

SECTION 1 - IDENTIFICATION

COMPANY ADDRESS:
 The Virtual Foundry, Inc
 1471 US HWY 51
 Stoughton, WI 53589
 USA

PRODUCT NAME: Basalt Moon Dust Filamet™

SECTION 2 - TYPICAL MATERIAL PROPERTIES

| Physical Properties | Unit | Value |
|---------------------|------|-------------|
| Ceramic Content | % | 60.0 - 62.0 |

SECTION 3 - FILAMENT SPECIFICATIONS

| Nominal Diameter | Diameter Tolerance | Ovality | Net Filament Weight |
|------------------|--------------------|---------|------------------------|
| 1.75mm | ± 0.05mm | ≥ 95% | 1000 / 500 / 250 grams |
| Pellets | - | - | 1000 grams |

SECTION 4 - GUIDELINES FOR PRINTING

| | |
|--|---|
| Advised Printing Temperature | 190 - 230°C (374 - 446°F) For high speed printers: 235 - 250°C (455 - 482°F) |
| Advised Build Plate Temperature | 40 - 65°C (104 - 149°F) (Optional) 65°C (149°F) is recommended for glass/G10 build plates |
| Build Plate Surface Type | Powder coated spring steel, glass, G10, blue painter's tape |
| Build Plate Preparation | Powder Coated Spring Steel: No preparation required Glass/G10: Clean with IPA, print at 65°C (149°F) PEI/PC/Fiberglass/Acrylic/Other: Blue painter's tape |
| Print Cooling | Recommended for small details/intricate parts |
| Advised Printing Speed | 60 - 80mm/sec For high speed printers: 120 - 130mm/sec |
| Advised Flow Rate | 120 - 135% |
| Nozzle Size/Type | 0.6mm Hardened Steel |

SECTION 5 - ADDITIONAL INFORMATION

This filament is abrasive and will wear standard brass nozzles fast. The Virtual Foundry, Inc recommends a hardened steel nozzle. Gem tipped, stainless steel, titanium and tungsten nozzles have been tested and found to wear quickly.

