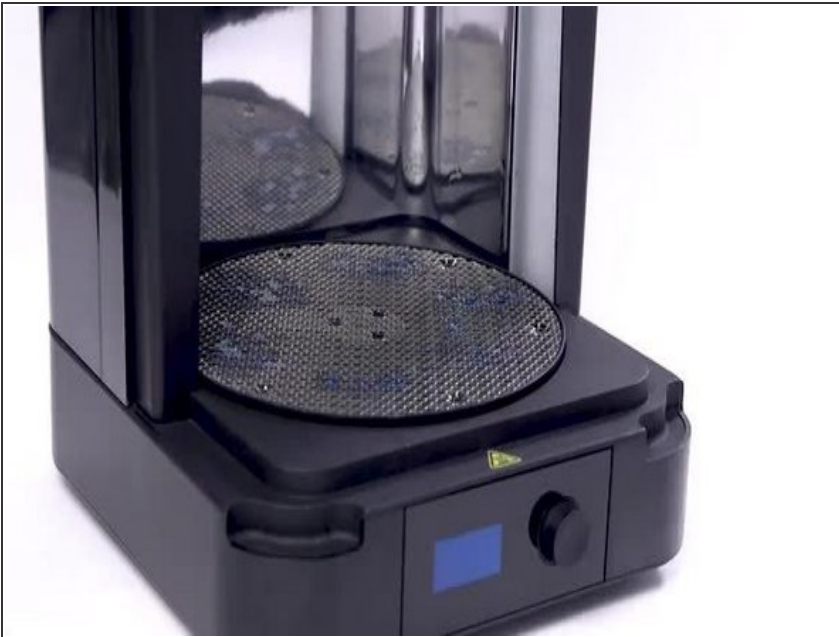
- With the wash bucket now drained, all Form Wash surfaces should be wiped down thoroughly and allowed to dry.
- Wipe down outer surfaces with a microfiber cloth and IPA.
  - ⚠ Be **EXTREMELY** cautious to avoid getting any IPA on the Formlabs printers if they are nearby, as the orange covers will crack with exposure to IPA.
  - ⚠ **DO NOT** use a paper towels as it may scratch surfaces.
- The wash bucket should be rinsed with IPA and then can be wiped down with a paper towel.

## Step 6 — Filling the Wash Bucket



- After the Form Wash has been cleaned, the wash bucket can be refilled.
- Fill the bucket with fresh IPA until the IPA level is between the min and max fill lines.
- Replace the inner lid and wash bucket in the reverse order to which you removed them.

## Step 7 — Cleaning the Form Cure



- The Form Cure should be cleaned on a monthly basis.
  - IPA can be used on all internal surfaces.
  - ☑ Be sure to lift the turntable to clean off any cured resin on or beneath it.
  - Use a microfiber cloth and warm water on the outer lid.
- ⚠ DO NOT use a paper towels as it may scratch surfaces.

For more information, see: [\[1\]](#) [\[2\]](#) [\[3\]](#) [\[4\]](#)