

ABS-Like Resin

iF3129

Suitable for industrial housing

Low shrinkage rate, the surface of the printed product is smooth, and the precision is high, which is suitable for the assembly of mechanical shells.



iF3129 Resin Material Properties Data

project	content	Data value	testing method
Physical and chemical properties (before curing)	colour	black/white/gray	
	viscosity	360-380mPa·s(@25°C)	ASTM D1084
	density	1.35±0.05g/cm ³	ASM D1875
Physical and chemical properties (after curing)	critical exposure	10-12mj/cm ³	
	shrinkage	≤1%	
	hardness(D)	75-80D	ASTM D2240
	elongation at break	13-15%	
	tensile strength	55~60MPa	
	bending strength	45-50MPa	
	high impact strength	320kj/m ²	
	Temperature resistance	110°C	

Remark:

- 2.Certain wear resistance, physical properties similar to engineering plastic ABS
- 3.Printing industrial parts, not easy to deform, good dimensional stability
- 4.Printed parts can be colored according to requirements
- 5.Linear shrinkage and volume reduction, high dimensional accuracy
- 6.Completely solidified, suitable for certain chemical environment
- 7.Low calorific value, no injury to the film
- 8.Matte color, more in line with the industrial printing parts of the appearance needs
- 9.Low smell, less skin irritation

Light source intensity comparison

Machine type	DLP	L4K Pro	CREALITY	ANYCUBIC (2k)
Relative light intensity	5	1	0.6	0.4

Print parameter recommendation form

Material model	Material Colour	Recommended thickness	Light source wavelength
iF3129	white	0.05mm	405nm

machine	Bottom exposure	Normal layer exposure	Top support diameter	Support diameter
LCD(4K Mono)	60s	4s	0.6~0.8mm	0.8~1.2mm
Anycubic mono X	35s	3s	0.6~0.8mm	0.8~1.2mm
DLP	5s	2.5s	0.6~0.8mm	0.8~1.2mm

Support density	Support angle	post-curing time (30W power)
50%	45%	3 min



Print parameter recommendation form

Material model	Material Colour	Recommended thickness	Light source wavelength
iF3129	Black	0.05mm	405nm

machine	Bottom exposure	Normal layer exposure	Top support diameter	Support diameter
LCD(4K Mono)	60s	10 (8~12) s	0.6~0.8mm	0.8~1.2mm
Anycubic mono X	35s	7 (6~8) s	0.6~0.8mm	0.8~1.2mm
DLP	5s	5.5s	0.6~0.8mm	0.8~1.2mm

Support density	Support angle	post-curing time (30W power)
50%	45%	3 min



Print parameter recommendation form

Material model	Material Colour	Recommended thickness	Light source wavelength
iF3129	Gray	0.05mm	405nm

machine	Bottom exposure	Normal layer exposure	Top support diameter	Support diameter
LCD(4K Mono)	60s	8 (8~10) s	0.6~0.8mm	0.8~1.2mm
Anycubic mono X	35s	6 (6~8) s	0.6~0.8mm	0.8~1.2mm
DLP	5s	5s	0.6~0.8mm	0.8~1.2mm

Support density	Support angle	post-curing time (30W power)
50%	45%	3 min

