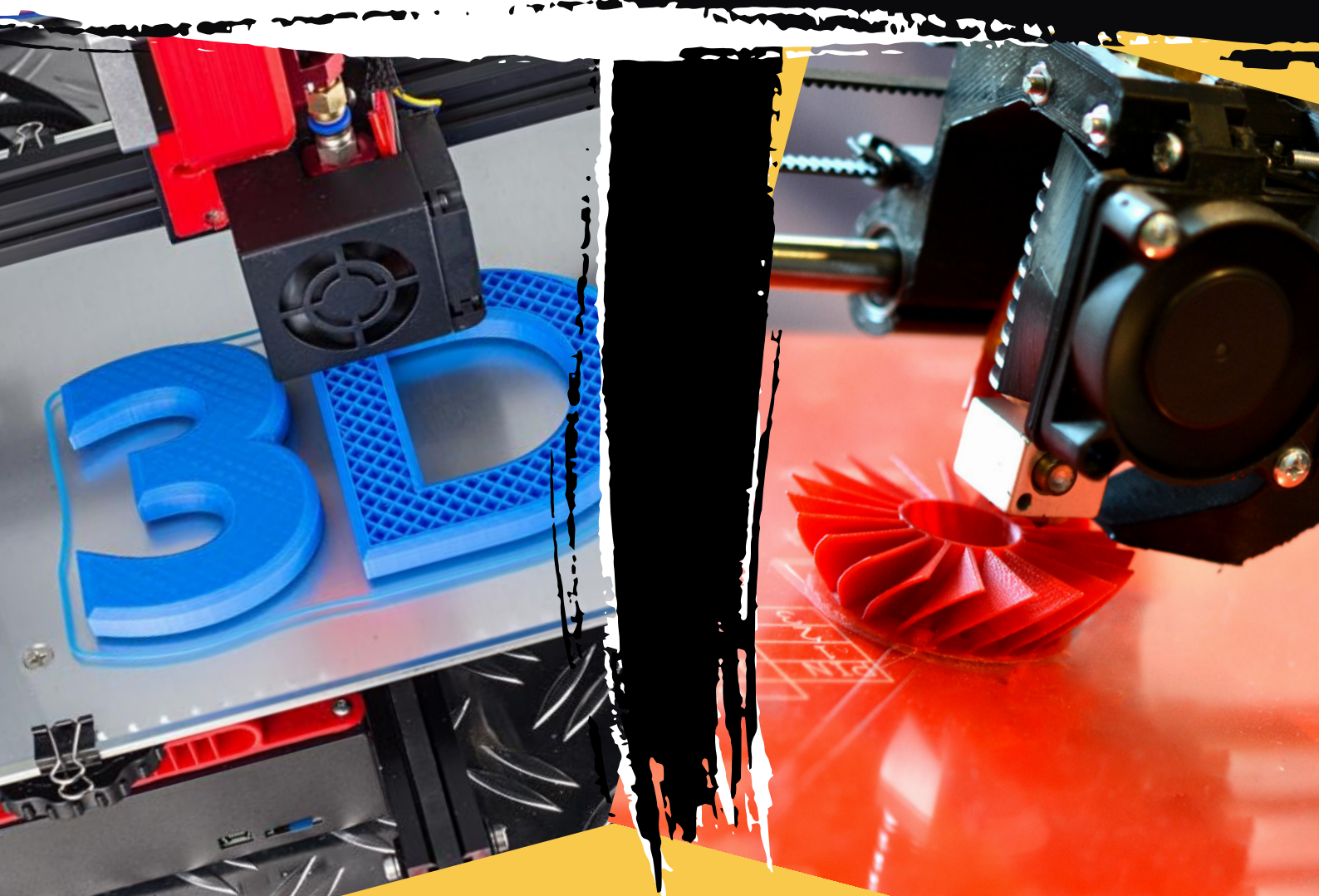


Revolubes 3D Print



Safety Information



DANGER!

If the label has been lost, mark the container to avoid confusion.

Hazard statements:

May be fatal if swallowed and enters airways. Harmful if inhaled. May cause an allergic skin reaction.

Prevention:

Avoid breathing mist/vapours. Use only outdoors or in a well-ventilated area. Contaminated work clothing should not be allowed out of the workplace. Wear protective gloves.

Response:

IF INHALED: Remove person to fresh air and keep comfortable for breathing. Call a POISON CENTRE/doctor if you feel unwell. If skin irritation or rash occurs: Get medical advice/attention. IF SWALLOWED: Immediately call a POISON CENTER/doctor. Do NOT induce vomiting.

Storage:

Store locked up. Keep out of reach of children.

Disposal:

Dispose of contents/container, used and contaminated petrol, white spirit, turpentine, or any other solvent used for cleaning at your local Household Waste Recycling Centre.

Cleaning and Preparation

Each printer's component, regardless if it is used or new, requires an upfront and proper preparation before applying any lubricant. Such preparation is also required to aid the chemical reaction of Revolubes™ active ingredients with component's material.

To prepare the surfaces correctly, they must be thoroughly degreased and washed to remove any factory/old grease, production contamination, abrasive metal fillings and wear products (oxides, rust deposits, etc.), which may affect the operation of a component.

We strongly advise using the Revolubes Cleaner, which is purposely blended for the task however, you may also use SLS soaps and isopropyl alcohol as alternative solvents.

If you chose to use Revolubes Cleaner for the job, ensure that the component and the cleaner are both in temperature above +16°C (not air temperature), and proceed with the following steps:

- 1) Where necessary, clean the outside surfaces with soft cloth, a toothbrush, cotton swab to get rid of larger contamination deposits before degreasing.
- 2) Where possible, put the component in a container and fill it with fresh Revolubes™ Cleaner, so the component is fully submerged. Close the container with a lid.
- 3) Depending on the component's condition, leave it submerged between 30 mins and 2 hours. Leave the container in a warm place, shaking it from time to time. This will allow the cleaner to penetrate every nook and cranny and dissolve any solid contamination, oxides, and deposits.
- 4) Gently shake the container for about 1 minute.
- 5) Take the component out from the container and let the cleaner soak down.
- 6) Wipe it thoroughly with a cloth or paper towel until it is dry.
- 7) Proceed with application steps.

Application

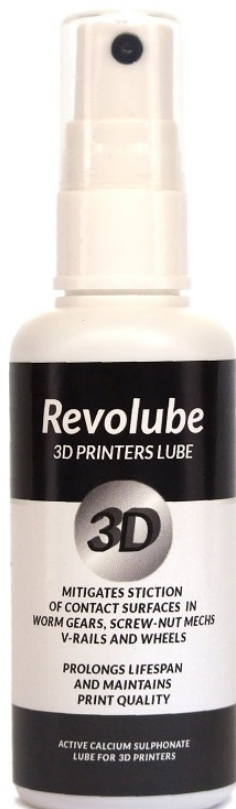
Ensure the reel's components and Revolube have temperature above +16°C. This is crucial to provide enough energy for the reaction of the active ingredients with the component's material. This is only necessary during application and the bed-in period, after which Revolubes™ performs down to -40°C.

Bearings

- Apply a thin layer of Revolubes™ Bearing Grease to the gears. Ensure the layer is evenly spread on the gears' faces.
- Fill the bearing's track with up to 1/3 of its volume.
- Do not overdose, as it may introduce hydrodynamic drag.



Z-axis screw-nut, guide rods, and V-rails.



Apply small doses of Revolubes™ 3D Lube, minding to spread it over the component's faces:

- Z-axis screw
- bearing carts
- guide rods
- V-rail wheels

Once lubricated, run the printer to allow the lubricants to work in. If there is any excess, wipe it off with a cloth or a paper towel.