

IC 131 Investment Casting

General Information

IC131 is formulated to work with DLP and SLA 3D printers using 385–405 nm light. It is specifically tuned to print on the Autodesk Ember printer. IC131 will extend the window lifetime of the Ember and other printers that use PDMS windows. IC131 produce reliable prints with high resolution that burn out cleanly. IC131 is offered in black.

Chemical Data

			Method
Viscosity (cps)	90		Brookfield SP #31
@25 °C			
	Fresh Print	Post-cured	
Tensile Modulus			
(mPa)	80	400	ASTM D 638-14
Tensile Strength			
(mPa)	4	4	ASTM D 638-14
Elongation			
(%)	8	4	ASTM D 638-14

**Parts were post-cured for 10min a side with a broad spectrum UV light at 30mW/cm².*

**Properties may vary in orientation and post-treatment.*

Recommended Ember Print Parameters for 50 µm

IC 131 is tuned to print with standard CMYK or PR48 print settings

Print parameters might require modification based on the geometry of the printed part.

Post Cure Procedure

For best results parts should be post cured under a broad band, UV light for 10 minutes on a side at 30 mW/cm²

Burnout Procedure

After thoroughly post curing the parts, the recommended cycle is:

- 150 °C for 2 hrs
- 450 °C for 5 hrs
- 750 °C for 3 hrs
- Casting temperature

Arkema Inc., 3D Printing Development Center
1880 S. Flatiron Ct STE J, Boulder, CO 80301

Please consult Arkema's disclaimer regarding the use of Arkema's products on <https://www.arkema.com/global/en/products/product-safety/disclaimer/>

Arkema - a French société anonyme, registered in the Nanterre (France) Trade and Companies Register under the number 319 632 790

arkema.com

ARKEMA