

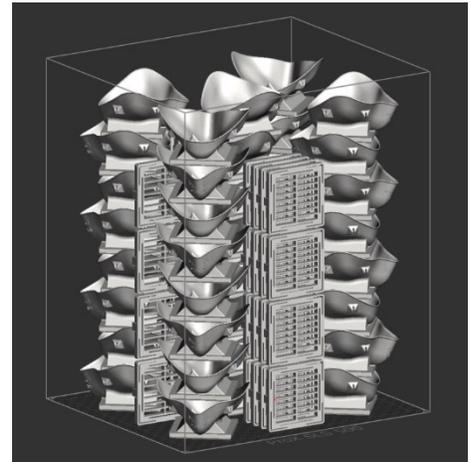
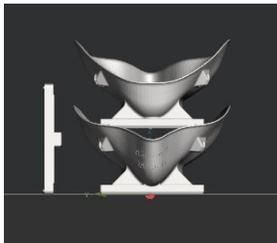
Manufacturing Guidance for 3D Printed Nylon Surgical Masks

Rev B SFM – Small, Medium, Large

Rev G Cover

Build Orientation

- For efficient nesting, place front portion of mask facing down and stack the same size vertically. For large and medium sizes, rotating 180° between subsequent layers helps stack more efficiently. Place the filter enclosure cover in the vertical orientation scattered throughout the build or build separately if necessary. Total build quantity and layout varies per machine.



Machine Parameters

- DuraForm ProX PA default 3D systems parameters are recommended for laser power, scan spacing, etc. Use locally established settings for heaters, scale/offset, etc.

	ProX 500/ ProX 6100	sPro 60	sPro 140	sPro 230
Parameter Settings	Default – Standard Production	Default – HS mode	Default – TruTemp	Default – TruTemp
DuraForm ProX PA Material Blend Ratio	Default – 40% Virgin/60% Recycled	Default – 33.3% sifted part cake, 33.3% virgin, 33.3% sifted overflow	Default – 40% Virgin/60% Recycled	Default – 40% Virgin/60% Recycled

Post Processing

- Break out parts from print cake (ensure print cake temperature $\leq 50^{\circ}\text{C}$ to prevent warping).
- Brush off bulk powder on parts.
- Blast parts with glass bead media for fine depowdering.
- Rinse parts with water to remove remaining media.
 - If available, use ultrasonic cleaner for an additional cleaning cycle in water.
- Dry parts using compressed air or an oven.
 - Recommended oven parameters: 50°C for 30 minutes.