

## SECTION 1 - IDENTIFICATION

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

**PRODUCT NAME:** High Carbon Iron Filamet™

## SECTION 2 - TYPICAL MATERIAL PROPERTIES

Physical Properties	Unit	Value
Filament Density	g/cc	2.90 – 3.85
Metal Content	%	75.0 – 80.0

## SECTION 3 - FILAMENT SPECIFICATIONS

Nominal Diameter	Diameter Tolerance	Ovality	Net Filament Weight
1.75mm	± 0.05mm	≥ 95%	1000 / 500 grams
2.85mm	± 0.05mm	≥ 95%	1000 / 500 grams
Pellets	-	-	1000 grams

## SECTION 4 - GUIDELINES FOR PRINTING

<b>Advised Printing Temperature</b>	190 – 230°C (374 – 446°F) For high speed printers: 235 – 250°C (455 – 482°F)
<b>Advised Build Plate Temperature</b>	40 – 65°C (104 – 149°F) (Optional) 65°C (149°F) is recommended for glass/G10 build plates
<b>Build Plate Surface Type</b>	Powder coated spring steel, glass, G10, blue painter's tape
<b>Build Plate Preparation</b>	Powder Coated Spring Steel: Ensure surface is clean and free of debris Glass/G10: Clean with IPA, print at 65°C (149°F) Other: Blue painter's tape
<b>Print Cooling</b>	Recommended for small details/intricate parts
<b>Advised Printing Speed</b>	60 – 80mm/sec For high speed printers: 120 – 150mm/sec
<b>Advised Flow Rate</b>	110 – 125%
<b>Nozzle Size/Type</b>	0.6mm Hardened Steel

