



# Biocompatible VeroContactClear

## Overview

Vero™ContactClear (CTT610) is a clear, general purpose material that simulates standard plastics and is suitable for permanent (more than 30 days) contact with intact skin.

To print biocompatible parts, make sure that you follow the detailed instructions in [VeroContactClear Biocompatibility Requirements](#), available on the Stratasys® website.

This document describes recommendations and tips for achieving optimum clarity for biocompatible VeroContactClear parts.

As a rule, best clarity is achieved when clear parts are printed and treated as explained below.

The following sections describe tips and recommendations for obtaining optimum results for printed parts.

- Supported printers and modes
- Preparing the printer
- Preparing parts for printing

# Biocompatible VeroContactClear

## Printing Recommendations and Tips

### Supported Printers

VeroContactClear can be printed on the following printers:


- J8™ Series
- J55™ Prime
- J35™ Pro

These printers must be running GrabCAD Print™ version 1.56 and above.

### Preparing the printer

To ensure biocompatible parts, make sure to read and follow the instructions in the [VeroContactClear Biocompatibility Requirements](#).

**Tray Settings**

 Tray settings don't match the printer configuration.

Tray Materials Change

- UltraClearS
- VeroContactClear
- VeroPureWhite
- SUP710

Print Modes

- Long Print
- High Quality Speed

▶ [Advanced](#)

Figure 3: Tray materials with VeroContactClear



Figure 1: Water bottle mouthpiece printed with VeroContactClear



Figure 2: 3D printed, biocompatible syringe

## Preparing Parts for Printing

To achieve maximum clarity, use the following guidelines:

- Always prefer a matte surface finish. The support material that covers matte surfaces helps protect the part's layers from excessive UV radiation, thereby improving clarity.
- When printing glossy parts, arrange them so they have similar heights (Figure 4). This ensures that the parts are not exposed to unnecessary UV radiation, since parts with similar heights require the same number of print-head and UV-lamp passes. When printing parts with different heights on the same tray, the print block passes over all parts even after the shorter parts have been completed. This causes the shorter parts to absorb more UV radiation than necessary, which increases the yellowish tint.
- Position parts at a 45-degree tilt for best clarity on the X and Y surfaces (Figure 5).

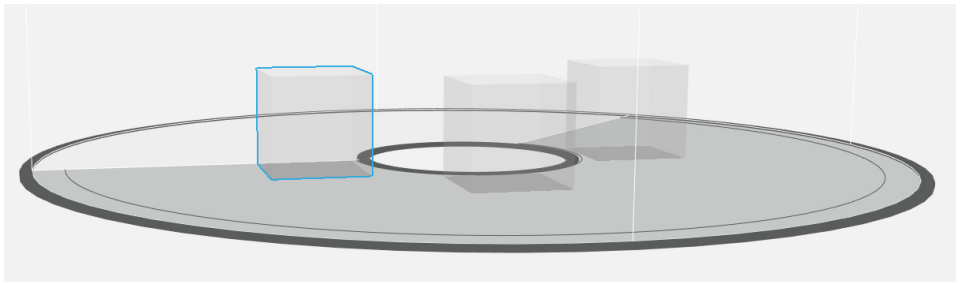


Figure 4: Parts with similar heights on J55 Prime.

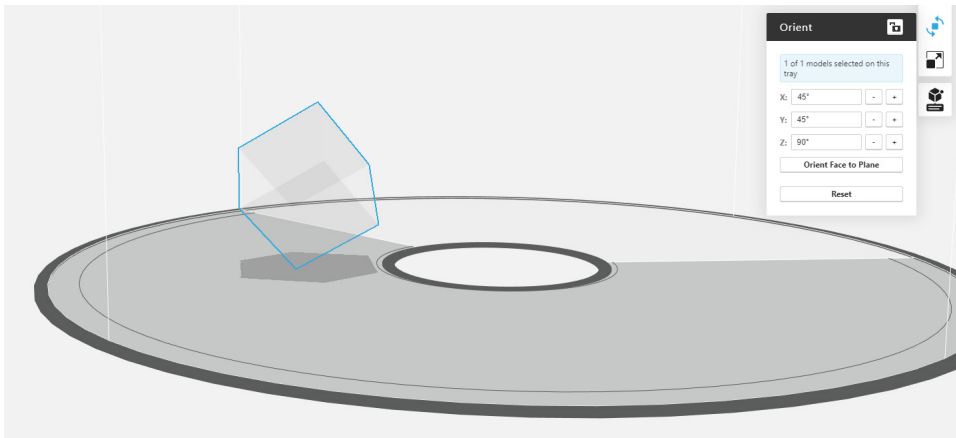


Figure 5: Part orientated with a 45-degree tilt on J55 Prime.

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