

Sterilization Results

Ultracur3D® EL 60

This document is intended to provide guidance for manufacturers regarding sterilization of the 3D printed materials. BASF3D Printing Solutions GmbH has performed specific sterilization tests for the materials 3D printed employing Ultracur3D® EL 60. Indications on material changes that can occur during the sterilization process were studied. It remains the responsibility of the device manufacturers and/or end-users to determine the suitability of all printed parts for their respective application.

Material

Material
Ultracur3D® EL 60

Print scene and Test Specimens

Three different test parts were chosen, to help determine the impact of the sterilization.

1. *Color disc* (Figure 1) to measure the color of the material before and after sterilization.
2. *Shore A Hardness part* (Figure 2) to check possible changes in mechanical properties.
3. *Tensile Bars* (Figure 3) to check possible changes in mechanical properties.



Figure 1 Color disc 2 mm



Figure 2 ASTM 2240 - Shore A Part



Figure 3 ASTM D412 C - Tensile Bar

Overall the following amount of specimens were printed for each test:

- 10 Tensile Bars
- 1 Color disc
- 1 Shore A Part

Steam Sterilization was performed internally.

Steam Sterilization

Table 1 Testing conditions Steam Sterilization

Steam Sterilization Parameters	Settings
Vacuum pulses	4
Temperature	134°C
Pressure	210 kPa
Holding time	4 minutes
Drying time	20 minutes

When exposed to steam sterilization, Ultracur3D® EL 60 demonstrates a 3 % decrease in elongation at break and 1 % decreases in modulus. The samples also show a 2 % increase in ultimate strength and 3 % increase in Shore A Hardness. The test specimens show no significant visual color change post-sterilization.

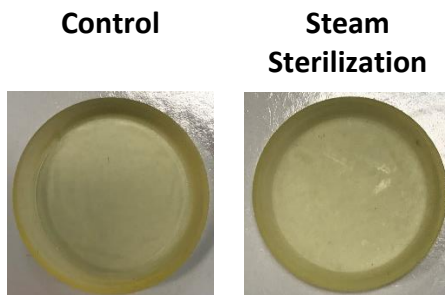


Figure 4 Color discs before and after Steam sterilization

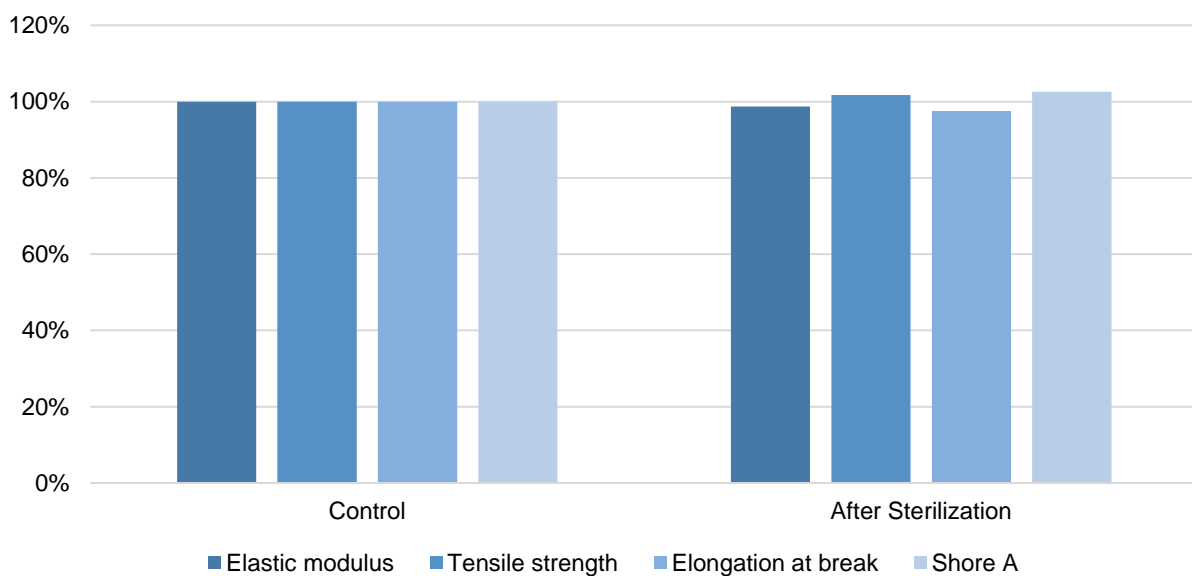


Figure 5 Mechanical properties comparison of the Steam-treated samples

Steam sterilization is recommended for Ultracur3D® EL 60.

Conclusion

The results of the performed tests show that **Ultracur3D® EL 60** can be summarized in the table below.

Sterilization Method	Ultracur3D® EL 60
Steam*	☺ recommended

*Additional information available in a separate document on demand.

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