

Technical datasheet

colorFabb DPA-100

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The soluble support material colorFabb DPA-100 was specifically developed for the use in fused filament fabrication (FFF). The FFF printer must be able to process several materials. This support material was developed especially for processing in interaction with qualitatively high-calibre copolyester materials such as our nGen, colorFabb_XT and colorFabb_HT in professional 3D printers. Furthermore, colorFabb DPA-100 is also ideally suited as a support material for ABS, ASA or PC/ABS.

Unlike when HIPS functions as the support material, to dissolve the support structure you do not need any foul-smelling, expensive solvent that must be disposed of as dangerous waste. Instead of this, colorFabb DPA-Detergent, our specially developed detergent, provides the opportunity to dissolve colorFabb DPA-100 in water. The detergent, dissolved in water, produces a mild alkaline which usually, together with the dissolved support material, can (in limited quantities) be disposed of via the waste water. Please check your local regulations.

TYPICAL MATERIAL PROPERTIES

Physical properties	Unit	Value
Density	g/cm ³	1,1
Melt volume flow rate (MVR) at 220°C, 10 kg	cm ³ /10 min	20
Glass transition temperature	°C	112
Solubility in water		No
Solubility in colorFabb DPA-Detergent		Yes
Minimum pH value for dissolution		>10

FILAMENT SPECIFICATION

Nominal diameter:	Diameter tolerance	Ovality
1,75 mm	± 0,05	≥ 95%
2,85 mm	± 0,05	≥ 95%

Netto filament weight 750 grams / 2200 grams

GUIDELINE FOR PRINT SETTINGS

Advised 3D printing temperature	230 – 270 °C
Advised bed temperature	90 – 110 °C
Bed surface / modification	PI or PEI (“Kapton” or “Ultem”), ABS, PC
Active cooling fan	0 - 25 % (generally 0%)
Advised 3D printing speed	40 – 80 mm/sec

Disclaimer

The product- and technical information provided in this datasheet is correct to the best of our knowledge. The information given is provided as a guidance for good use, handling and processing and is not to be considered as a quality specification. The information only relates to the specific product and the material properties.