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# Technical Data Sheet

# Ultrafuse® Support Layer

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## 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 |

| 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 |