Material: iglidur® I170-PF

1) General

The material iglidur® I170-PF, developed by igus®, was developed and tested solely for the "Fused-Deposition-Modeling" (FDM) manufacturing method. As such iglidur® I170-PF is more challenging to process than iglidur® I180-PF.

2) Example processing parameters

The optimal processing parameters depend on various printing-conditions. Therefore the recommended temperature-fields are:

- Nozzle temperature: 240 – 260 °C
- Bed temperature: 90 – 110 °C

3) Adhesion

Standard procedures which are used to assure adhesion (of standard ABS materials) on the printing bed can be applied.

The following methods were so far successfully tested:

- Blue-Tape (e.g. Scotch 2090) glued glass and apply glue (e.g. Pritt Power) on it
- Perforated plate (e.g. dot matrix board made of hard paper without Cu coating)
- Permanent printing plates

4) Further processing instructions:

When feeding the filament, the bends should not be too tight, i.e. the radius should not be less than 50 mm.

Please ensure good ventilation or suction during processing. In addition, please wear appropriate protective gear when handling the hot melt.

If the friction-wheel revolves, it is recommended to reduce the "retract" at the settings from the "slicer".

The material may not be heated to a temperature higher than 280 °C. If the material is heated to a temperature above 300 °C, dangerous decomposition products are released.

Based on the supplier's experience and the information provided by the supplier, the product has no adverse health effects if properly handled and used in accordance with the intended purpose.