

# LAYBRICK

**CALCIUM CARBONATE, CO-POLYESTERS, AND PLASTICIZERS - KAI PARTHY**



**Pre and Post Processing**

Laybrick sticks well to a cool blue tape bed. Some care must be taken while inserting filament, as it is extremely brittle. To ameliorate this, use a hair dryer or hot air gun to soften the filament slightly before inserting.

Laybrick can be finished by sandpaper and/or rubbing with isopropyl alcohol.



**HAZARDS (rating 1-10)**

Generally harmless, although ventilation is still recommended.

<b>SETTINGS TO PRINT WITH</b>	<b>PRIME/UNPRIME:</b>	
<ul style="list-style-type: none"> <li>Temp Range: 165-210°C</li> <li>Recommended flow multiplier: 1.000</li> <li>Recommended layer size: .15-.2</li> <li>Build Plate Temp: Off, with blue tape</li> <li>Recommended Fan: 100%</li> </ul>	<p>Steps: 340</p> <p>Rate: 10,000</p> <p>Time (ms): 25</p> <p>Primes after Tool Change: 1</p>	<p>Steps: 310</p> <p>Rate: 10,000</p> <p>Time (ms): 20</p> <p>Primes after Tool Change: 1</p>
<b>HOW WELL IT HANDLES PRINTS</b>	<b>PROPERTIES OF MATERIAL</b>	
<p>Overhangs: 25°</p> <p>Retraction: 4</p> <p>Circles: 4</p> <p>Layer change: 5</p> <p>Fine detail: 3</p> <p>Curling: 5</p>	<p>Modulus of Elasticity:</p> <p>Yield Strength:</p> <p>Fracture Point:</p> <p>Modulus of Elasticity in Bending:</p> <p><i>All parts done with a ___% infill</i></p>	



CHEMICAL/RESISTANCE						
Chemical	Water	Vinegar	HCl	Acetone	HF	Sulfuric Acid
Resistance (High/Limited/None)				None		
Chemical	Aqua Regia	Bleach	Gasoline	Methyl Alcohol	Ethyl Alcohol	NaOH
Resistance (High/Limited/None)				Limited	Limited	



*Images (Left to right, top to bottom): Single walled vase, Artifact/Feature size test, Retraction/Feature size test, arch, top of overhang test, bottom of overhang test.*

*Overhang: Minimum angle to the horizontal at which layers are relatively unperturbed.*

*Print handling parameters: 5-optimal, 4-very good, 3-fair, 2-passable, 1-very poor*

*Chemical Resistance: High-no observable affect after a long period of time, Limited-Slight affects over time (swelling, discoloration, slight softening, etc), None-very severely affected by chemical.*



NOTES:

Since Laybrick dissipates very slowly, it is recommended to leave a printed part on the bed for 2-4 hours to cool before removing; otherwise you may damage the part.

After printing with Laybrick, it is suggested to purge the melt chamber with another filament to avoid clogs. This can be done by simply removing the Laybrick filament and inserting an ABS or PLA filament and extruding about 30mm of that.