

# blueprinter®

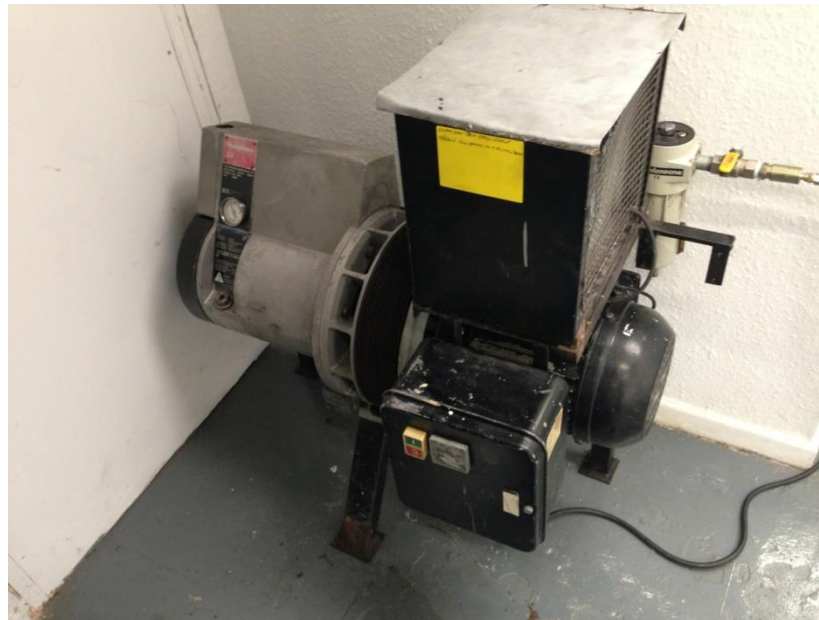
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blueprinter®

# Cleaning Station.

- Set up
- Air requirements
- Power
- Priming hopper
- Cleaning
- Unblocking



**Subject:** Compressor specification for cleaning station

To explain free air

This is not the same as max pressure 8bar as seen on budget/DIY compressors

The largest electric motor available on single-phase supply is normally 3HP.

This will drive the pump of a 14 c.f.m. Compressor, which will give 10 c.f.m. FAD (free Air Delivery). 10 c.f.m. FAD will sustain a constant 72-psi. Through a nozzle 3mm. diameter.

Of course, smaller compressors (10 c.f.m. upwards) will also work, but will not sustain the higher pressure indefinitely. With a smaller compressor, you will have to pause from time to time to allow the compressor to build up the pressure again. Continuing with low pressure will increase the risk of burning the part and be very time consuming.

The following chart gives an indication of the pressure you can expect your compressor to sustain when blasting continuously through the 3mm.

Air Displacement	Free Air Delivery	Pressure using 3mm Nozzle
14 cfm (400L/min)	10cfm (300L/Min)	72psi (5 Bar)
10 cfm (300L/min)	7 cfm (200L/Min)	50psi (3.5Bar)

# Recycling Powder

- Brush Grinder
- Drums
- Types of powder
- How to mix

# Remove parts from machine and clean parts

- Remove the finished part from the printer

During the print process, the build chamber is filled with powder. The part is supported by the excess powder during the build. After the build is completed, you need to remove the part and the excess powder from the build chamber. The excess powder can be reused.

a) Pull the printer handle towards you and open the top lid.

b) Place the remover box on top of the build chamber.

c) When the remover box is placed correctly, the build chamber platform is raised.

d) When the build chamber is fully raised, push the sliding tray into place at the bottom of the remover box.

e) Remove the remover box from the printer.

- Practical

# How to clean parts

- Using the gun
- Additional tools

## Remove excess powder from the finished part

Use the cleaning station to remove excess powder from the finished part.

**Note!** Keep your body in contact with the **cross bar (1)** when working with the cleaning station to avoid static electricity.



- Make sure that there is powder in the cleaning station powder reservoir. The powder is used to blaster the parts.
- Place the remover box with the printed part in the cleaning station.
- Remove the sliding tray and the top part of the remover box.
- Close the lid and lock the snap lock on each side of the cleaning station.
- Turn on the compressor and the cleaning station.
- Place your hands in the gloves and use the powder blaster gun to remove excess powder from the part. Keep the powder blaster gun at a distance of 10-15 cm from the part.

## Powder blaster gun

**Note!** If there is excess powder that cannot be removed using the powder blaster gun, use a manual tool, for example a spatula or a small brush to remove the powder.

# Good practice

- **Clean the cleaning station**

- Use the air vacuum gun to clean the lid, by squeezing the side
- Vacuum the inside of the cleaning station regularly, to make sure that the sieves do not get clogged.
- Clean the filter after use. To clean the filter:
  - a) Open the two **snap locks (1)**.
  - b) Remove the **filter holder (2)** and the **filter (3)**.
  - c) Vacuum the inside of the **filter holder**.
  - d) Clean the **filter (3)** in a dishwasher and let the **filter (3)** dry.
  - e) Put the **filter (3)** back in the **filter holder (2)**, and attach the **filter holder (2)** with the **snap locks (1)**.

