

# Organic-Direct-Binding

## ODB



**2,000 mm**  
build space

**up to 200 dpi**  
Resolution x, y

**± 0,1 %**  
Accuracy

### Advantages of sand molds

- › Large format 3D printing with dimensions of up to 2,000 x 1,000 x 1,000 mm (LxWxH)
- › Variable hybrid approaches and combination with conventional molds
- › Close-to-production mold and casting properties
- › All common casting alloys processable
- › Complex cores can be manufactured in one piece and reproduced reliably and accurately
- › Mold design with integrated sprue system possible
- › Cost-effective production from prototypes to small batches
- › High flexibility in terms of required quantities and mold design

#### Material data

Material	Silica sand
Designation	GS 15, GS 19
Medium grain size	150 µm, 190 µm
Applications	Molds and cores for casting

#### Technical data

Build space up to	2,000 x 1,000 x 1,000 mm
Binder type	Cold-curing furan resin
Layer height	300 µm
Accuracy	+0.1 % (min. +1.5* layer height)
Loss on ignition	approx. 2.5 % weight. %
Bending strength	≥220 N/cm <sup>2</sup> (depending on sand or binder)
Resolution x, y	up to 200 dpi
Recycling	possible up to 30 %*

\*sand recycling can influence the strength of the components