

Technical Data Sheet

Ultrafuse® Support Layer

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Version No.: 1.0

General information

Components

Polyoxmethylen based composite filament for Ultrafuse® Metal Fused Filament Fabrication.

Product Description

Ultrafuse® Support Layer filament developed to be used in combination with Ultrafuse® Metal Filaments. When printed between support and the object, it creates a barrier during sintering and facilitates the separation of support from the metal part. Ultrafuse® Support Layer is not developed to print stand-alone parts and should be printed as a layer attached to the support structures in dual extrusion prints.

Delivery form and warehousing

Ultrafuse® Support Layer filament should be stored at 15 - 25°C in its originally sealed package in a clean and dry environment. If the recommended storage conditions are observed the products will have a minimum shelf life of 12 months.

Product safety

A small amount of formaldehyde is formed during the printing of Ultrafuse® Support layer, therefore the filament should only be printed in a well ventilated room or with a professional extraction/filter system. Process within recommended range of temperature. For further and more detailed information please consult the corresponding material safety data sheets.

For your Information

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Recommended 3D-Print processing parameters

Nozzle Temperature	245 – 260 °C / 473 – 500 °F
Build Chamber Temperature	Passively heated, closed chamber
Bed Temperature	-
Bed Material	-
Nozzle Diameter	≥ 0.4 mm
Print Speed	15 - 20 mm/s

Drying Recommendations

Drying recommendations to ensure printability	Ultrafuse® Support Layer is in a printable condition, drying is not necessary
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Filament Properties

Filament Diameter	1.75 mm	2.85 mm
Tolerance	±0.050 mm	±0.075 mm
Roundness	±0.050 mm	±0.075 mm
Length per Spool	90 m	32 m
Weight per Spool	0.3 kg	0.3 kg