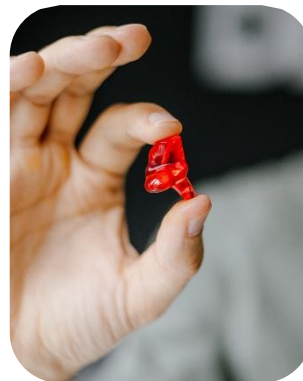


Workflow Guide

dx rapid cast 2.0

3D printing of cast molds that can be removed without tools – the Detax cast material.



This guide will lead you through the process of designing, manufacturing, preparing, filling and removing the cast shell.

Workflow

1. Design



Time

Approx. 10 min



Design Parameter

• n. a.



Wall Thickness Cast

Approx 0.8 mm



Filling Cone

Use a filling cone or second stand as a support cone.

If you use build job builder

Make sure that you place the filling cone on top of the cast shell.

2. Create Print Job



Time

Approx. 5 min



Note

Use the validated parameter files for dx rapid cast 2.0.

If you use build job builder
Use thicker support points.

3. Printing Process



Time

Approx. 45 min



Note

Use a Detax-validated 3D printer.

4. Post Process

4.1. Cleaning



Time

2 x 2 min in IPA two separate containers



Note

Between the two cycles and after the washing process, careful blow out with compressed air with max. 2 bar.



If you use build job builder

Don't remove the cast shell from the supports, wash it in one part.
Please make sure that the cast shells are complete floated with IPA during the washing process.

4.2. Post Curing



Time

XXX

Otoflash G171 N²

2 x 2000 flashes with nitrogen

RScure Programm

Dx rapid cast 2.0

Dreve PCU LED

2:30 min with Nitrogen
Light intensity 33%

If you use builjob builder

If necessary, carefully remove the cast shells from the support structure after post-curing.
Don't pull them off, use a cutter.

5. Filling the Cast Molds



Note

No cast separator is required.



Pressure

Working pressure of the pneumatic mixing gun is 2-3 bar.

6. Setting of the Silicone and Removal Process

Place the filled cast molds in a pressure pot filled with water to cure.
The cast molds must be completely surrounded by water.



Time

Softwear 2.0
Approx. 15 min

Others
Please find in the IFU of the silicone.



Water Temperature

40 °C



Pressure

3-4 bar

7. Demolding Process

The demolding process starts at the moment the silicone starts to cure.



Time

Few seconds



Tools

Your hands

No tools are necessary to remove the cast shells.

After the specified curing time of the silicone, you can remove the cast shells from the pressure pot and start to remove the cast shell.
