



UNIVERSITY OF
NORTHERN COLORADO

Environmental Health and Safety

3D Printer Procedure

October 2018



UNIVERSITY OF
NORTHERN COLORADO

Environmental Health and Safety

3D Printer Procedure

Table of Contents

- I. Purpose
- II. What is 3D Printing
 - A. ABS vs. PLA Feedstock
 - B. 3D Printing Emissions: Nanoparticles and Vapors
- III. Responsibilities
 - A. Environmental Health and Safety
 - B. Deans, Directors and Principal Investigators (PI) with 3D Printer Oversight
 - C. Facilities Management
 - D. Purchasing Department
- IV. 3D Printer Guidelines
 - A. Ventilation
 - B. General Safety Information
 - C. Engineering Controls
- V. Personal Protective Equipment (PPE)
- VI. Training and Recordkeeping



UNIVERSITY OF
NORTHERN COLORADO

Environmental Health and Safety

3D Printer Procedure

I. Purpose

The 3D Printer Procedure establishes the minimum requirements necessary to allow for the safe use of 3D printers located in the University of Northern Colorado (UNC) facilities. The procedure is presented in recognition of the continued expansion of 3D printer use by faculty, staff and students. Studies have indicated that 3D printers are capable of generating potentially harmful concentrations of ultrafine particles (UFP) and chemical vapors during the print process and through processes used following printing to treat the finished product.

II. What is 3D Printing

3D printing, an additive manufacturing technology, has made rapid prototyping and small-scale manufacturing easier and more accessible. However, this revolutionary process does not come without hazards.

3D printing refers to various processes used to create or replicate an object by using successive layers of material (usually plastics) to create an object. Objects can be of any shape or geometry and produced from a 3D model or from a design fed into the 3D printer by a computer.

A. ABS vs. PLA Feedstock

Each 3D printer is designed to use certain types of materials. The most common type of desktop 3D printer technology joins thin strands, or filaments, made of ABS (Acrylonitrile Butadiene Styrene) or compostable materials, such as Polylactic Acid (PLA). Using a computer-generated image, a 3D printer heats and melts the feed material, placing layers of filament on top of one another to form a precise 3D replica of the image.

The materials being fed into the machine (feedstock) can have inherent hazards and may release vapors and gases that may be more hazardous, for example, after they are heated during the 3D printing process.

Generally speaking, ABS represents a greater health and safety risk than PLA media.

B. 3D Printing Emissions: Nanoparticles and Vapors

Nanoparticles

To reduce the potential for nanoparticles to aerosolize or be inhaled by users, it is best to purchase 3D printers with an enclosure, from the manufacturer. Even with an enclosure, a review will need to be performed regarding ventilation systems (see Section IV.A).

Exposures to nanoparticles at high concentrations have been associated with adverse health effects, including total and cardio-respiratory mortality, strokes and asthma symptoms. While PLA feedstock is designed to be biocompatible, the thermal decomposition products of ABS feedstock have been shown to have toxic effects on lab rodents.

Chemical Vapors

3D printers may best be used in a location that has additional ventilation.

Heating of certain thermoplastic filament can generate toxic vapors and vapors with high volatile organic compounds (VOCs). Most 3D printers do not come with an enclosure, exhaust ventilation or any filters. The following must be assessed before purchasing and installing a 3D printer:

- Building/Room where 3D printer will be located
- Placement of the 3D printer in the space itself
- Selection of printing feedstock

III. Responsibilities

A. Environmental Health and Safety (EHS)

- EHS will be responsible for the review and approval of all 3D printer purchases.
- Purchasing review will consider the type of printer, the type of print media to be used and the proposed location of the printer set-up before approval is granted.
- EHS may require the modification of proposed printer location or the addition or modification of exhaust ventilation before purchasing approval is granted. Modification of systems will be at the user's expense.
- EHS has authority to immediately halt any operations if it considers the area unsafe.

B. Deans, Directors and Principal Investigators (PI) with 3D Printer Oversight

- The PI and 3D printing managers are responsible for enforcing the provisions of this procedure including compliance with the training requirements.
- Providing required personal protective equipment (PPE) and enforcing its correct use.
- Responsible for developing their own operating procedure for the equipment.
- Ensure the equipment is used properly and by trained individuals.

C. Facilities Management

- Review all 3D printer purchase requests and provide information for proper ventilation.
- Install ventilation once the printer and ventilation upgrades are approved.

D. Purchasing Department

- Review all 3D Printer purchase requests with EHS.
- Ensure printers are not ordered until approval, from EHS, is received.

IV. 3D Printer Guidelines

A. Ventilation

3D printers using PLA media exclusively may be set-up in a workspace having at least 4 air changes per hour (ventilation may or may not be required). The number of PLA printers in one location should be limited by the size of the space. Requests for the placement of PLA printers in any space will be reviewed by EHS and FM before proceeding.

3D printers using ABS media, including printers designed and set-up to use both PLA and ABS may only be used in work areas having a dedicated exhaust system or one pass air and at least six air changes per hour. It is recommended that printers using ABS media be used within a fume hood whenever possible.

3D printers using other types of media, including but not limited to thermoplastics, photopolymers, nylon, high impact polystyrene, high density polyethylene, powdered metals, biological media or other uncommon medias shall be reviewed by EHS on a case by case basis with specific precautions required based on the hazards unique to the printing process.

B. General Safety Information

- All printers must be installed according to the manufacturer's requirements and according to NFPA 72 National Electric Code.
- Safety Data Sheets (SDS) must be obtained and kept by the department, for all print media and for any other chemical product used in the printing process. SDS must be readily accessible for review in the event of an emergency.
- Safety interlock switches must be enabled and working properly during printer operation.
- Operators must be protected from hot surfaces associated with the printers.
- If UV light is used in the curing process, personal protective equipment and/or shielding must be utilized to protect personnel.
- Turn off the printer if the printer nozzle jams, and allow the printer to ventilate before removing the cover.
- Maintain a safe distance from the printer to minimize the inhalation of emitted particles.

C. Engineering Controls

Particle emissions are the focus, especially when multiple printers are running simultaneously. Another consideration is toxic vapors that can be generated by heating

plastics. Engineering controls should be considered first to assist with minimizing hazards. These may include the following:

- Use 3D printers ONLY in properly ventilated areas.
- Choose low-emitting printers and feed materials/filament when possible.
- Purchase and use the manufacturers supplied controls, such as an interlocked enclosure. (Enclosures appear to be more effective at controlling emissions than just a machine cover.)

V. Personal Protective Equipment (PPE)

- Follow all PPE recommendations found in the Safety Data Sheet (SDS) for the specific printer media used.
- Eye protection is required during any activity where airborne projectiles may be present (i.e. cutting off rough edges of a printed item).
- A spill kit capable of neutralizing the caustic components of the alkaline bath solution shall also be available, by the department, in the area.

VI. Training and Recordkeeping

It is the responsibility of each department to ensure that their employees receive the required training. All users working directly with a 3D printer and associated media are required to have a minimum of annual hazard communication (HAZCOM) training covering any hazardous materials used in the process. Training can be provided by the Environmental Health and Safety department.

Completion of the training must be documented in writing with the records maintained by the department of the printing operations.