Texilit™, micro-cones and reflex cleaning

DOCUMENT REVISION CONTROL

DATE	REVISION	SECTION	AMENDMENT	APPROVED BY	SIGNATURE
2022-09-06	0	-	INITIAL RELEASE	Félix Mongeon, P. Eng.	
2022-09-22	1	1,2,3,4,5	Document name and format modification	Félix Mongeon, P. Eng.	
2023-02-10	2	2,3,4,5	Inclusion of general cleaning procedure	Maxime Charette	
2024-02-06	3	4	Instruction “a” modified and split in “a” and “c”. Instructions from ‘’c’’ shifted.	Amine Achou	

TABLE OF CONTENTS

1. DOCUMENT PURPOSE 2
2. RESPONSIBILITIES 2
3. WARNING 2
4. CLEANING PROCEDURE (General maintenance) 3
5. HEAVY CLEANING PROCEDURE (Ultrasonic bath) 4

1. DOCUMENT PURPOSE

The purpose of this document is to share the cleaning procedure applicable for Texilit™, micro-cone and reflex Inserts.

An alternative procedure for cleaning reflex inserts that requires less equipment is also available. Ask a DBM Reflex® representative to obtain this procedure if you do not have access to the equipment listed in this procedure. (after-sales.support@dbmreflex.com)

2. RESPONSIBILITIES

- **Tool/injection shop** must follow recommendations included in this document.
- **Tool/injection shop** must contact DBM Reflex® representative if recommendations cannot be followed or if further assistance is required. (after-sales.support@dbmreflex.com)

3. WARNING

- Wear gloves (nitrile or latex) before any manipulation.
- DO NOT rub insert with rag or touch with bare skin, this can create irreversible damage.
- Always used **deionized water or distilled water** with your **industrial steam cleaner** and or **ultrasonic bath**
- Inserts are made of **Nickel (22-25HRc)** and have **Chromium coating**. They are fragile and must be handled with the **utmost care**.
- It's **NOT possible to Polish** insert with Chromium coating. If polishing operations are attempted, chromium layer will be partly removed, and it will cause aesthetical defect. Such as (White/blueish) appearance which will be visible on molded lens.
- If a damage happens, please **contact DBM Reflex® representative** before attempting anything. (after-sales.support@dbmreflex.com)

4. CLEANING PROCEDURE (General maintenance)

a. **Spray** the insert with Mold Cleaner ***(Slide Mold Cleaner 4)*** to remove mold saver, grease, dust, or other deposited contaminants***)***

-If the insert is not contaminated by grease, oil, silicon, skip step ''a'' and go to step ''b''.

Figure 1 - Mold Cleaners examples

b. **Blow** Dust/oil free compressed air to dry component

c. Spray the insert with cleaner (Bio Circle FT 200) for final cleaning.

Figure 2 -Cleaners examples

d. **Industrial steam cleaner,** Wear heat resistant gloves and ***hold part firmly*** while you spray steam over the part. ***(Avoid contact between nozzle and the part)***

Figure 3- Industrial steam cleaner example

e. Immediately **rinse** component with **isopropyl alcohol (≥ 70%)** * to remove water.

f. **Blow** Dust/oil free compressed air to dry component.

g. If the insert is still dirty, **repeat steps from** "**a**" **to** "**f**" (If the insert is still dirty after, go to "5”). HEAVY CLEANING PROCEDURE (Ultrasonic bath)".
If you don’t have access to an ultrasonic bath, please contact DBM support.

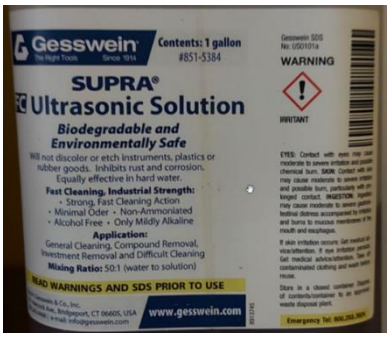
***** Isopropyl alcohol is available in drugstore

5. HEAVY CLEANING PROCEDURE (Ultrasonic bath)

5.1 ULTRASONIC CLEANING PARAMETERS

- **Minimum** Ultrasonic Frequency:40 kHz (lower frequencies are too harsh).
- **Maximum** power: 250 W (adjust parameters according to ultrasound generator specifications).
- Use only aqueous soap solution compatible with nickel and chromium ***(Such as Gesswein #851-5384)*** and follow supplier recommendation for dissolution ratio.

Figure 4 - Ultrasonic cleaning solution example



5.2 PROCEDURE

a. Gently **submerse** component in ultrasonic bath while making sure it rests in a stable position so critical areas will not contact tray or surrounding parts.

b. **Activate** ultrasounds for 5 minutes.

c. Carefully **change location** in ultrasonic bath.

d. **Activate** ultrasounds for another 5 minutes.

e. Carefully take component out of ultrasonic bath, do not allow it to dry.

f. **Rinse** component with **deionised water** to remove soap residue.

g. Immediately **rinse** component with **isopropyl alcohol (min 70%)** to remove water.

h. **Blow** Dust/oil free compressed air to dry component

i. If the insert still dirty, please **contact DBM Reflex® representative** for support