

# ees 3D

# PRIMASELECT™ METAL

## Why should I use PrimaSELECT™ METAL?

- Easy to print
- Contains 80% real metal for a genuine look and feel
- Works on most 3d-printers
- PLA based
- Easy to polish and post process
- Can print with retraction



\* Please see our website for latest options and colors available.



## PRIMASELECT™ METAL

PrimaSELECT Metal is a new exciting type of filament which let you take 3D-printing to a new level. In this new material we have introduced a filament that contains 80% metal powder! Needless to say, this material is as close to real metal as you can come in the filament industry for FDM/FFF printers. SELECT Metal is available in Bronze and Copper.

There's many benefits by using metal powder. You will experience a real "metal feel" when you touch it and it also have that "cold" feeling that you can have when you touch copper or bronze. When it comes to weight SELECT Bronze/Copper is about 3-4 times heavier than regular PLA which also enhances the feeling of real metal. Thanks to the metal powder there's also very low shrinkage when printing with this filament.

You can use SELECT Bronze/Copper in almost any FDM printer on the market today and the filament has been tested in a number of different set ups with both Bowden and direct drive printers. Due to the abrasive nature of metal we recommend that you use a hardened steel nozzle\* with this filament. It prints great with a regular brass nozzle also but the wear and tear is bigger and the risk for wearing out your nozzle increases.

## COLORS AVAILABLE



COPPER

BRONZE



# PRIMASELECT™ METAL

## INFORMATION:

SELECT Bronze/Copper works great without a heated bed, but if you have it we recommend a setting of 35-60 °C Post –processing is really fun with this filament as you can make it look just like a cast molded model. When the print is done it is looks almost like clay, but then you can use some techniques to bring out that metal gloss. A rotary tumbler is the easiest way of handling the finished print. You can just tumble it for a few hours or until you have the finish you are looking for.

You can also use some fine grit sand paper (600) and polish your print to desired finish. Polish the model with sand paper and water. The longer you polish, the better the shine. You can finish with some metal polish for that perfect look.

PrimaSELECT™ Metal sticks on BuildTak or glass plate coated with adhesive spray or glue stick.

PrimaSELECT™ Metal is reeled on a transparent spool with 500 g of high quality filament. It's packed in a sturdy box and packed with silica gel to avoid moisture.

PrimaSELECT™ Metal are available in diameter sizes of 1.75 mm and 2.85 mm.

\* Please consider the use of a hardened steel nozzle when printing with PrimaSELECT Bronze/Copper. The Bronze/Copper powder inside makes the filament abrasive and will result in fast wear of regular brass nozzles.



## DIMENSIONS

Size:	Ø tolerance	Roundness
1,75 mm	±0,05 mm	≥ 95 %
2,85 mm	±0,10 mm	≥ 95 %

## PHYSICAL PROPERTIES

Description:	Testmethod	Typical value
Specific gravity	ASTM D1505	1,20 g/cc/td>
Tensile strength	ASTM D882	70 MPa (MD)
100 MPa (TD)		
Elongation at break	ASTM D882	170% (MD)
110% (TD)		
Tensile modulus	ASTM D882	1900 MPa (MD)
2300 Mpa (TD)		
Impact strength	-	7,0 KJ/m <sup>2</sup>

## THERMAL PROPERTIES

Description:	Testmethod	Typical value
Printing temp.	PF	210-235 °C
Melting temp.	-	150 °C ± 10 °C
Melting point	ASTM D3418	140-150 °C
Vicat softening temp.	ISO 306	±45 °C

Our state of the art factory is equipped with the latest in laser measuring technology to ensure that you will receive a spool of filament with a very tight diameter and roundness tolerance.

This in turn makes for a filament that is compatible with most common printers on the market today.