

eSUN Cleaning Filament

- Appearance: white translucent
- Uses: Cleans the extruder's interior by removing accumulated residual filaments while the cleaning rod passes through the extruder.

- **Advantages:**

1. Good heat stability, passes normally through the extruder under the temperature range of 150–260°C when carrying out temperature trials of cleaning filament on the 3D printer, indicating that a wide range of temperatures can be used for cleaning.
2. Possesses a certain level of adhesive quality, allowing the removal of residual filaments to prevent the clogging of the extruder by carbonized residual filaments.
3. Does not easily disintegrate or break down at high temperatures, will not clog extruder even if it stays in the extruder for long periods of time.
4. During the interchange of filaments with different extrusion temperatures, using the cleaning filament as an intermediary filament to pass through the extruder can prevent low extrusion temperature filaments from disintegrating and clogging the extruder as the extruder temperature increases; similarly, it can prevent high-extrusion temperature filaments from cooling and solidifying inside the extruder as the extruder temperature decreases.

- **Usage Instructions:**

1. Cleaning filament can be used both before and after printing. Before using the cleaning filament, first ensure that the extruder temperature is maintained at the previous filament's extrusion temperature. Insert 1–2 cleaning filament into the extruder and allow the accumulated residual filament to completely exit the extruder. Once this step is completed, filament direction can be reversed to remove the cleaning filament.
2. Cleaning filament can also be used as an intermediary filament between different filament types (of different extrusion temperatures, or of different colors). After printing using filaments with high/low extrusion temperature, first ensure that the extruder temperature is maintained at the previous filament's extrusion temperature. Insert 1–2 cleaning filament into the extruder and allow the accumulated residual filament to completely exit the extruder. Once this step is completed, filament direction can be reversed to remove the cleaning filament. The extruder

temperature can then be decreased/increased to that of the next filament to be used, respectively. Note: Before using the cleaning filament, first ensure that the extruder temperature is maintained at the previous filament's extrusion temperature. After using the cleaning filament, filament direction can be reversed to remove the cleaning filament.

3. Main applications of cleaning filament:

- I. To clean the 3D printer's extruder before and after printing.
- II. To function as an intermediary filament between different filament types with different extrusion temperatures.
- III. To function as an intermediary filament between the same filament type with different colors.
- IV. To function as an intermediary filament between different filament types with wide differences in composition, color etc.

eSUN is a premium filament manufacturer and has been providing OEM services for many top brands. ESUN is the best Filament Brand in China with very high quality standard. ESUN has been awarded 2014 China 3D Printing Filament First-Choice Brand. We stand behind our promise on quality and customer satisfaction. INTSERVO is authorized distributor of ESUN brand.

- **Why you should choose ESUN brand?**

1. eSUN filament has very good temperature stability. This is very important in order to print out smoother, prettier product.
2. eSUN filament has very strict quality inspection standard. This ensures that our product has no defect and very stable and consistent quality.
3. eSUN uses only pure, new raw materials. No recycled materials are used.
4. eSUN leads the filament industry on innovation. We are the ONLY manufacturer of PVA filament. We just announced 3D printer cleaning filament. We have more innovations coming.
5. eSUN filament is SGS certified.
6. eSUN filament products are clean, dry, with high quality spool and neatly packaged.