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Subject: Printing tubes?

Posted by [Piers](#) on Tue, 18 Dec 2012 19:36:13 GMT

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Recently I designed some flowers posted here

The stems i designed are simple tubes with internal diameter of 2.1mm , wall thickness is 1.1mm. The tube has printed correctly. It appears to have a hole running all the way through (I can drill to the length of the bit , and the material removed was in powder form).

After a few different attempt im still unsuccessful in removing the powder deeper within the tube.

My question is :

What is the minimum internal diameter for not only printing a tube but being able to clear it with ease?

Since SLS parts have a somewhat hydrophobic effect would bathing in something like Isopropanol help loosen the powder more?

Kind regards

Oh i got a new camera, and took this photo ..... shame to waste it

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#### File Attachments

1) [rose.jpg](#), downloaded 225 times

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Subject: Re: Printing tubes?

Posted by [Youknowwho4eva](#) on Tue, 18 Dec 2012 20:09:25 GMT

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I like the Shapeways underneath I'd try maybe some compressed air?

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Subject: Re: Printing tubes?

Posted by [Piers](#) on Wed, 19 Dec 2012 07:59:50 GMT

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Hey Micheal

I tried compressed air with no luck.....that said if i had a finer nozzle on the air gun (something similar to a can of compressed air or a WD40), lowered the PSI and tried that way it may work. Will give it a go.

Since i havent figured out the stems I used the Shapeways box to hold the fiber optics in place and block any unwanted light.....worked surprisingly well

Thanks

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Subject: Re: Printing tubes?

Posted by [Youknowwho4eva](#) on Wed, 19 Dec 2012 14:52:02 GMT

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Yea, that's what I would get. A can of compressed air. Maybe try a pipe cleaner? The tiny ones you can find at a craft store or something.

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Subject: Re: Printing tubes?

Posted by [Piers](#) on Wed, 19 Dec 2012 17:55:55 GMT

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Havent tried them but I assume that if a .5mm wire cant shift the blockage.

I forgot to take them into work today so will test the Isopropanol to see if it can loosen the powder and then try the pipe cleaner idea.

Thanks Micheal

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Subject: Re: Printing tubes?

Posted by [stannum](#) on Thu, 20 Dec 2012 03:05:59 GMT

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Some people reported freezing allowed them moving apparently stuck parts. Maybe it works for holes too.

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Subject: Re: Printing tubes?

Posted by [mfoster3](#) on Thu, 13 Feb 2014 16:52:34 GMT  
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I have a similar issue with parts that I've designed that have a couple of inches of .020" spaced surfaces that are intended to slide relative to one another. When I received the printed parts they were as if welded together. I soon realized that it was tightly compacted powder between the parts that was preventing them from moving. Compressed air didn't seem to have an affect. I was able to dislodge the powder using thin spring steel wire that I had on hand that is available from McMaster-Carr. I would like to find a better method such as the a fore mentioned freezing to help loosen up the powder as the finished parts will be in a more complex assembly that will be more difficult access. Any addition details about the freezing method would be appreciated.

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