

**LAY-a-WAY** support filament

experimental

<p><b>HIGH-T-LAY</b></p> <ul style="list-style-type: none"> <li>• for hot build room 100C, printT ~240C</li> <li>• fast dissolve in water</li> <li>• forget HIPS-Limonene stink</li> <li>• remove flaky residue with brush</li> </ul>	<p><b>LAYaPVA</b></p> <ul style="list-style-type: none"> <li>• best print viscosity, printT ~230C</li> <li>• stabile at long tool-change periods</li> <li>• improved thermal stability</li> <li>• very fast dissolvable</li> </ul>
<p><b>ETHY-LAY</b></p> <ul style="list-style-type: none"> <li>• dissolve restless with alcohol</li> <li>• total clear, cold platform</li> <li>• for sensitive bio prints</li> <li>• print-temp. 165C</li> </ul>	<p><b>LAY-CLOUD</b></p> <ul style="list-style-type: none"> <li>• dedicated for flexible prints</li> <li>• best polyurethane adhesion</li> <li>• cloudy residue, simply drops</li> <li>• printT ~240+-5C</li> </ul>

**LAY-AWAY** support series

- HIGH-T-LAY**  
for hot build room 100C  
forget HIPS-Limonene stink
- ETHY-LAY**  
dissolve with alcohol  
total clear
- LAYaPVA**  
fastest dissolve
- LAY-CLOUD**  
for flexible prints

		<b>HIGH-T-LAY</b>	<b>LAY-a-PVA</b>	<b>LAY-Cloud</b>	<b>ETHYL-LAY</b>
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 (spirit)
extrusion temp.		240°C	230°C	235 - 245°C	165°C
print platform		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 platform with knowledge	HIPS, ABS-laquer, hair-spray, glue sticks, 3d-lack to prevent warping: remove large parts <u>not</u> 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				