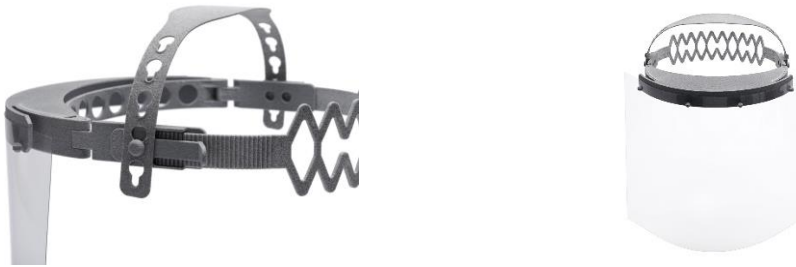


3D PRINTABLE FACE SHIELD

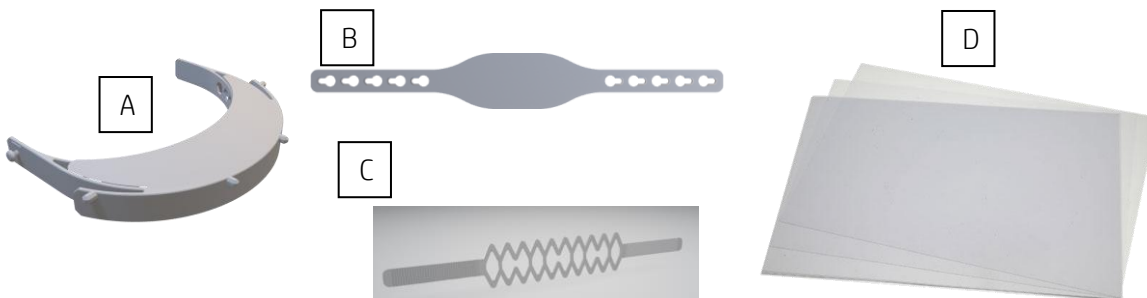


Assembly Instructions and Operating Conditions



Bill of Materials

- 3x HP Multi Jet Fusion parts
 - Structure with 1x HP MJF part printed in HP 3D High Reusability PA12 [*A in the image below*]
 - 1x string printed in HP 3D High Reusability PA12 [*B*]
 - 1x string printed in HP 3D High Reusability PA12 [*C*]
- 1x acetate sheet of approximately 0.2mm thickness and A4 size [*D*]



Tools

- HP Jet Fusion 5200 or 4200 3D Printing Solution
- Standard office hole punch (shown on the right)
- Vinyl Gloves (use them through the whole process)



Assembly Instructions

0. Use the hole punch to make the holes in the acetate sheet. Normally you can use a standard office hole punch as shown above. Make the holes at approximately at 38mm/1.5in from each of the short edges of the A4 acetate.

For better accuracy, use the template provided below. Try first with one sheet. **Once validated and properly assembled, repeat with the rest of sheets to prepare them for assembly.**

Ordered lists of steps:

1. Take part B and attach it to part A through the pins on the sides, perpendicular to it.

This will help the face shield to stay in place without falling.



2. Insert part C into the openings at the ends of Part A



3. Attach the acetate sheet to the front of Part A by placing pins through the holes.



Operating Conditions

In order to clean/sterilize this device, **autoclave cannot be used**; it is recommended to sterilize using a formaldehyde solution.

Another method that has been used to sterilize the product is by **submerging it in a dissolution of bleach in water**. The specifics used are: a pill of Sodium Dichloroisocyanurate (81%) dissolved in 8 liters of water. The product was submerged for 5 minutes and then dried.

Acetate - Hole Template for A4 sized sheets.

Slightly different sizes should be ok as long as the distance between the holes is kept.

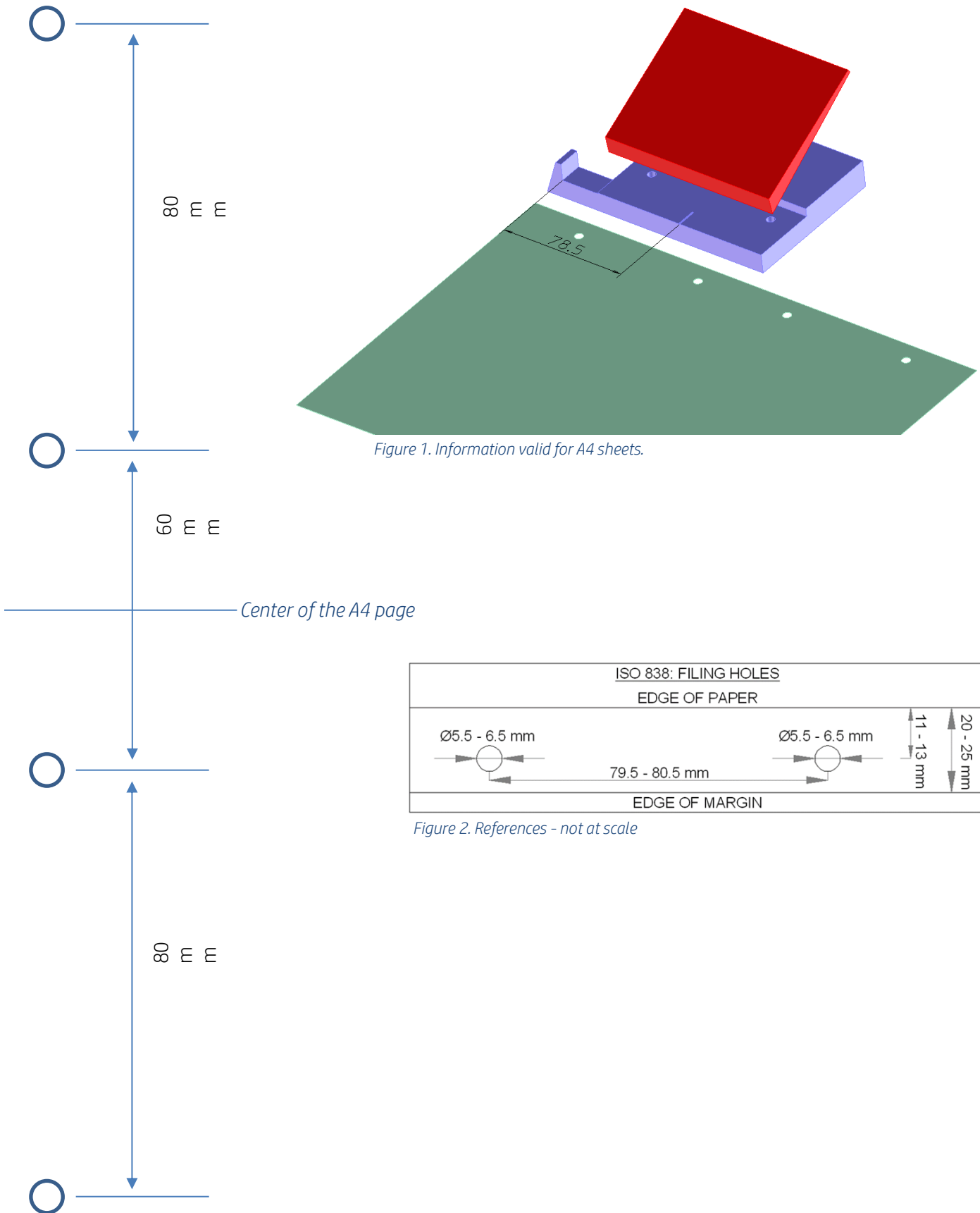


Figure 1. Information valid for A4 sheets.

ISO 838: FILING HOLES			
EDGE OF PAPER			
Ø5.5 - 6.5 mm	79.5 - 80.5 mm	Ø5.5 - 6.5 mm	11 - 13 mm
			20 - 25 mm
EDGE OF MARGIN			

Figure 2. References - not at scale

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