

1. INTRODUCTION

The following instructions for use are for dental professionals who use Structomer® Model-X Plus as a dental modelling 3D printing material. Structomer® Model-X Plus is intended for printing dental and orthodontic models. This instruction for use also provides information about safety and environmental aspects. Safety datasheet (MSDS) corresponding to the Structomer® Model-X Plus material is available on <https://www.structo3d.com/> and with the local dealers.

2. INTENDED USE / INDICATION

Structomer® Model-X Plus is intended to be 3D printed into dental and orthodontic models used in dental applications. The models are individually manufactured by dental professionals. The models are designed to aid in dental applications.

3. HARDWARE REQUIREMENTS

Structomer® Model-X Plus can be used in combination with all laser, DLP and LCD based 3D printers which support Structomer® material. Information about supported 3D printers can be obtained from Structo Pte. Ltd. (see Contact Information below).

Please follow the hardware instructions provided by the hardware manufacturer concerning the printing parameters and support structure recommendations for Structomer® Model-X Plus.

4. CONTRAINDICATION

Any deviation from this instruction for use is not recommended. In case of an allergic reaction, please contact a medical physician. The printed models are for single-use only and are not to be used in contact with any part of the human body.

5. SAFETY INSTRUCTIONS

Structomer® Model-X Plus is produced and tested according to the most stringent quality standards. In order to ensure optimum processing, please read the information contained in this Instructions for Use (IFU) carefully. Improper use and failure to observe the information can have a detrimental effect on the device quality.

Nitrile gloves, goggles and coat should be worn as means of personal protection during resin handling. For proper handling of the resin, refer to Structomer® Model-X Plus safety datasheet (MSDS). However, tolerance and sensitivity to particular resin components may vary for each individual, possibly resulting in adverse effects. In such cases, the respective user should discontinue use of Structomer® Model-X Plus.

Structo Pte. Ltd.
www.structo3d.com

60 MacPherson Road
 Block 1 #04-08 Siemens Centre
 Singapore 348615

6. MANUFACTURING PROCESS

Prepare

- Make sure that printer used is compatible with Structomer® Model-X Plus
- Assign the suitable cloud profile.
- Define support structures if required.

Shake

- **Shake** bottle well before use (2 -5 mins).
- **Pour** Structomer® Model-X Plus into printer reservoir upto **max-level** mark. Resin top-up is required after every print to maintain this level.
- To ensure resin homogeneity, gently mix sitting resin in the printer tank.

Build

- Before printing, manual mixing of the resin before each print is recommended.
- 3D **print** the desired dental models (upto 9 horizontal solid arches per print).

Remove

- Remove build platform off the 3D printer.
- Remove printed objects off the build platform immediately after print completion.
- Use a razor blade/knife to get under the borders of the printed part and gently ease off the entire part.

Clean [IPA wash or Solventless wash (Spin)]

- Rinse the printed objects in an ultrasonic bath (Duration: 2 cycles x 2 minutes) to get rid of excess resin in **2 wash cycles**.
- **Fresh Isopropanol** (at least 90% concentration) should be used as the cleaning agent for cycle 2.
- Spin the printed objects in a Spinner (Structo G-01)

Dry for IPA wash

- Dry printed objects with compressed dry air to avoid residues of IPA on the object surface. In the absence of compressed air, the printed objects should be allowed sufficient time for natural drying.

UV Post-Cure

- Post curing duration vary depending upon the type of Post curing unit used. 1 min in Metal halide lamp PCU, 5 mins at 60 °C in 405nm UV LED light PCU & 15 mins in a PCU combination of UV-A(315-400nm) and UV-Blue (400-550 nm) bulb.
- Remove printed objects out of the post-cure unit immediately after completion.

Aligner making

- Carry out clear aligner thermoforming as per manufacturer's instructions.
- Use **0.8mm** sheet thickness
- **2 bar** pressure is most recommended

Finish

- Trim aligner along the gumline to remove off the model.
- Finish and polish as per manufacturer's recommendations.

Note:

Repeat printing: For repeated printing cycles, top-up resin in the printer tank up to the max. mark and manually mix the remaining resin before each print.

UV post-curing: Full polymerization of printed object by UV post-curing is critical to achieve desired material properties and to provide a functional end-product. The manufacturer's recommended processing time varies depending upon the type of PCU is used. 1 min in Metal Halide lamp type PCU, 5 mins in 405 nm multi directional LEDs and 15 minutes in a PCU with six 18W/71 lamps

Tel : +65 6514 7332
 Email : sales@structo3d.com

(Dulux L Blue); and six 18W/78 lamps (Dulux blue UV-A). Post-curing light sources need routine maintenance following manufacturer's instruction.

Aligner Thermoforming: Please observe the directions for use and safety instructions of the vacuum thermoforming machine provided by each manufacturer. A sheet thickness of **0.8 mm** (0.031") and thermoforming pressure of **2 bar** (29 psi) is recommended for clear aligner applications. Observe the cleaning and disinfection instructions provided by the manufacturer.

7. GENERAL INFORMATION ON HANDLING

7.1. Delivery

Structomer[®] Model-X Plus is supplied in 1 kg or 5 kg tightly sealed bottle. Check the following upon receipt of the materials:

- Integrity of the bottle & packaging.
- Bottle cap seal is intact and not broken.
- Received quantity against delivery order.
- Shipping documents and label designations.
- Material received not past its 'Use-by' date.

7.2. Storage

Structomer[®] Model-X Plus must be stored in its original sealed bottle and kept away from sunlight to avoid undesired polymerization as the material is photo sensitive. The expiry date printed on the product must be observed.

Satisfactory processing cannot be guaranteed if materials which have exceeded their expiry date are used.

7.3. Cleaning

Fully cured dental models made from Structomer[®] Model-X Plus can be easily cleaned of small particles using room temperature water and lint free cloth.

8. HAZARDS AND PRECAUTIONS

8.1. Hazard Statements

| | |
|------|---|
| H302 | Harmful if swallowed |
| H314 | Causes severe skin burns and eye damage |
| H315 | May cause skin irritation |
| H317 | May cause an allergic skin reaction |
| H319 | May cause serious eye irritation |
| H361 | Suspected of damaging fertility or the unborn child |
| H411 | Toxic to aquatic life with long lasting effects |

8.2. Precautionary Statements (Prevention)

| | |
|------|---|
| P202 | Do not handle until all safety precautions have been read and understood. |
| P261 | Avoid breathing dust / fumes / gas / mist / vapors / spray. |
| P264 | Wash skin thoroughly after handling. |
| P272 | Contaminated work clothing should not be allowed out of the workplace. |
| P273 | Avoid release to the environment. |
| P280 | Wear protective gloves/protective clothing/eye protection. |

8.3. Precautionary Statements (Response)

| | |
|--------------------|---|
| P302 + P352 | IF ON SKIN (or hair): Wash with plenty of soap and water. |
| P304 + P340 | IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing. |
| P305 + P351 + P338 | IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses if present and continue rinsing. |

7.4. Disposal

Structomer® Model-X Plus in its liquid form is hazardous to the environment. It is recommended that resin waste (including resin residue in used isopropanol) be delivered to a chemical waste collection point and disposed in accordance with all local and national regulations for chemical waste disposal. Residuals must be removed from packaging and when emptied, completely disposed of in accordance with the regulations for waste removal. Handle contaminated packages in the same way as the product itself. Incompletely emptied packaging must be disposed of in the form of disposal specified by the regional disposer.

- | | |
|-------------|---|
| P312 | Call a POISON CENTER or doctor / physician if you feel unwell. |
| P321 | Special treatment (see supplementary first aid instructions on this label). |
| P312 | Special treatment (see supplementary first aid instructions on this label) |
| P332 + P313 | If skin irritation occurs: Get medical advice/attention. |
| P337 + P313 | If eye irritation persists: Get medical advice/attention. |
| P362 | Take off contaminated clothing and wash before reuse. |
| P391 | Collect spillage |

9. LABEL SYMBOLS



Warning



Use-by date



Consult
Instructions
for use



Manufacturer



Batch code



Keep away
from sunlight

10. CONTACT INFORMATION

10.1. Distribution & Manufacturer

Sales & Distribution:

Structo Pte. Ltd.
60 MacPherson Road
Block 1 #04-08
Singapore 348615

Tel: +65 6514 7332

Email: sales@structo3d.com

Web: www.structo3d.com

Manufacturer:

Structo Pte. Ltd.
3 Kallang Sector
#03-05/06
Singapore 349278

Tel: +65 6514 7332

Email: materials@structo3d.com

Web: www.structo3d.com