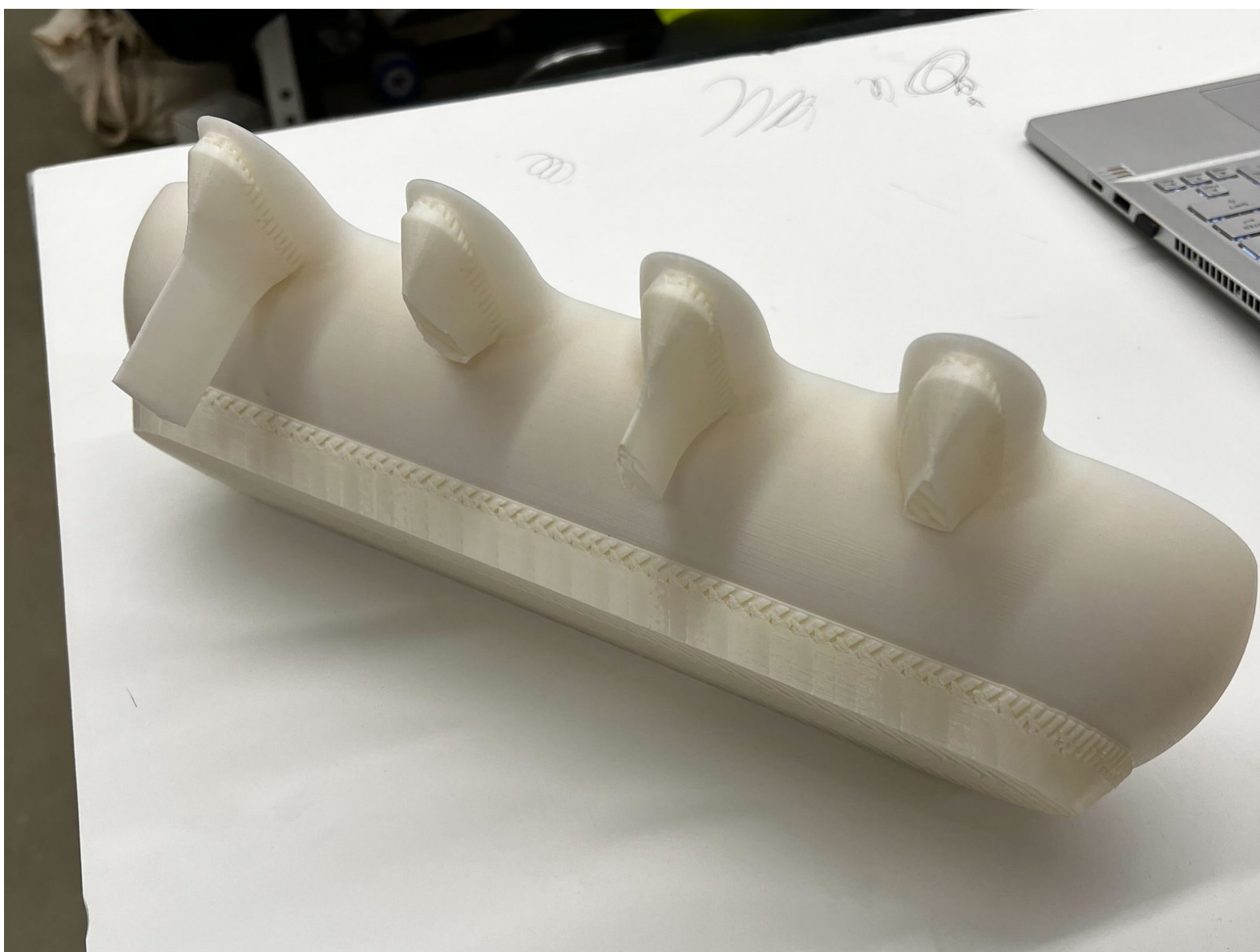




Fortus 400mc: Soluble Support Harvesting

Harvesting and support removal procedures for parts printed on the Fortus with soluble support material

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Introduction

Many Stratasys FDM materials can be used with Soluble Release support materials (SR20, SR30, etc.). These support structures can be dissolved using WaterWorks solvent and an agitation tank.

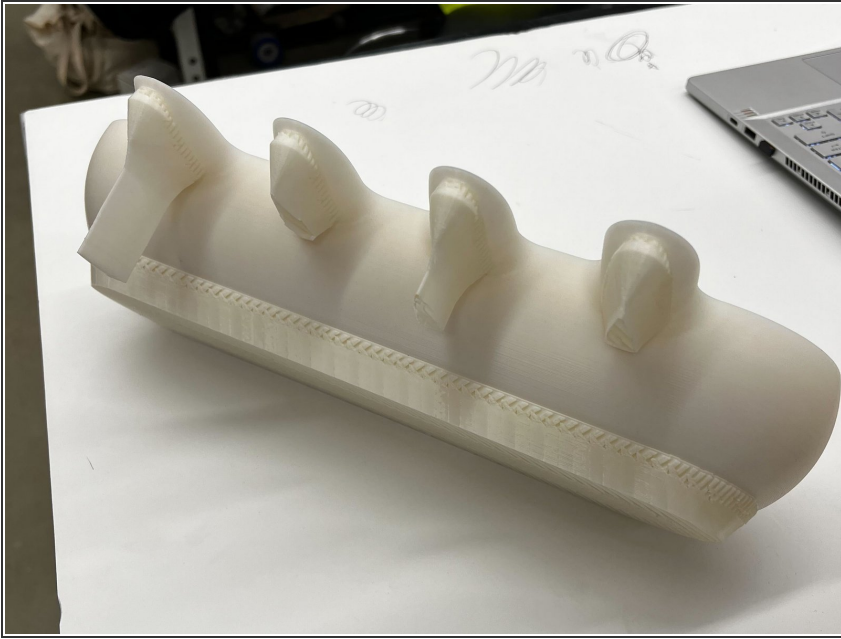
This guide provides instructions for safely and effectively harvesting parts that use soluble supports.



TOOLS:

- [BuildTak Spatula](#) (1)
 - [Heat Gloves](#) (1)
 - [Arm-length Rubber Gloves](#) (1)
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Step 1 — Separate Part(s) from Build Sheet



- While wearing gloves, remove the build sheet from the printer and lay it on your workstation

⚠ The build sheet and all parts will be hot. Gloves are required

- Use your hands and/or the BuildTak spatula to separate each part from the build sheet
- Each part will have a raft made of model material with a thin layer of support material separating raft from part. This support layer is the weak point that you should try to separate
- If there is easily-removable support material, you can remove it using tools so that less solvent is used.

Step 2 — Prepare CleanStation



- Fill the CleanStation CSII and add the WaterWorks Soluble Concentrate to the bath
- Refer to [this guide](#) for detailed instructions on using the CleanStation

Step 3 — Dissolve Supports



- Place the parts in the CleanStation basket, close and latch the lid, and start the cleaning cycle
- ⚠ Use the included arm-length rubber gloves whenever you reach into the solvent bath
- If necessary, repeat the cleaning cycle until all support material has been dissolved. If you so choose, you can remove small stubborn pieces of support material by hand
- Again, refer to [this guide](#) for instructions on using the CleanStation

Step 4 — Clean and Dry Parts



- With the basket lid latched and the tank lid in the locked upright position, you can lift the basket up and hang it from the tank lid for easier part removal
- ⚠ Use the included arm-length rubber gloves whenever you reach into the solvent bath
- Remove the parts from the basket and rinse them thoroughly with water, then dry the parts completely
- ⓘ If the parts were printed with a non-solid infill pattern, they can absorb some of the WaterWorks solution. Allow parts to sit out and drain, then rinse with water again