



# Bilby 3D

## **MATERIAL DATA SAFETY SHEET**

Issued in Australia by Bilby 3D Pty Ltd.

The attached Material Data Safety Sheet has been prepared by the manufacturer outside Australia.

In accordance with Australia WHS regulations the following Australian contact details apply

### **Section 1: AUSTRALIAN COMPANY DETAILS**

In Australia the product is imported and distributed by:  
Bilby 3D Pty Ltd

Mailing Address :

Kingsgrove Business Centre, 7/192 Kingsgrove Rd, Kingsgrove NSW 2208

Head Office Address :

Kingsgrove Business Centre, 7/192 Kingsgrove Rd, Kingsgrove NSW 2208

Contact Phone: 1800 847 333

### **Section 2: AUSTRALIAN EMERGENCY CONTACT**

#### **Emergency Contact**

In the event of an emergency please contact:

Poisons Information Centre 24 hour Telephone Advice Line on 13 11 26

### **Section 3: AUSTRALIAN ISSUE DATA**

**Date of Issue** : 1 March 2020

# 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.

### Notice

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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](http://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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