



Somos[®] WaterShed[®] AF

Overview

Somos[®] WaterShed[®] AF is a multi-purpose stereolithography resin that meets the requirements for investment casting patterns, as it is antimony-free. Patterns created with Somos WaterShed AF leave much lower amounts of ash residue after burnout, reducing clean-up and speeding up mold production.

Technical Data

Optical Properties

E_c	9.12 mJ/cm ²	[critical exposure]
D_p	7.57 mils	[slope of cure-depth vs. ln (E) curve]



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Safety Instructions

Avoid injuring yourself or others

Adhere to the following guidelines:

- Read and understand the Safety Data Sheet (SDS) before using the material.
- Avoid contact with eyes, skin & clothing by wearing the following Personal Protective Equipment (PPE):
 - Safety Glasses/Goggles
 - Gloves
 - Laboratory Coat
- Keep the work area clean.
- Avoid spreading material on clean surfaces.
- If material is found on clean areas, it should be cleaned off immediately with a disposable paper towel and isopropanol.
- Wash hands regularly after handling material.
- Provide adequate ventilation.
- Prevent build-up of volatile substances from materials and solvents.
- Remove dust from clean and finished parts.
- See the Stratasys[®] [Handling of Cured Somos Stereolithography Resins](#) guide for UV materials for further safety instructions.

Preparing Equipment

Operating Conditions

We recommend the following room conditions:

- Ambient temperature of 20°C – 25°C (68°F – 77°F)
- Humidity of less than 40%.
- Minimize dust, as it can build-up and reduce the performance of the optics on your SLA machine, potentially leading to an increase in scattered UV light. Ultimately, this could increase the viscosity of the material in the vat.
- Use UV filters for lighting and external windows.

Replacing Material

When replacing material, make sure you clean the vat thoroughly, dispose of used material and cleaning products (solvents, paper towels, etc.) properly and follow vat installation procedures.

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Machine Maintenance

Contact your equipment supplier for up-to-date technical support for your equipment. Below are a few common checks that will help you build parts successfully:

Recoater Blade

- Keep the re-coater blade clean. Remove debris from the bottom and periodically check the gap and rake of the blade.
- Periodically check the rim level.
- Keep bearing rails clean and oiled.
- Periodically check belts, sprockets and bearings.

Optics and Overhead Mirror

- Keep mirrors and optics dust free and clean. Periodic preventative maintenance will increase the life of the laser beam and improve its quality.
- Have the laser tuned and serviced periodically. The typical tuning frequency is two to three times a year. This reduces the risk of burn spots on the laser crystals.

Machine Computer

- Inspect the cooling fans for electronic components regularly to ensure they are working properly.
- Keep the build tree clean. Having too many build files can corrupt the procycon.mdb, which contains material data, start position and sensor locations.
- Install back up hard drives to ensure you do not lose any data. This is very important, especially for older equipment.
- Make sure the latest computer software service packs are installed are your system for optimal performance.

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Build Parameters

Build parameters are subject to site conditions and machine efficiency. The parameters mentioned below can be considered base settings that you can tweak for improved styles.

Machine Settings

Check to see that the Zephyr blade is clean of any residue by running a gloved finger along each side of the blade. If there is any residue, gently wipe it off with the proper tool.

Before beginning a new build, always check the Zephyr blade to ensure there were no changes after any build crash or other adverse events that may have changed the gap.

Also, check that the resin level in the blade is set to the halfway point. On builds with large flat or trapped volumes, check that the blade does not run out of material. If it does, material starvation could be causing it to give an incomplete part re-coating.

Beam Diameter

The minimum beam diameter (in X or Y directions) should be used when calculating the maximum scan speed.

Smax Calibration

The Smax should not exceed the recommended hatch speed for the machine being used.

Postprocessing

Part-cleaning Procedure

- Drain excess material off the parts in the vat.
- Remove the platform from the machine and remove the parts.
- Supports can be gently scraped off with a spatula. The pattern is not fully cured and must be handled gently to prevent breakage or distortion.
- Centrifuge the parts to remove as much uncured resin from the pattern as possible. This can be done with, among others, commercial grade “honey spinners”.
- Clean the part by wiping the outer surface of the pattern with a soft paper towel soaked in isopropyl alcohol, and remove any uncured residue.
- Never submerge the pattern in cleaning solvents. Solvents entering the pattern will have to be removed. Solvents left in the pattern can cause failures such as shell cracking during the burnout phase.

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Post Cure Procedures

UV Post-cure

After thoroughly air-drying the parts and checking that they are free from liquid resin residue, UV post-cure the parts for 20 minutes, rotating the part once after 10 minutes.

Disposal Instructions

Avoid injuring yourself or others

In some areas, partially cured or uncured waste UV material may be classified as hazardous waste and requires special packaging.

Transportation Disposal

Contact the governmental or other body that regulates waste disposal in your area to determine the disposal protocols.

Packaging Transportation Disposal Methods

Packaging Transportation Disposal methods must prevent any form of human contact with the waste UV material, even if it is classified as nonhazardous or unregulated. This therefore precludes the use of disposal methods that might result in groundwater or surface water contamination.

Solvent Disposal

Solvents should be isolated in a sealed, marked container and disposed of as “hazardous waste” in accordance with all applicable laws and regulations.

Clean-up Material Disposal

Soiled clothing, empty containers, etc., should be disposed of in accordance with the applicable “hazardous waste” guidelines. If any of these items contain uncured or partially cured UV-curable materials, the disposal method used must prevent any form of human contact, including any that could result in groundwater or surface water contamination.

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FAQ/Troubleshooting

Below are some examples of common issues and troubleshooting solutions. Consult this part of the guide if you are having difficulties and do not hesitate to contact your local Stratasys representative.

Issue: Delamination

Delamination occurs on the bottom layer of parts at the corners or on part edges.

Solution: Check Blade

Have the physical gap on your re-coating blade checked.

- For Zephyr blades
 - Set the blade gap to 0.004 inches (0.102 mm)
- For doctor blades
 - Set the blade gap to 0.006 inches (0.1524 mm).

Watch the buildup of the first few layers of the part to determine that the surface is being properly coated with material. Check for signs of material starvation or de-wetting.

Issue: Roughness

The top surface of the part is not smooth and level.

Solution: Check Re-coating Blade

This condition is somewhat common and arises due to the viscosity of the material and the presence of debris that may become suspended in it.

Check the re-coating blade to make sure the bottom surface is clean and filter debris from the vat.

It is very important that you maintain the correct material viscosity in your stereolithography machine. The viscosity can increase over time, and this can cause problems in building parts. If the viscosity increase is severe enough, the material may have to be replaced, resulting in significant expense and lost production time.

If increasing viscosity is identified early, the material can, in most cases, be saved. Regularly measuring resin viscosity can provide an early indication of the problem. This must be done even if the machine is not used often, as resin viscosity can change even when the machine is idle.

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Viscosity Measurement

Depending on the viscosity range of the material you want to test, use the appropriate-sized cup, based on Zahn Cups guidelines. You will also need a long-stem thermometer that mounts onto the Zahn cup handle and a stopwatch.

Procedure:

- Ensure the material in the vat is at part-building temperature.
- Mount the thermometer on the Zahn cup handle and hold the tip of the thermometer so it is halfway up the bowl. The tip of the thermometer should not touch the material in the bowl but be suspended above it.
- Turn the thermometer on and set it to Celsius.
- Lower the machine platform about 100 mm below the material surface.
- Slowly immerse the Zahn cup at a 45° angle into the vat of material, being careful not to create bubbles, and rest the cup on the platform. Be careful that it does not fall into the material.
- Monitor the temperature of the material with the thermometer. Wait until the Zahn cup and material have reached the vat temperature. Once the Zahn cup thermometer shows a steady reading, you can take a measurement.
- Slowly lift the Zahn cup completely out of the material. Start the stopwatch when the top of the cup leaves the material.
- Watch the stream of material flowing from the hole at the bottom of the cup. When the stream just under the cup breaks and changes from a continuous flow to individual drops, stop the stopwatch.
- Read the number of seconds on the stopwatch and use the table on the following page to determine the approximate viscosity of the material.
- Repeat the procedure to obtain at least two values that are close to each other. When finished, turn the thermometer off to save the battery.
- Record the following data in a chart for each material and machine:
 1. Date
 2. Temperature of material
 3. Readings (seconds)
 4. Viscosity (from table)
- If the viscosity of the material starts to increase significantly after having been stable for some time, contact your support or sales representative, and provide the data from the table.
- Clean the cup and thermometer by wiping them with a paper towel. Wash the cup and thermometer stem with solvent and dry them. Do not remove the long-stem thermometer from the Zahn cup until the stem is completely clean.

Note: Whenever you have material in your machine, measure and record its viscosity once a week.

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Table of approximate viscosity in cps linked to Zahn #4 cup test time

Seconds	Approximate Viscosity (CPS)
20	245
22	280
24	310
26	340
28	375
30	410
32	440
34	470
36	505
38	540
40	570
42	600
44	635
46	667
48	700
50	730

Seconds	Approximate Viscosity (CPS)
52	765
54	800
56	830
58	860
60	895
62	930
64	960
66	990
68	1030
70	1060
72	1090
74	1120
76	1150
78	1190
80	1220
82	1255

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Disclaimer

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