

iGlide I180-PF

iglide® I180-PF

Print Settings	
Extruder Temperature	250°C
Bed Temperature	115°C
Bed Preparation	Clean with isopropyl alcohol before and after every print.
Cooling Fan	Off
Closed Chamber	Yes
Heated Chamber	Yes
Chamber Temperature	60°C
Notes	<ul style="list-style-type: none"> iGlide I18-PF is usually used along with another build material. In that case, the print style (loops, infill, skin, etc.) can be driven by the other material.

Material Management	
Drying	Temperature <ul style="list-style-type: none"> 60°C Dry Time <ul style="list-style-type: none"> Heat only → 6 hours Heat + Vacuum → 2 hours
Recommended Support Material	<ul style="list-style-type: none"> SSU00
Storage	<ul style="list-style-type: none"> Moisture free container.
Compatible Materials	<ul style="list-style-type: none"> ASA

Slicer Settings	KISSlicer (0.4mm)	SSI (0.4mm)
Material Profile Name	IGUS I180-PF (0.4)	IGUS 180-PF
Layer Height	0.175 – 0.225 mm	0.175 – 0.225 mm
Loops	0.4	0.4
Skin	10.5	10.5
Infill	20 %	20 %

Chemical Resistance Table

Resistance classes:

+	0	-	x	
resistant	limited resistance	not resistant	no data existing	+ 1) The bearings are not chemically affected by these substances. However, their dimensions may change due to moisture absorption.

0	Grease, synthetic
+	Heptane
+	Hexachlorobenzene
X	Hexachloroethane
X	Hexamethylphosphoric acid triamide
+	Hexane
X	Humic acids
0	Hydroquinone (aq.), 5%
-	Hydrochloric acid, 10%
+	Hydrochloric acid, 2%
-	Hydrofluoric acid (aq.), 4%

X	Hydrofluorosilicic acid (aqueous), 30%
X	Hydrogen chloride gas
+	Hydrogen peroxide, 0.5%
-	Hydrogen peroxide, 30%
X	Hydrogen sulfide (aq.)
+	Hydrogen sulfide (dry)
+	India Ink
X	Inert gases (argon, helium, neon)
+	Ink, printing ink
-	Iodine tincture, 3%
-	Iron(III) chloride (aqueous), acidic, 10%

+	Iron(III) chloride (aq.), neutral, 10%
+	Isooctane, 80%
+	Isopropyl alcohol = isopropanol
-	Isopropyl ether
X	Ketones (aliphatic)
+	Lactic acid, 10%
+	Lactic acid, 90%
+	Lead acetate (aq.), 10%
+	Lead stearate
+	Linseed oil
+	Lithium bromide/chloride/salts (aq.), 50%

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X	Lithium chloride in alcohol, 20%
+	Magnesium chloride (aq.), 10%
+	Magnesium hydroxide (aqueous)
X	Maleic acid (aqueous), 10%
0	Maleic acid, concentrated solution
X	Malt
X	Manganese sulfate (aqueous), 10%
+	Mercury
+	Mercury chloride, 6%
X	Methane
0	Methanol
-	Methanol +20% CaCl ₂ or LiCl
X	Methyl acetate
-	Methyl ethyl ketone
X	Methylamine
-	Methylene chlorid
+	Milk
X	Molasses
X	Molykote-lubrication grease
X	Mortar, cement, lime
0	Naphthalene
X	Naphthalenesulfonic acid
X	Nickel salts (aqueous), 10%
0	Nitric acid (aq.), 2%
-	Nitric acid (aq.), 5%
X	Nitriloacetic acid
X	Nitro paint hazard class A I
X	Nitro paint hazard class A II
-	Nitrobenzene
X	Nitrogen oxides (dry)
X	Nitromethane
X	Nitrotoluene
X	Nitrous gases
X	Octane
+	Oil, cooking
+	Oleic acid
-	Oleum
+	Oxalic acid (aq.), 10%
+	Oxygen gas +23 °C/73.4 °F, without pressure
+	Ozone
+	Palmitic acid
+	Paraffin oil
X	Paraffins
-	Perchlorethene
-	Perchloric acid, 10%
X	Perfumes

-	Phenol (aq.), 6%
X	Phenol (aq.), 88%
-	Phenol (spirituous), 70%
+	Phosphoric acid (aq.), 0.3%
0	Phosphoric acid (aq.), 10%
+	Phosphoric acid (aq.), 3%
+	Phthalic acid, saturated solution
-	Polyester resins (with styrene)
+	Potassium bromide (aq.), 10%
+	Potassium carbonate (aq.), 60%
+	Potassium chloride (aq.), 10%
+	Potassium chloride (aq.), 90%
+	Potassium dichromate (aq.) 5%
+	Potassium nitrate (aq.), 10%
+	Potassium permanganate (aqueous), 1%
+	Potassium sulfate, saturated solution
-	Propane, propene
+	Propanol
X	Propenoic acid
-	Pyridine
-	Pyrocatechol (aq.), 6%
X	Pyruvic acid (aqueous), 10%
0	Resorcinol (1.3-Dihydroxybenzene), 50%
+	Salicylic acid
+	Seawater
+	Silicone oils
+	Silver nitrate
+	Soap suds
X	Soda lye (aq.), 10%
X	Soda lye (aq.), 50%
+	Soda solution, 10%
+	Sodium acetate (aqueous), 10%
0	Sodium bisulphite (aqueous), 10%
+	Sodium bromide (aq.), 10%
+	Sodium carbonate (aqueous), 21.5%
+	Sodium carbonate (aqueous), 50%
+	Sodium carbonate, 5%
X	Sodium chlorate (aq.), 10%
+	Sodium chloride, saturated solution
X	Sodium dichromate (aqueous), 10%
X	Sodium dodecyl benzenesulfonate

0	Sodium hypochlorite (aqueous), 10%
X	Sodium hypophosphite (aqueous), 10%
+	Sodium nitrate (aqueous), 10%
X	Sodium nitrotriacetate (aqueous), 10%
X	Sodium oleate
X	Sodium salts, 10%
+	Sodium sulfate, 10%
+	Sodium sulfite, neutral, 2%
+	Sodium thiosulfate, 10%
X	Soldering fluid
0	Steam
0	Sulfuric acid, 10%
0	Sulfuric acid, 2%
-	Sulfuric acid, concentrated, 98%
+	Sulphur
+	Tallow
0	Tar
+	Tartaric acid
-	Tetrahydrofuran (solvent)
-	Tetralin
-	Thionyl chloride
-	Toluol
0	Transformer oil
-	Trichlorethylene
X	Trichloroacetic acid (aq.), 50%
-	Trichloroethane
+	Triethanolamine, 90%
+	Trisodium phosphate, 90%
X	Uranium fluorides
+	Urea
X	Uric acid (aq.), 10%
+	Urine
0	Vaseline
X	Casein
X	Violet oil
X	Washing machine cleaner (phosphoric and nitric acids)
+	Water glass (sodium silicate)
+	Wax, melted
0	White spirit
-	Xylol
-	Zinc chloride (aq.), 10%
+	Zinc oxide
+	Zinc sulfate (aq.), 10%