

Material data sheet

voxeljet 3D printers

Plastic

Base material	PMMA particle material (55 µm)	› Can be used for prototypes, illustrative models or lost models
Binder-type	Polypor B	
Tensile strength	≥ 2.0 MPa	› Precise layering & high accuracy
Yield point	1 %	
Burn-out temperature	700 °C	› Components of high complexity
Residual ash content	< 0.01 weight %	
Especially suited for	investment casting; design models	› Economical production in batch sizes of one as well as in series production
Advantages	sharp edges; for highest accuracy and true-to-detail; reusable particle material	

Technical data plastic parts

Layer thickness	100 - 150 µm
Resolution x, y	up to 600 dpi
Accuracy	± 0.4 % (min. ± 0.3 mm)

Suitable finishing treatment

	Wax	Epoxy
Tensile strength	see base material	up to 25 MPa
Softening temp.	73 °C	80 °C
Burn out temp.	see base material	-
Characteristics	smooth liquid, resistant surface	solid material, dyeable

Sand

Base material	silica sand	silica sands of various grain sizes	› Any hybrid design and combination with conventional molds
Binder-type	Phenolic resin	Cold hardening furan resin	
Bending strength	250 - 500 N/cm ²	≥ 220 N/cm ² (depending on the sand or binder)	› Complex cores manufactured and reproduced in one piece
Loss on ignition	adjustable (1.8 - 2.4 weight %)	1.5 weight %	
Especially suited for	Sand casting of almost all alloys, especially steel or iron alloys.	Sand casting of almost all alloys.	› High flexibility with regard to quantity and mold design
Advantages	low gas shock, sand almost 100% recyclable, easy unpacking and highest edge sharpness.	Largest build volumes, fast build rates, most widely used.	

Technical data sand parts

Layer thickness	200 - 300 µm; standard 300 µm
Resolution x, y	up to 300 dpi
Accuracy	± 0.1 % (min. ± 1.5 layer thickness)

- › Close-to-production mold and casting properties
- › Economical from prototype to small series production