

Notes on post processing F270 parts

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If F270 parts are soaked in the parts washer to remove support material the voids between the extruded material will be filled with rinse solution. When the part is washed with water some of the rinse solution will be replaced with water, but the part will be saturated with liquid. This liquid will continue to work its way out of the finished part over time. If the part is pressurized it can be blown out, but this is time consuming.

I did an experiment today heating 1" thick parts in a 60C oven for one hour. After that time no more liquid could be extracted using air.

The only problem that I encountered is that the oven shelf wires left a shallow impression on the parts. I recommend placing the parts on a piece of sheet metal.

This process should be included in the F270 SOP

1. Rinse part in parts washing tank for 8 hours at 70C. Parts with thin support may be cleaned in a much shorter time, and parts with deep thin holes may take longer.
2. Rinse part in water for several minutes to remove rinse solution
3. Place the part in a 70C oven for one hour on a flat aluminum plate