

Technical Data Sheet

Ultrafuse® Support Layer

Date / Revised: 19.10.2022

Version No.: 1.1

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

This product is not intended for sale, distribution or use in the US and Canada and is not available to our customers in those countries.

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Filament Properties

Filament Diameter	1.75 mm	2.85 mm
Diameter Tolerance	±0.050 mm	±0.1 mm
Roundness	±0.050 mm	±0.05 mm
Available Spool size	0.3 kg	0.3 kg
Available colors	natural	

Spool Properties

Available Spool size	0.3 kg
Outer diameter	200 mm
Inner diameter	50.5 mm
width	55 mm

Recommended 3D-Print processing parameters

Printer	FFF printer
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

Please check your print profile availability for an easy start at www.forward-am.com.

Further Recommendations

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