Tech. Data Sheet
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# LAY-a-WAY support filament

experimental



| | | HIGH-T-LAY | LAY-a-PVA | LAY-Cloud | ETHYL-LAY |
|---|---|---|---|---|---|
| print speed | 8 - 100 mm/sec | all | all | all | all |
| first layer | 8 – 30 mm/sec | all | all | all | all |
| perimeter | 8 - 100 mm/sec | all | all | all | all |
| infill | 8 - 100 mm/sec | all | all | all | all |
| bridges | > 30 mm/sec | all | all | all | all |
| gap fill | 8 - 100 mm/sec | all | all | all | all |
| layer height | 0,15 – 0,5 mm | all | all | all | all |
| soluble in | | goes brittle in H2O, use brush | cpl in H2O | cpl in H2O | cpl in ethyl-alcohol (spririt) |
| extrusion temp. | | 240°C | 230°C | 235 - 245°C | 165°C |
| | | | | | |
| print plattform | | 90°C, or cold! | 60°C, or cold! | 70°C, or cold! | 30°C, or cold! |
| build room | | max. 100°C | max. 60°C | max. 70°C | max. 50°C |
| elongation at break filament: | | Inaccurate | Inaccurate | Inaccurate | Inaccurate |
| tensile strength: filament: | | Inaccurate | Inaccurate | Inaccurate | Inaccurate |
| density filament: | | 1,13 | 1,22 | 1,16 | 1,0 |
| humidity: | store dry | | | | |
| dry in oven | | max 90°C | max 60°C | max 80°C | max 45°C |
| availability | 1,75/2,85 | all | all | all | all |
| | | | | | |
| sticks at plattform with | HIPS, ABS-laque, hair-spray, glue sticks, 3d-lack | | | | |
| knowledge | to prevent warping: remove large parts not before cooling down to 20°C, use cool spray to | | | | |
| Printer: | Prusa, Delta-style, Ultimaker, Kühling-K.; GermanRepRap; Stratasys hack; etc. | | | | |
| safety: | no special requirements / see MSDS | | | | |
| content: | Polymerblend on base of thermoplastics | | | | |