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(54) Titre : FILAMENTS A BASE DE MATERIAU D'AME REVETU
(54) Title: FILAMENTS BASED ON A COATED CORE MATERIAL

(57) **Abrégé/Abstract:**

The invention relates to a filament comprising a core material (CM) comprising an inorganic powder (IP) and the core material (CM) is coated with a layer of shell material (SM) comprising a thermoplastic polymer. Further, the invention relates to a process for the preparation of said filament, as well as to three-dimensional objects and a process for the preparation thereof.

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(54) Title: FILAMENTS BASED ON A COATED CORE MATERIAL

(57) Abstract: The invention relates to a filament comprising a core material (CM) comprising an inorganic powder (IP) and the core material (CM) is coated with a layer of shell material (SM) comprising a thermoplastic polymer. Further, the invention relates to a process for the preparation of said filament, as well as to three-dimensional objects and a process for the preparation thereof.

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Filaments based on a coated core material

Description

5 The invention relates to a filament comprising a core material (CM) comprising an inorganic powder (IP) and the core material (CM) is coated with a layer of shell material (SM) comprising a thermoplastic polymer. Further, the invention relates to a process for the preparation of said filament, as well as to three-dimensional objects and a process for the preparation thereof.

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One of the most used 3D printing technologies or additive manufacturing technology is the fused deposition modeling (FDM), also known as fused filament fabrication process (FFF). For the production of three-dimensional objects, usually filaments of thermoplastic materials, provided on a spool, are deposited layer-by-layer through a
15 heated nozzle on a base. Therefore, the thermoplastic material is heated to a temperature past its melting and/or glass transition temperature. The thermoplastic material and the temperature gradient are selected in order enable its solidification essentially immediately upon contacting the base or a preceding layer of thermoplastic material extruded.

20

In order to form each layer, drive motors are provided to move the base and/or the extrusion nozzle (dispensing head) relative to each other in a predetermined pattern along the x-, y- and z-axis. Fused deposition modeling (FDM) was first described in US 5,121,329. Typical materials for the production of three-dimensional objects are
25 thermoplastic materials. The production of three-dimensional metallic or ceramic objects by fused filament fabrication is only possible if the metal or ceramic material has a low melting point so that it can be heated and melted by the nozzle. If the metal or ceramic material has a high melting point, it is necessary to provide the metal or ceramic material in a binder composition to the extrusion nozzle. The binder
30 composition usually comprises a thermoplastic material. When depositing the mixture of a metal or ceramic material in a binder on a base, the formed three-dimensional object is a so called „green body“ which comprises the metal or ceramic material in a binder. To receive the desired metallic or ceramic object, the binder has to be removed and finally the object has to be sintered. However, the use of filaments comprising an
35 inorganic powder and a binder coated with a shell material (SM) comprising a thermoplastic polymer is not mentioned.

US 5,738,817 and US 5,900,207 describe a fused deposition modeling process for making a three-dimensional article by using a mixture of a particulate composition
40 dispersed in a binder. The particulate composition comprises ceramic materials, elemental metals, metal alloys and/or steels. The binder consists of a polymer, a wax,

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an elastomer, a tackifier and a plasticizer. The binder is removed from the article by a burnout cycle during which the article is slowly heated to cause some of the components of the binder system to melt and flow out of the article. After these components are removed from the article, the temperature is increased and the other
5 components of the binder are thermally decomposed and are removed from the article by diffusion and evaporation. This step d) process is very time consuming. Furthermore, the melting of the binder before evaporation leads to distortion of the article and moreover, the high temperatures may lead to blistering on the surface or internal cracking and/or delamination of the article. The application of filaments
10 comprising an inorganic powder and a binder coated with a shell material (SM) comprising a thermoplastic polymer is not disclosed.

US 2012/0033002 describes a process for the preparation of three-dimensional thermomagnetic objects by fused filament fabrication using a mixture of a
15 thermomagnetic powder and a binder system. This binder system comprises polymers like polyesters, polysulfones, poly(ether sulfones) and styrene copolymers. After the printing of the three-dimensional object, the binder has to be removed. For this step d) step, very high temperatures are necessary. The high temperatures that are necessary for the step d) step may, as stated above, lead to blistering on the surface of the three-
20 dimensional object, internal cracking and/or delamination of the article. Filaments comprising a core material (CM) coated with a layer of shell material (SM) are not mentioned.

US 2012/0231225 discloses filaments for use in an extrusion-based additive
25 manufacturing system. These filaments comprise a core portion of a first thermoplastic polymer and a shell portion of a second thermoplastic polymer that is compositionally different from the first thermoplastic material. In some embodiments of the filaments disclosed in US 2012/0231225, the material of the core portion and the shell portion exhibit different crystallization temperatures. This difference in crystallization
30 temperatures is desired, since it “reduces distortions, internal stresses, and sagging of the semi-crystalline polymeric materials when deposited as extruded roads to form layers of 3D models.” Inorganic materials are not involved in any of the filaments mentioned.

35 EP 15 152 349.5 describes the use of a mixture comprising an inorganic powder and a binder in a fused filament process and to a process for producing three-dimensional objects by a fused filament fabrication process. However, a filament comprising a core material and an additional shell material is not disclosed.

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WO 2015/077262 A1 discloses filaments as 3D printer inputs comprising separated layers or sections. These layers may comprise different materials, such as polymers, carbon fiber, fiber glass, wood fiber, nanocellulose fiber or carbon nanotubes. But WO 2015/077262 A1 does not disclose the combination of an inorganic powder and at least
 5 one binder as core material and at least one thermoplastic polymer as shell material.

The object underlying the present invention is to provide new filaments for an application in an extrusion-based additive manufacturing system.

10 This object is achieved by a filament comprising a core material (CM) coated with a layer of shell material (SM), wherein

the core material (CM) comprises the components a) to c)

- 15 a) 30 to 80% by volume, based on the total volume of the core material (CM) of at least one inorganic powder (IP),
 b) 20 to 70% by volume, based on the total volume of the core material (CM) of the at least one binder b) comprising component b1)

20 b1) at least one polymer (P)

- c) 0 to 20% by volume, based on the total volume of the core material (CM) of the at least one additive (A),

25 and the shell material(SM) comprises the components d) to f)

- d) 75 to 100% by volume, based on the total weight of the shell material (SM) of at least one thermoplastic polymer (TP)
 e) 0 to 20% by volume, based on the total volume of the shell material (SM) of the
 30 at least one inorganic powder (IP),
 f) 0 to 25% by volume, based on the total volume of the shell material (SM) of the at least one additive (A), wherein the thickness of the layer of shell material (SM) is 0.05 to 0.5 mm.

35 One advantage of the inventive filaments is their higher mechanical stability compared to filaments prepared from the same core material (CM) but without the shell material (SM). In particular, the inventive filaments can be rolled on a spool, while filaments without shell material (SM) are usually too brittle and therefore are not suited to be spooled.

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Since the mechanical properties and therefore the processability of the inventive filaments in a conventional machine for a fused filament fabrication process (FFF)are

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mainly determined by the shell material (SM), there is more freedom of variation in regard to the composition of the core material (CM) compared to filaments without a shell material (SM). For example, the inventive shell material (SM)-core material (CM) configuration allows for the use of significantly higher loads of inorganic powder in the core material (CM) or ultra-low viscosity binders and/or additives in the core material (CM) that could result in a more brittle core. Without a layer of shell material (SM) according to the invention it was not possible to consistently feed highly brittle material in the conventional machines used in the fused filament fabrication process (FFF). Furthermore, it is also possible that the inventive filaments exhibit a tacky or extremely tacky core material (CM), which would without the presence of the shell material (SM) block the feeder mechanism. Consequently, by the inventive process filaments for the application in a fused filament fabrication process (FFF) can be realized, which obtain a core material (CM) of ultra-low viscosity or of extreme tackiness.

The core material (CM) shows a good flowability at the processing temperatures and at the shear rates used in a conventional Fused Deposition Modeling (FDM) process. Moreover, no demixing of the inorganic powder (IP) and the binder (B) of the core material (CM) occurs and usually no stress cracks arise during the hardening. Another advantage of the present invention is that the binder (B) can easily be removed at temperatures below the melting point of the binder (B), resulting in only little or even no deformation of the three-dimensional object.

In one embodiment of the invention Polyoxymethylene (POM) is present in the binder (B). Polyoxymethylene (POM) as component of the binder (B) exhibits a high crystallization rate and hardens quickly. Furthermore, polyoxymethylene (POM) is not known to be a sticky polymer as it has a low coefficient of friction.

Consequently, it is surprising that layers of the filament comprising an inorganic powder (IP) and a binder (B), which comprises polyoxymethylene (POM), adhere to each other, although polyoxymethylene (POM) has a low coefficient of friction and that as a consequence of this adherence the filament can be used in a fused deposition modeling (FDM) process using a layer-based additive technique.

The invention is specified in more detail as follows.

The filament comprises a core material (CM) coated with a layer of shell material (SM).

The filament may exhibit any length and/or diameter as deemed appropriate by the person skilled in the art.

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Preferably, the diameter of the filament is 1.5 to 3.5 mm, more preferably 2.0 to 3.1 mm, most preferably 2.6 to 3.0 mm.

The layer of shell material (CM) may have any thickness as deemed appropriate by the person skilled in the art.

Preferably, the thickness of the layer of shell material (SM) is 0.05 to 0.5 mm, more preferably 0.09 to 0.3 mm, most preferably 0.1 to 0.25 mm.

The core material (CM) may have diameter as deemed appropriate by the person skilled in the art.

Preferably the diameter of the core material is 1.5 to 3.0 mm, more preferably 1.9 to 2.7 mm, most preferably 2.2 to 2.7 mm.

The core material (CM) comprises the components a) to c).

The core material (CM) comprises as component a) 30 to 80 % by volume, preferably 40 to 68 % by volume, more preferably 50 to 65% by volume, based on the total volume of the core material (CM), of at least one inorganic powder (IP).

The terms “component (a)” and “inorganic powder (IP)” for the purpose of the present invention are synonymous and are used interchangeably throughout the present invention.

As component a), any known inorganic powder (IP) can be used. Preferably, a sinterable inorganic powder (IP) is used as component a). More preferably, the inorganic powder (IP) is a powder of at least one inorganic material selected from the group consisting of a metal, a metal alloy and a ceramic material, most preferably the at least inorganic powder is a metal or a metal alloy, particularly preferably, the at least inorganic powder is a metal.

Another subject of the present invention is therefore a filament, wherein the inorganic powder (IP) is a powder of at least one inorganic material selected from the group consisting of a metal, a metal alloy and a ceramic material, preferably the at least inorganic powder is a metal or a metal alloy, particularly preferably, the at least inorganic powder is a metal.

“An inorganic powder (IP)” means precisely one inorganic powder (IP) as well as a mixture of two or more inorganic powders (IP). The same holds true for the term “an inorganic material”. “An inorganic material” means precisely one inorganic material as well as mixtures of two or more inorganic materials.

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“A metal” means precisely one metal as well as mixtures of two or more metals. A metal within the present invention can be selected from any metal of the periodic table of the elements which is stable under the conditions of a fused filament fabrication process and which can form three-dimensional objects. Preferably, the metal is selected from the group consisting of aluminium, yttrium, titanium, zirconium, vanadium, niobium, chromium, molybdenum, tungsten, manganese, iron, carbonyl iron powder (CIP), cobalt, nickel, copper, silver, zinc and cadmium, more preferably, the metal is selected from the group consisting of titanium, niobium, chromium, molybdenum, tungsten, manganese, iron, carbonyl iron powder (CIP), nickel and copper. With particular preference, the metal is selected from the group consisting of titanium, iron and carbonyl iron powder (CIP).

Carbonyl iron powder (CIP) is highly pure iron powder, prepared by chemical decomposition of purified iron pentacarbonyl.

“A metal alloy” means precisely one metal alloy as well as mixtures of two or more metal alloys. Within the context of the present invention, the term „metal alloy“ means a solid solution or a partial solid solution, which exhibits metallic properties and comprises a metal and another element. “A metal” means, as stated above precisely one metal and also mixtures of two or more metals. The same applies to “another element”. “Another element” means precisely one other element and also mixtures of two or more other elements.

Solid solution metal alloys exhibit a single solid phase microstructure while partial solid solution metal alloys exhibit two or more solid phases. These two or more solid phases can be homogeneous distributed in the metal alloy, but they can also be heterogeneous distributed in the metal alloy.

The metal alloys can be prepared according to any process known to the person skilled in the art. For example, the metal can be melted and the other element can be added to the molten metal. However, it is also possible, to add the metal and the other element directly to the core material (CM) without the preparation of a metal alloy before. The metal alloy will then be formed during the process of the preparation of the three-dimensional object.

Concerning the metal, the above-stated embodiments and preferences for the metal apply.

The other element can be selected from the metals described above. However, the other element differs from the metal comprised in the metal alloy.

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The other element can be selected from any element of the periodic table, which forms a metal alloy that is stable under the conditions of a fused filament fabrication process or, which is stable or forms stable alloys with the metal under the conditions of a fused filament process. In a preferred embodiment of the present invention the other element
5 is selected from the group consisting of the aforementioned metals, boron, carbon, silicon, phosphorous, sulfur, selenium and tellurium. Particularly preferably, the at least one other element is selected from the group consisting of the aforementioned metals, boron, carbon, silicon, phosphorous and sulfur.

10 Preferably, the metal alloy according to the present invention comprises steel.

“A ceramic material” means precisely one ceramic material as well as mixtures of two or more ceramic materials. In the context of the present invention, the term „ceramic material“ means a non-metallic compound of a metal or a first metalloid, and a non-
15 metal or a second metalloid.

“A metal” means precisely one metal and also mixtures of two or more metals. The same relies to “a non-metal” and “a first metalloid”, as well as “a second metalloid”. “A non-metal” means precisely one non-metal and also mixtures of two or more non-
20 metals. “A first metalloid” means precisely one first metalloid and also mixtures of two or more first metalloids. “A second metalloid” means precisely one second metalloid and also mixtures of two or more second metalloids.

Non-metals are known per se to the person skilled in the art. The non-metal according
25 to the present invention can be selected from any non-metal of the periodic table. Preferably, the at least one non-metal is selected from the group consisting of carbon, nitrogen, oxygen, phosphorus and sulfur.

Metalloids are as well known per se to the skilled person. The first metalloid and the
30 second metalloid can be selected from any metalloid of the periodic table. Preferably, the first metalloid and/or the second metalloid are selected from the group consisting of boron and silicon. It should be clear that the first metalloid and the second metalloid differ from each other. For example, if the first metalloid is boron, then the second metalloid is selected from any other metalloid of the periodic table of the elements
35 besides boron.

In one embodiment of the present invention, the ceramic material is selected from the group consisting of oxides, carbides, borides, nitrides and silicides. In a preferred embodiment the ceramic material is selected from the group consisting of MgO, CaO,
40 SiO₂, Na₂O, Al₂O₃, ZrO₂, Y₂O₃, SiC, Si₃N₄, TiB and AlN. Particularly preferred, the ceramic material is selected from the group consisting of Al₂O₃, ZrO₂ and Y₂O₃.]

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For the preparation of the inorganic powder (IP), the inorganic material has to be pulverized. To pulverize the inorganic material, any method known to the person skilled in the art can be used. For example, the inorganic material can be ground. The grinding for example can take place in a classifier mill, in a hammer mill or in a ball mill.

5

The carbonyl iron powder (CIP) is prepared by chemical decomposition of purified iron pentacarbonyl.

The particle sizes of the inorganic powders (IP) used as component a) are preferably from 0.1 to 80 μm , particularly preferably from 0.5 to 50 μm , more preferably from 0.1 to 30 μm , measured by laser diffraction.

Another subject of the present invention is therefore a filament, wherein the particle size of the inorganic powder (IP) is from 0.1 to 80 μm .

15

The core material comprises (CM) comprises as component b) 20 to 70 % by volume, preferably 20 to 60% by volume, more preferably 20 to 50% by volume, based on the total volume of the core material (CM), of at least one binder (B).

20 The terms “component b)” and “binder (B)” for the purpose of the present invention are synonymous and are used interchangeably throughout the present invention.

The binder (B) comprises a component b1) which is at least one polymer (P).

25 Preferably, the binder (B) comprises 50 to 96% by weight, more preferably 60 to 90% by weight, most preferably 70 to 85% by weight of the at least one polymer (P), based on the total weight of the binder (B), as component b1).

Preferably, the at least one polymer (P) is a polyoxymethylene (POM).

30

As component b1), at least one polyoxymethylene (POM) may be used. “At least one polyoxymethylene (POM)” within the present invention means precisely one polyoxymethylene (POM) and also mixtures of two or more polyoxymethylenes (POM).

35 For the purpose of the present invention, the term “polyoxymethylene (POM)” encompasses both, polyoxymethylene (POM) itself, i. e. polyoxymethylene (POM) homopolymers, and also polyoxymethylene (POM) copolymers and polyoxymethylene (POM) terpolymers.

40 Polyoxymethylene (POM) homopolymers usually are prepared by polymerization of a monomer selected from a formaldehyde source (b1a).

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The term “formaldehyde source b1a) relates to substances which can liberate formaldehyde under the reaction conditions of the preparation of polyoxymethylene (POM).

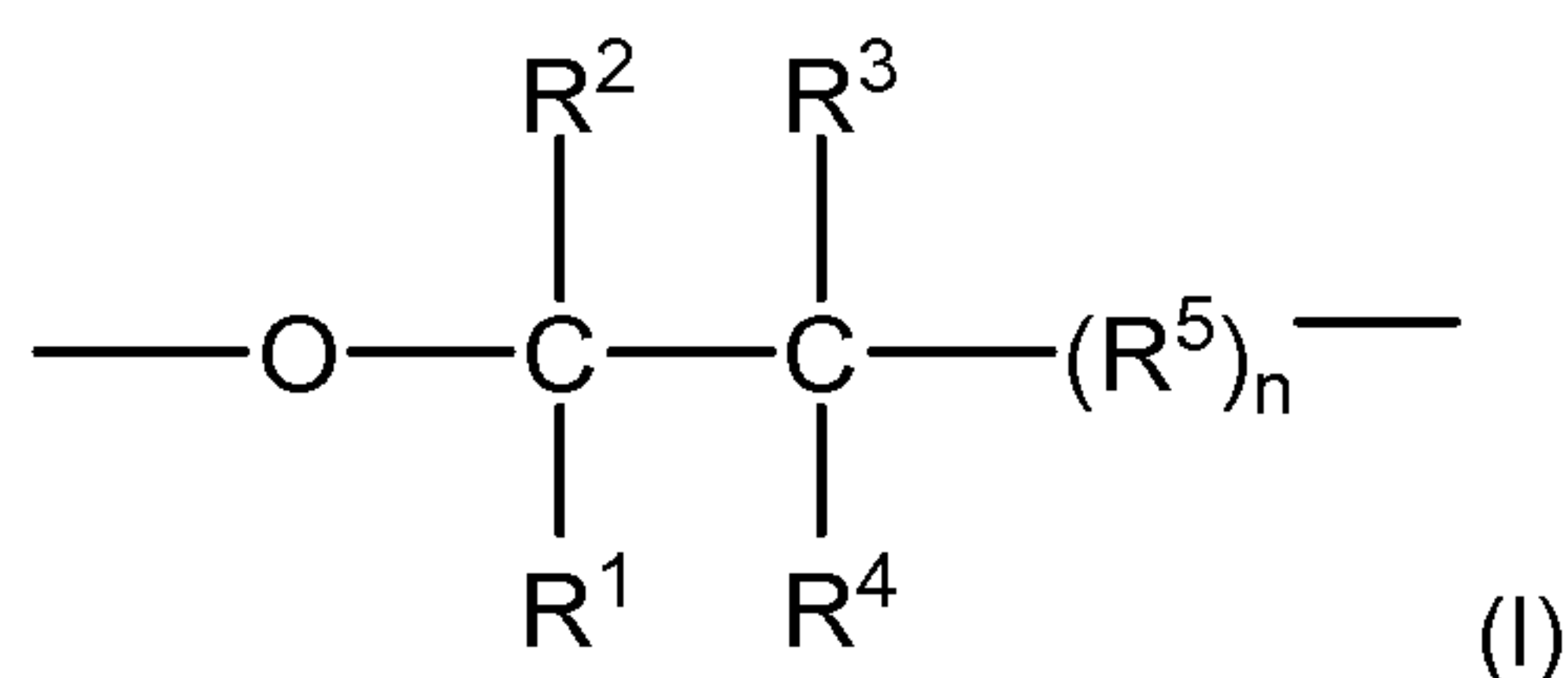
- 5 The formaldehyde sources b1a) are advantageously selected from the group of cyclic or linear formals, in particular from the group consisting of formaldehyde and 1,3,5-trioxane. 1,3,5-trioxane is particularly preferred.

10 Polyoxymethylene (POM) copolymers are known per se and are commercially available. They are usually prepared by polymerization of trioxane as main monomer. In addition, comonomers are concomitantly used. The main monomers are preferably selected from among trioxane and other cyclic or linear formals or other formaldehyde sources b1a).

- 15 The expression “main monomers” is intended to indicate that the proportion of these monomers in the total amount of monomers, i. e. the sum of main monomers and comonomers, is greater than the proportion of the comonomers in the total amount of monomers.

20 Quite generally, polyoxymethylene (POM) according to the present invention has at least 50 mol-% of repeating units $-\text{CH}_2\text{O}-$ in the main polymer chain. Suitable polyoxymethylene (POM) copolymers are in particular those which comprise the repeating units $-\text{CH}_2\text{O}-$ and from 0.01 to 20 mol-%, in particular from 0.1 to 10 mol-% and very particularly preferably from 0.5 to 6 mol-% of repeating units of the formula (I),

25



wherein

- 30 R^1 to R^4 are each independently of one another selected from the group consisting of H, C_1 - C_4 -alkyl and halogen-substituted C_1 - C_4 -alkyl;
 R^5 is selected from the group consisting of a chemical bond, a $(-\text{CR}^{5a}\text{R}^{5b}-)$ group and a $(-\text{CR}^{5a}\text{R}^{5b}\text{O}-)$ group,

35 wherein

R^{5a} and R^{5b} are each independently of one another selected from the group consisting of H and unsubstituted or at least monosubstituted C_1 - C_4 -alkyl,

10

wherein the substituents are selected from the group consisting of F, Cl, Br, OH and C₁-C₄-alkyl;

5 n is 0, 1, 2 or 3.

If n is 0, then R⁵ is a chemical bond between the adjacent carbon atom and the oxygen atom. If R⁵ is a (-CR^{5a}R^{5b}O-) group, then the oxygen atom (O) of the (-CR^{5a}R^{5b}O-) group is bound to another carbon atom (C) of formula (I) and not to the oxygen atom
10 (O) of formula (I). In other words, formula (I) does not comprise peroxide compounds. The same holds true for formula (II).

Within the context of the present invention, definitions such as C₁-C₄-alkyl, as for example defined above for the radicals R¹ to R⁴ in formula (I), mean that this
15 substituent (radical) is an alkyl radical with a carbon atom number from 1 to 4. The alkyl radical may be linear or branched and also optionally cyclic. Alkyl radicals which have both a cyclic component and also a linear component likewise fall under this definition. Examples of alkyl radicals are methyl, ethyl, n-propyl, iso-propyl, butyl, iso-butyl, sec-butyl and tert-butyl.

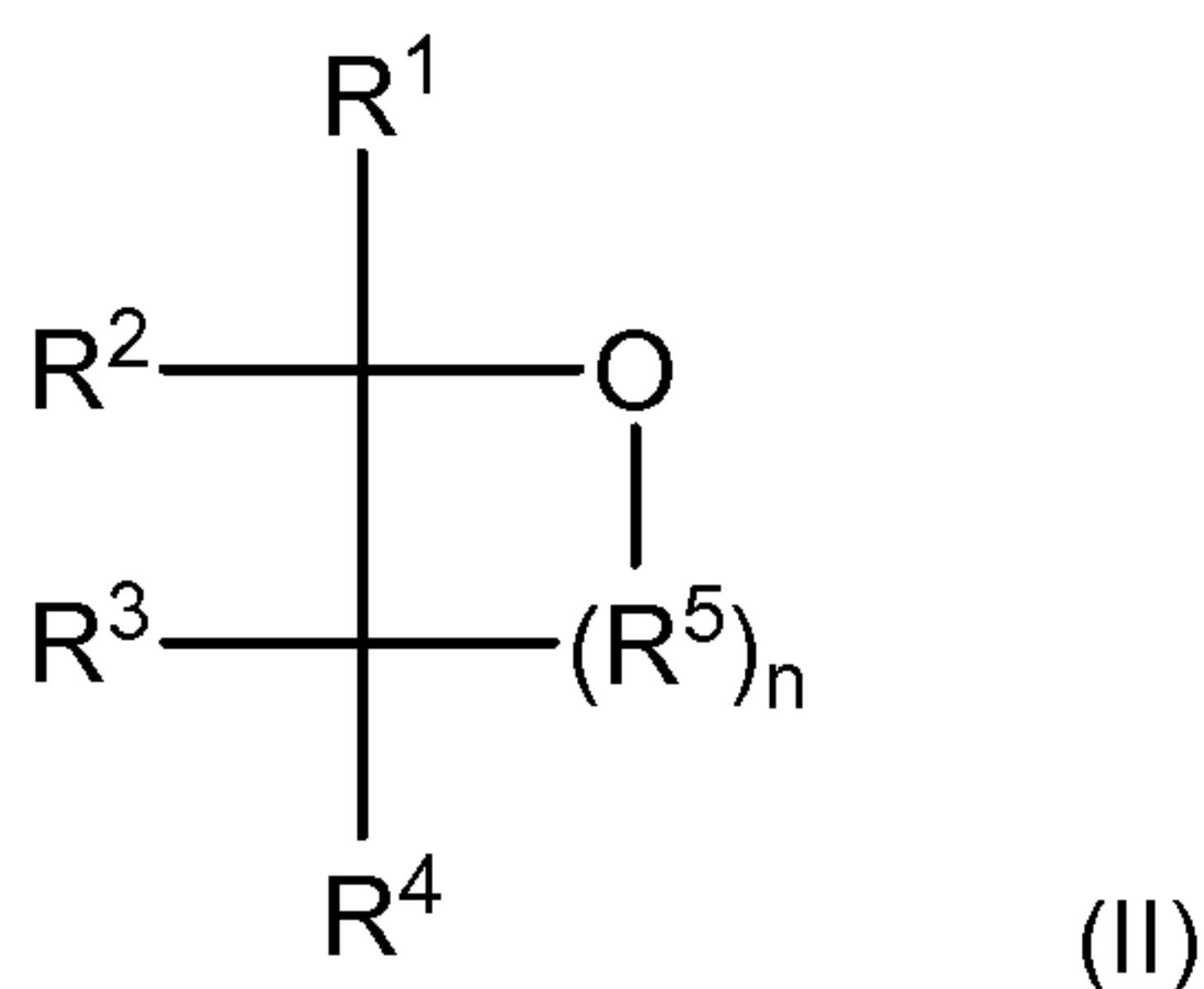
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In the context of the present invention, definitions, such as halogen-substituted C₁-C₄-alkyls, as for example defined above for the radicals R¹ to R⁴ in formula (I), mean that the C₁-C₄-alkyl is substituted by at least one halogen. Halogens are F (fluorine), Cl (chlorine), Br (bromine) and I (iodine).

25

The repeating units of formula (I) can advantageously be introduced into the polyoxymethylene (POM) copolymers by ring-opening of cyclic ethers as first comonomers (b1b). Preference is given to first comonomers (b1b) of the general
formula (II),

30



wherein

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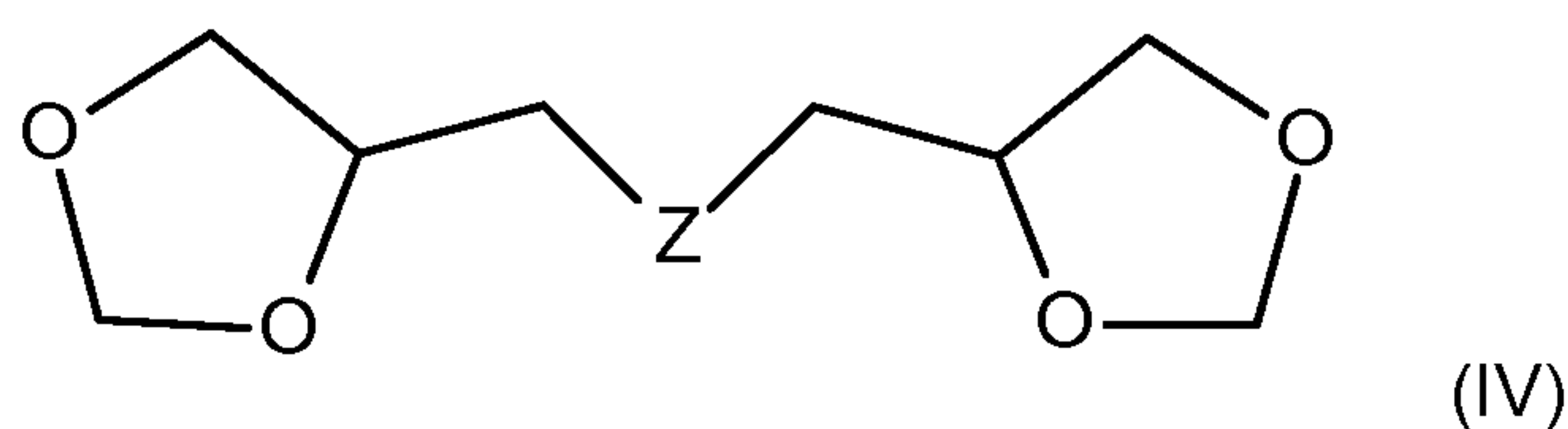
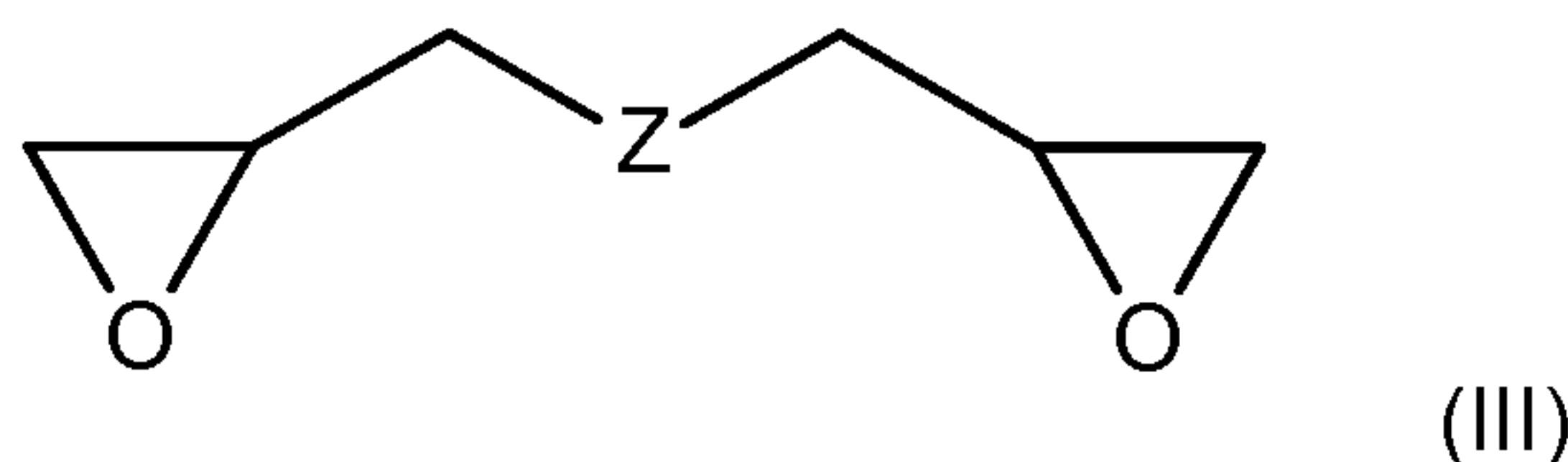
R¹ to R⁵ and n have the meanings as defined above for the general formula (I).

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As first comonomers (b1b) mention may be made for example of ethylene oxide, 1,2-propylene oxide, 1,2-butylene oxide, 1,3-butylene oxide, 1,3-dioxane, 1,3-dioxolane and 1,3-dioxepane (= butanediol formal, BUFO) as cyclic ethers and also linear oligoformals or polyformals such as polydioxolane or polydioxepane. 1,3-dioxolane and 1,3-dioxepane are particularly preferred first comonomers (b1b), very particular preferred is 1,3-dioxepane as first comonomer (b1b).

Polyoxymethylene (POM) polymers which can be obtained by reaction of a formaldehyde source together with the first comonomer (b1b) and a second comonomer (b1c) are likewise suitable. The addition of the second comonomer (b1c) makes it possible to prepare, in particular, polyoxymethylene (POM) terpolymers.

The second comonomer (b1c) is preferably selected from the group consisting of a compound of formula (III) and a compound of formula (IV),



20

wherein

Z is selected from the group consisting of a chemical bond, an (-O-) group and an (-O-R⁶-O-) group,

25

wherein

R⁶ is selected from the group consisting of unsubstituted C₁-C₈-alkylene and C₃-C₈-cycloalkylene.

30

Within the context of the present invention, definitions such as C₁-C₈-alkylene means C₁-C₈-alkanediyl. The C₁-C₈-alkylene is a hydrocarbon having two free valences and a carbon atom number of from 1 to 8. The C₁-C₈-alkylene according to the present invention can be branched or unbranched.

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Within the context of the present invention, definitions such as C₃-C₈-cycloalkylene means C₃-C₈-cycloalkanediyle. A C₃-C₈-cycloalkylene is a cyclic hydrocarbon having two free valences and a carbon atom number of from 3 to 8. Hydrocarbons having two free valences, a cyclic and also a linear component, and a carbon atom number of from 3 to 8 likewise fall under this definition.

Preferred examples of the second comonomer (b1c) are ethylene diglycidyl, diglycidyl ether and diethers prepared from glycidyl compounds and formaldehyde, dioxane or trioxane in a molar ratio of 2 : 1 and likewise diethers prepared from 2 mol of a glycidyl compound and 1 mol of an aliphatic diol having from 2 to 8 carbon atoms, for example the diglycidyl ether of ethylene glycol, 1,4-butanediol, 1,3-butanediol, 1,3-cyclobutanediol, 1,2-propanediol and 1,4-cyclohexanediol.

In a preferred embodiment component b1) is a polyoxymethylene (POM) copolymer which is prepared by polymerization of from at least 50 mol-% of a formaldehyde source, from 0.01 to 20 mol-% of at least one first comonomer (b1b) and from 0 to 20 mol-% of at least one second comonomer (b1c).

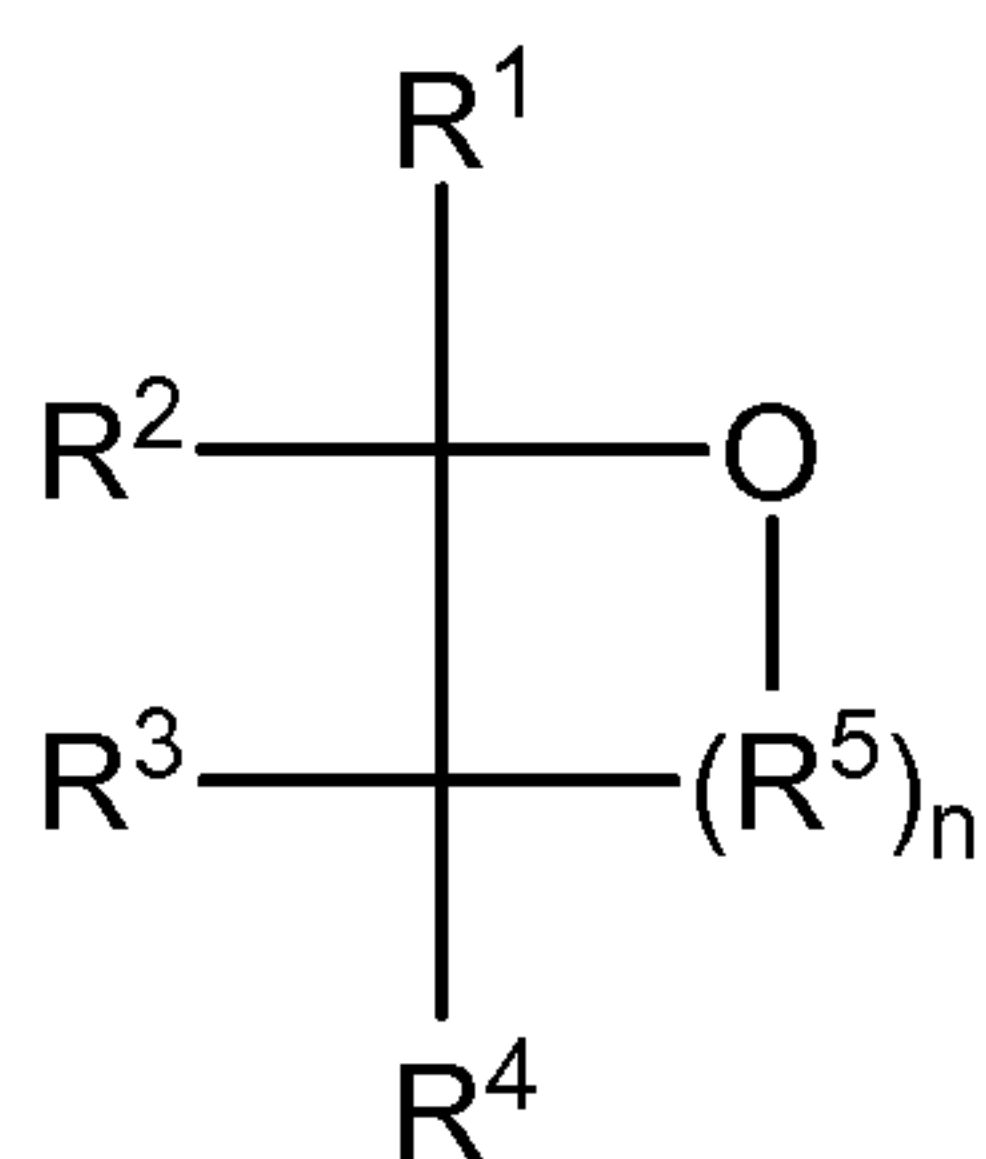
In a particularly preferred embodiment component (b1) is a polyoxymethylene (POM) copolymer which is prepared by polymerization of from 80 to 99.98 mol-%, preferably from 88 to 99 mol-% of a formaldehyde source, from 0.1 to 10 mol-%, preferably from 0.5 to 6 mol-% of at least one first comonomer (b1b) and from 0.1 to 10 mol-%, preferably from 0,5 to 6 mol-% of at least one second comonomer (b1c).

In a further preferred embodiment component b1) is a polyoxymethylene (POM) copolymer which is prepared by polymerization of from at least 50 mol-% of a formaldehyde source, from 0.01 to 20 mol-% of at least one first comonomer (b1b) of the general formula (II) and from 0 to 20 mol-% of at least one second comonomer (b1c) selected from the group consisting of a compound of formula (III) and a compound of formula (IV).

Another subject of the present invention is therefore a filament, wherein component b1) is a polyoxymethylene (POM) copolymer which is prepared by polymerization of

- 35 - from at least 50 mol-% of a formaldehyde source (b1a),
- from 0.01 to 20 mol-% of at least one first comonomer (b1b) of the general formula (II)

13



(II),

wherein

5 R^1 to R^4 are each independently of one another selected from the group consisting of H, C_1 - C_4 -alkyl and halogen-substituted C_1 - C_4 -alkyl;

10 R^5 is selected from the group consisting of a chemical bond, a $(-CR^{5a}R^{5b}-)$ group and a $(-CR^{5a}R^{5b}O-)$ group,

wherein

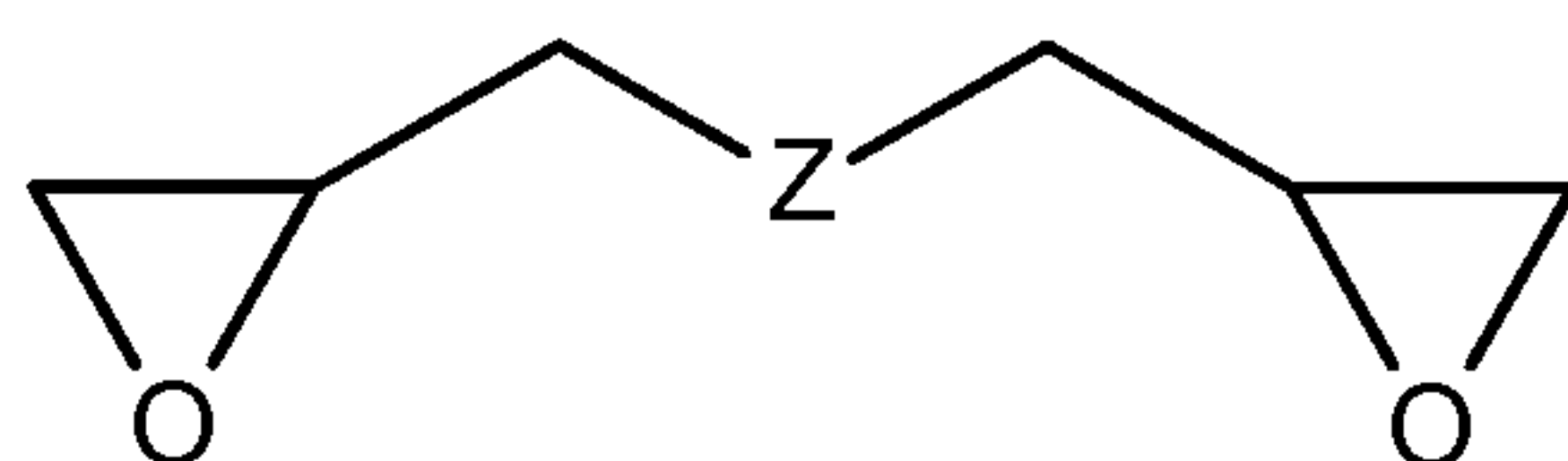
15 R^{5a} and R^{5b} are each independently of one another selected from the group consisting of H and unsubstituted or at least monosubstituted C_1 - C_4 -alkyl,

wherein the substituents are selected from the group consisting of F, Cl, Br, OH and C_1 - C_4 -alkyl;

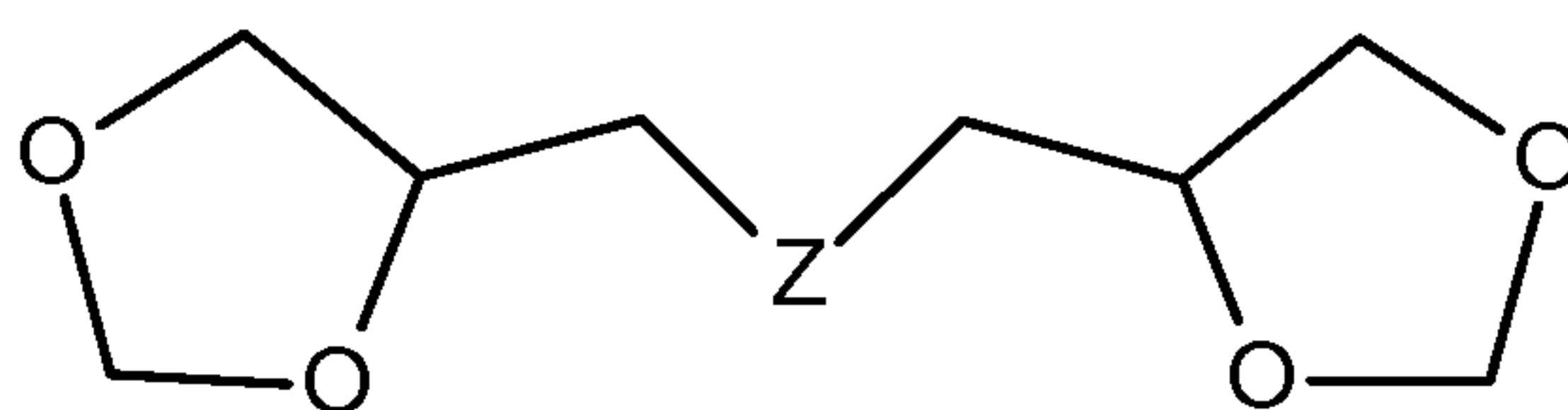
20 n is 0, 1, 2 or 3;

and

25 - from 0 to 20 mol-% of at least one second comonomer (b1c) selected from the group consisting of a compound of formula (III) and a compound of formula (IV)



(III),



(IV),

14

wherein

Z is selected from the group consisting of a chemical bond, an (-O-) group and an (-O-R⁶-O-) group,

5

wherein

R⁶ is selected from the group consisting of unsubstituted C₁-C₈-alkylene and C₃-C₈-cycloalkylene.

10

In a preferred embodiment of the present invention at least some of the OH-end groups of the polyoxymethylene (POM) are capped. Methods for capping OH-end groups are known to the skilled person. For example, the OH-end groups can be capped by etherification or esterification.

15

Preferred polyoxymethylene (POM) copolymers have melting points of at least 150°C and weight average molecular weights M_w in the range from 5 000 g/mol to 300 000 g/mol, preferably from 6 000 g/mol to 150 000 g/mol, particularly preferably in the range from 7 000 g/mol to 100 000 g/mol.

20

Particular preference is given to polyoxymethylene (POM) copolymers having a polydispersity (M_w/M_n) of from 2 to 15, preferably from 2.5 to 12, particularly preferably from 3 to 9.

25 The measurement of the weight average molecular weight (M_w) and the number average molecular weight (M_n) is generally carried out by gel permeation chromatography (GPC). GPC is also known as sized exclusion chromatography (SEC).

30 Methods for the preparation of polyoxymethylene (POM) are known to those skilled in the art.

Further, the binder (B) may comprise a component b2).

35 Preferably, the binder (B) comprises from 2 to 35% by weight, more preferably 3 to 20% by weight, most preferably 4 to 15% by weight of component b2).

Preferably component b2) is at least one polyolefin (PO). "At least one polyolefin (PO)" within the present invention means precisely one polyolefin (PO) and also mixtures of two or more polyolefins (PO).

40

15

Polyolefins (PO) are known per se and are commercially available. They are usually prepared by polymerization of C₂-C₈-alkene monomers, preferably by polymerization of C₂-C₄-alkene monomers.

- 5 Within the context of the present invention, C₂-C₈-alkene means unsubstituted or at least monosubstituted hydrocarbons having 2 to 8 carbon atoms and at least one carbon-carbon double bond (C-C-double bond). "At least one carbon-carbon double bond" means precisely one carbon-carbon double bond and also two or more carbon-carbon double bonds.

10

In other words, C₂-C₈-alkene means that the hydrocarbons having 2 to 8 carbon atoms are unsaturated. The hydrocarbons may be branched or unbranched. Examples for C₂-C₈-alkenes with one C-C-double bond are ethene, propene, 1-butene, 2-butene, 2-methyl-propene (= isobutylene), 1-pentene, 2-pentene, 2-methyl-1-butene, 3-methyl-1-butene, 1-hexene, 2-hexene, 3-hexene and 4-methyl-1-pentene. Examples for C₂-C₈-alkenes having two or more C-C-double bonds are allene, 1,3-butadiene, 1,4-pentadiene, 1,3-pentadiene, 2-methyl-1,3-butadiene (= isoprene).

If the C₂-C₈-alkenes have one C-C-double bond, the polyolefins (PO) prepared from those monomers are linear. If more than one double bond is present in the C₂-C₈-alkenes, the polyolefins (PO) prepared from those monomers can be crosslinked. Linear polyolefins (PO) are preferred.

It is also possible to use polyolefin (PO) copolymers, which are prepared by using different C₂-C₈-alkene monomers during the preparation of the polyolefins (PO).

Preferably, the polyolefins (PO) are selected from the group consisting of polymethylpentene, poly-1-butene, polyisobutylene, polyethylene and polypropylene. Particular preference is given to polyethylene and polypropylene and also their copolymers as are known to those skilled in the art and are commercially available.

The polyolefins (PO) can be prepared by any polymerization process known to the skilled person, preferably by free radical polymerization, for example by emulsion, bead, solution or bulk polymerization. Possible initiators are, depending on the monomers and the type of polymerization, free radical initiators such as peroxy compounds and azo compounds with the amounts of initiator generally being in the range from 0.001 to 0.5% by weight, based on the monomers.

The binder (B) may comprise a further polymer (FP) as component b3).

40

16

The terms “component b3)” and “further polymer (FP)” for the purpose of the present invention are synonymous and are used interchangeably throughout the present invention.

- 5 Preferably, the binder (B) comprises 2 to 40% by weight, more preferably 5 to 30% by weight, most preferably 10 to 26% by weight, based on the total weight of the binder (B), as component b3).

Component (b3) according to the present invention is at least one further polymer (FP).

- 10 “At least one further polymer (FP)” within the present invention means precisely one further polymer (FP) and also mixtures of two or more further polymers (FP).

As already stated above, the at least one further polymer (FP) differs from component (b1), the polyoxymethylene (POM), and component (b2), the polyolefin (PO).

15

According to the present invention, the at least one further polymer (FP) is preferably selected from the group consisting of a polyether, a polyurethane, a polyepoxide, a polyamide, a vinyl aromatic polymer, a poly(vinyl ester), a poly(vinyl ether), a poly(alkyl(meth)acrylate) and copolymers thereof.

20

Another subject of the present invention is therefore a filament , wherein the further polymer (FP) is at least one further polymer (FP) selected from the group consisting of a polyether, a polyurethane, a polyepoxide, a polyamide, a vinyl aromatic polymer, a poly(vinyl ester), a poly(vinyl ether), a poly(alkyl (meth)acrylate) and copolymers thereof.

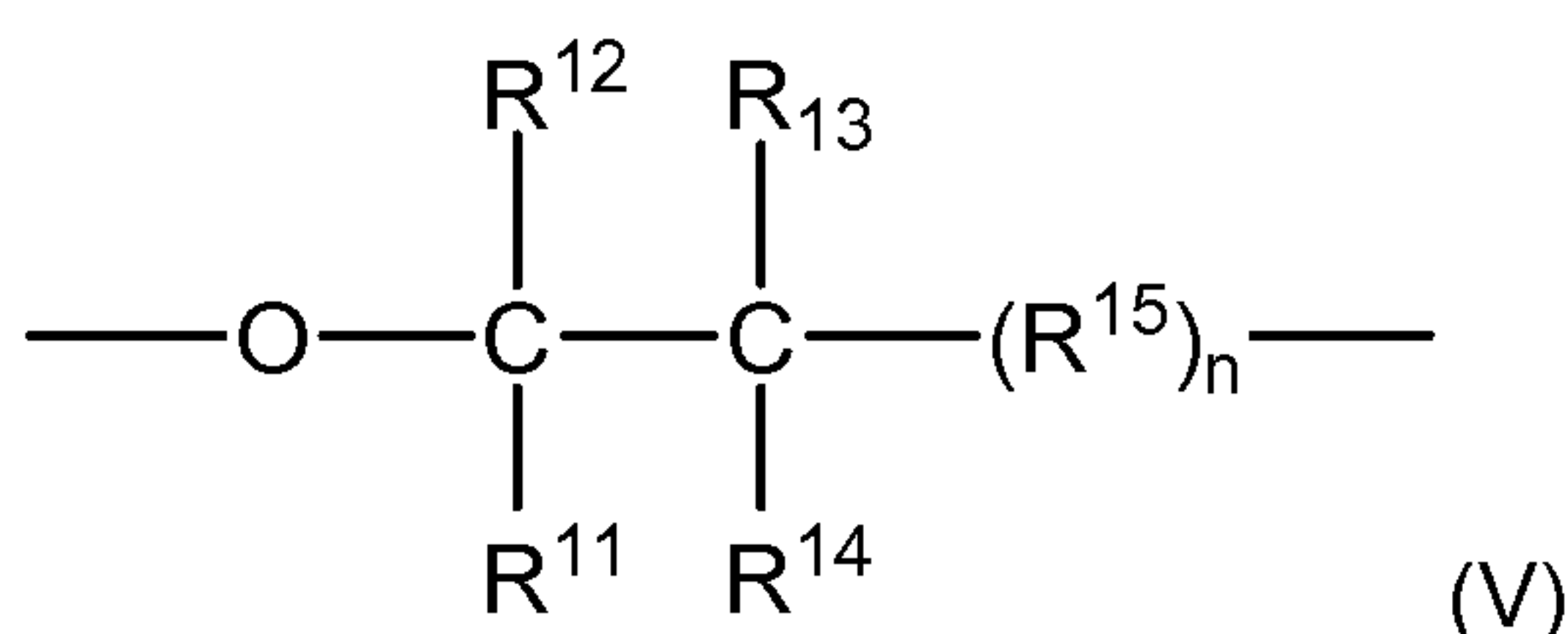
25

Preferably, component (b3), the at least one further polymer (FP), is selected from the group consisting of a poly(C₂-C₆-alkylene oxide), an aliphatic polyurethane, an aliphatic uncrosslinked epoxide, an aliphatic polyamide, a vinyl aromatic polymer, a poly(vinyl ester) of an aliphatic C₁-C₈ carboxylic acid, a poly(vinyl ether) of a C₁-C₈ alkyl vinyl ether, a poly(alkyl(meth)acrylate) of a C₁₋₈-alkyl and copolymers thereof.

30

Preferred at least one further polymers (FP) are described in more detail below.

- 35 Polyethers comprise repeating units of formula (V).



17

wherein

- R¹¹ to R¹⁴ are each independently of one another selected from the group consisting of H, C₁-C₄-alkyl and halogen-substituted C₁-C₄-alkyl;
- 5 R¹⁵ is selected from the group consisting of a chemical bond, a (-CR^{15a}R^{15b}-) group and a (-CR^{15a}R^{15b}O-) group,

wherein

- 10 R^{15a} and R^{15b} are each independently of one another selected from the group consisting of H and unsubstituted or at least monosubstituted C₁-C₄-alkyl,

wherein the substituents are selected from the group consisting of F, Cl, Br, OH and C₁-C₄-alkyl;

15

n is 0, 1, 2 or 3.

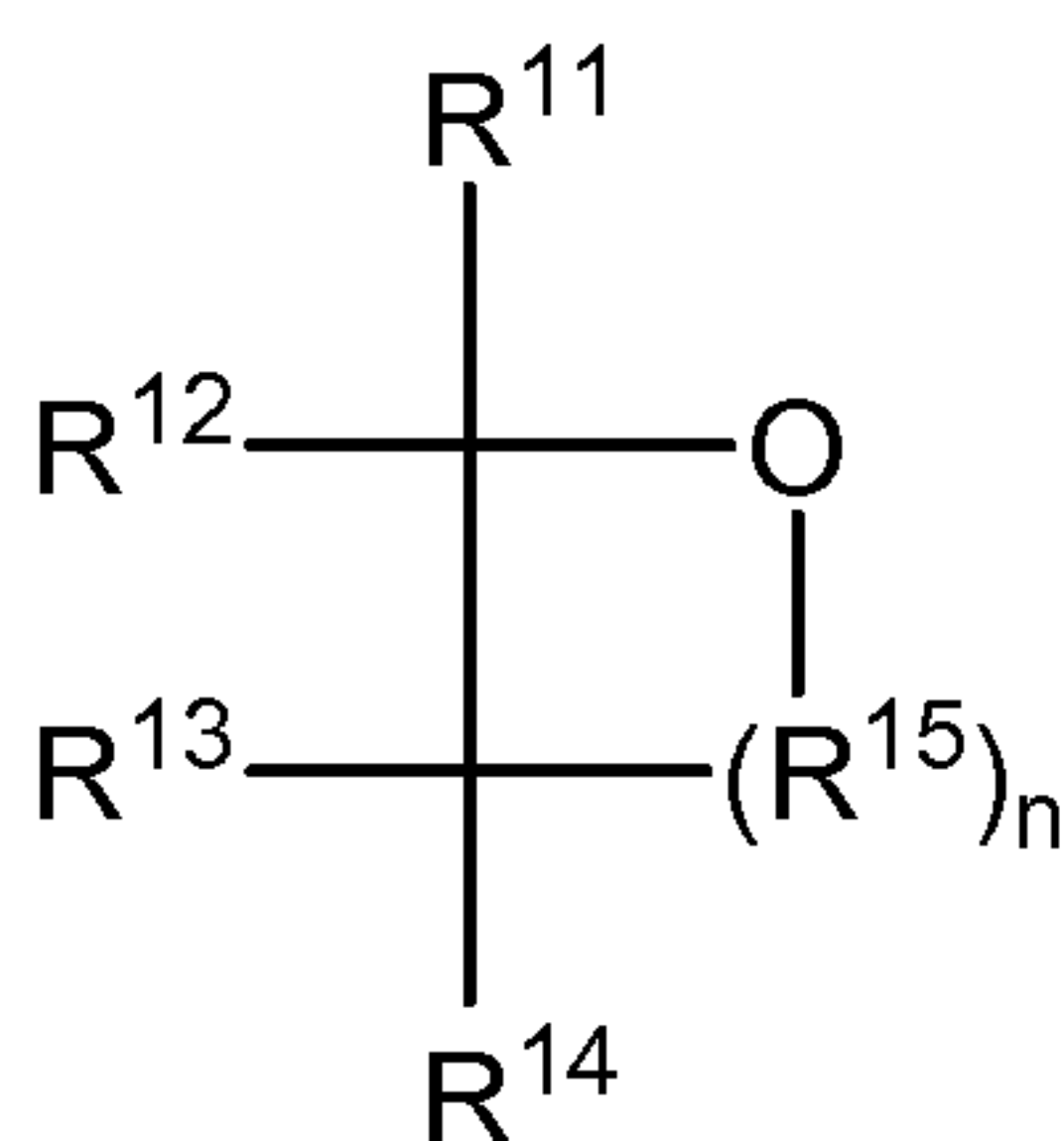
- If n is 0, then R¹⁵ is a chemical bond between the adjacent carbon atom and the oxygen atom. If R¹⁵ is a (-CR^{15a}R^{15b}O-) group, then the oxygen atom (O) of the (-CR^{15a}R^{15b}O-) group is bound to another carbon atom (C) of formula (V) and not to the oxygen atom (O) of formula (V). In other words, formula (V) does not comprise peroxide compounds. The same holds true for formula (VI).
- 20

Typical polyethers as well as their preparation are known to the skilled person.

25

A preferred polyether according to the present invention is, for example, a poly(alkylene glycol), also known as a poly(alkylene oxide).

- Polyalkylene oxides and their preparation are known to the skilled person. They are usually synthesized by interaction of water and a bi- or polyvalent alcohol with cyclic ethers, i. e. alkylene oxides, of the general formula (VI). The reaction is catalyzed by an acidic or basic catalyst. The reaction is a so called ring-opening polymerization of the cyclic ether of the general formula (VI).
- 30



(VI)

35

18

wherein

R¹¹ to R¹⁵ have the same meanings as defined above for formula (V).

- 5 A preferred poly(alkylene oxide) according to the present invention is derived from monomers of the general formula (VI) having 2 to 6 carbon atoms in the ring. In other words, preferably, the poly(alkylene oxide) is a poly(C₂-C₆-alkylene oxide). Particular preference is given to a poly(alkylene oxide) derived from monomers selected from the group consisting of 1,3-dioxolane, 1,3-dioxepane and tetrahydrofuran (IUPAC-name: oxolane). In other words, particularly preferably, the poly(alkylene oxide) is selected from the group consisting of poly-1,3-dioxolane, poly-1,3-dioxepane and polytetrahydrofuran.

- 15 In one embodiment, the poly(alkylene oxide) can comprise OH-end groups. In another embodiment, at least some of the OH-end groups of the poly(alkylene oxide) can be capped. Methods for capping OH-end groups are known to the skilled person. For example, the OH-end groups can be capped by etherification or esterification.

- 20 The weight average molecular weight of the poly(alkylene oxide) is preferably in the range of from 1 000 to 150 000 g/mol, particular preferably from 15 00 to 120 000 g/mol and more preferably in the range of from 2 000 to 100 000 g/mol.

- A polyurethane is a polymer having carbamate units. Polyurethanes as well as their preparation is known to the skilled person.

- 25 Within the present invention, aliphatic polyurethanes are preferred. They can, for example, be prepared by polyaddition of aliphatic polyisocyanates and aliphatic polyhydroxy compounds. Among the polyisocyanates, diisocyanates of the general formula (VII) are preferred

- 30
$$\text{OCN—R}^7\text{—NCO} \quad (\text{VII}),$$

wherein

- 35 R⁷ is a substituted or unsubstituted C₁-C₂₀-alkylene or C₄-C₂₀-cycloalkylene, wherein the substituents are selected from the group consisting of F, Cl, Br and C₁-C₆-alkyl.

- Preferably R⁷ is a substituted or unsubstituted C₂-C₁₂-alkylene or C₆-C₁₅-cycloalkylene.

- 40 Within the context of the present invention, definitions such as C₁-C₂₀-alkylene means C₁-C₂₀-alkanediyle. The C₁-C₂₀-alkylene is a hydrocarbon having two free valences and

19

a carbon atom number of from 1 to 20. The C₁-C₂₀-alkylene according to the present invention can be branched or unbranched.

Within the context of the present invention, definitions such as C₄-C₂₀-cycloalkylene means C₄-C₂₀-cycloalkanediyle. A C₄-C₂₀-cycloalkylene is a cyclic hydrocarbon having two free valences and a carbon atom number of from 4 to 20. Hydrocarbons having two free valences, a cyclic and also a linear component and a carbon atom number of from 4 to 20 likewise fall under this definition.

10 Preferred diisocyanates are selected from the group consisting of hexamethylenediisocyanate, 2,2,4-trimethyl hexamethylenediisocyanate, 2,4,4-trimethyl hexamethylenediisocyanate, 1,2-diisocyanatomethyl cyclohexane, 1,4-diisocyanatomethyl cyclohexane and isophorondiisocyanate (IUPAC-name: 5-isocyanato-1-(isocyanatomethyl)-1,3,3-trimethyl-cyclohexane).

15

The diisocyanates may also be used in oligomeric, for example dimeric or trimeric form. Instead of the polyisocyanates, it is also possible to use conventional blocked polyisocyanates which are obtained from the stated isocyanates, for example by an addition reaction of phenol or caprolactam.

20

Suitable polyhydroxy compounds for the preparation of aliphatic polyurethanes are, for example, polyesters, polyethers, polyesteramides or polyacetals or mixtures thereof.

Suitable chain extenders for the preparation of the polyurethanes are low molecular weight polyols, in particular diols and polyamines, in particular diamines or water.

The polyurethanes are preferably thermoplastic and therefore preferably essentially uncrosslinked, i. e. they can be melted repeatedly without significant signs of decomposition. Their reduced specific viscosities are as a rule from 0.5 to 3 dl/g, preferably from 1 to 2 dl/g measured at 30°C in dimethylformamide.

A polyepoxide comprises at least two epoxide groups. The epoxide groups are also known as glycidyl or oxirane groups. "At least two epoxide groups" mean precisely two epoxide groups and also three or more epoxide groups.

35

Polyepoxides and their preparation is known to the person skilled in the art. For example, polyepoxides are prepared by the reaction of epichlorhydrine (IUPAC-name: chlormethyloxirane) and a diol, a polyol or a dicarboxylic acid. Polyepoxides prepared in this way are polyethers having epoxide end groups.

40

20

Another possibility to prepare polyepoxides is the reaction of glycidyl(meth)acrylate (IUPAC-name: oxiran-2-ylmethyl-2-methylprop-2-enoate) with polyolefins or polyacrylates. This results in polyolefins or polyacrylates having epoxy end groups.

- 5 Preferably, aliphatic uncrosslinked polyepoxides are used. Copolymers of epichlorhydrine and 2,2-bis-(4-hydroxyphenyl)-propane (bisphenol A) are particularly preferred.

Component b3) (the at least one further polymer (FP)) can also comprise a polyamide.

- 10 Aliphatic polyamides are preferred.

The intrinsic viscosity of suitable polyamides is generally from 150 to 350 ml/g, preferably from 180 to 275 ml/g. Intrinsic viscosity is determined here from a 0.5% by weight solution of the polyamide in 96% by weight sulfuric acid at 25°C in accordance
15 with ISO 307.

Preferred polyamides are semicrystalline or amorphous polyamides.

Examples of polyamides suitable as component (b3) are those that derive from lactams
20 having from 7 to 13 ring members. Other suitable polyamides are those obtained through reaction of dicarboxylic acids with diamines.

Examples that may be mentioned of polyamides that derive from lactams are polyamides that derive from polycaprolactam, from polycaprylactam, and/or from
25 polylauro lactam.

If polyamides are used that are obtainable from dicarboxylic acids and diamines, dicarboxylic acids that can be used are alkanedicarboxylic acids having from 6 to 14 carbon atoms, preferably from 6 to 10 carbon atoms. Aromatic dicarboxylic acids
30 are also suitable.

Examples that may be mentioned here as dicarboxylic acids are adipic acid, azelaic acid, sebacic acid, dodecanedicarboxylic acid, and also terephthalic acid and/or isophthalic acid.
35

Examples of suitable diamines are alkanediamines, having from 4 to 14 carbon atoms, in particular alkanediamines having from 6 to 8 carbon atoms, and also aromatic diamines, for example m-xylylenediamine, di(4-aminophenyl)methane, di(4-aminocyclohexyl)methane, 2,2-di(4-aminophenyl)propane, 2,2-di(4-aminocyclohexyl)-
40 propane, and 1,5-diamino-2-methylpentane.

21

Other suitable polyamides are those obtainable through copolymerization of two or more of the monomers mentioned above and mentioned below, and mixtures of a plurality of polyamides in any desired mixing ratio.

- 5 Preferred polyamides are polyhexamethylenedipamide, polyhexamethylene-sebacamide, and polycaprolactam, and also nylon-6/6,6, in particular having a proportion of from 75 to 95% by weight of caprolactam units.

- 10 Particular preference is given to mixtures of nylon-6 with other polyamides, in particular with nylon-6/6,6 (PA 6/66), particular preference being given to mixtures of from 80 to 50% by weight of PA 6 and from 20 to 50% by weight of PA 6/66, where the PA 6/66 comprises from 75 to 95% by weight of caprolactam units, based on the total weight of the PA 6/66 in the mixture.

- 15 The following, non-exclusive list comprises the abovementioned polyamides, and other suitable polyamides, and also the monomers comprised.

AB polymers:

- | | | |
|----|-------|-------------------------|
| 20 | PA 4 | Pyrrolidone |
| | PA 6 | ϵ -Caprolactam |
| | PA 7 | Ethanolactam |
| | PA 8 | Caprylolactam |
| | PA 9 | 9-Aminopelargonic acid |
| 25 | PA 11 | 11-Aminoundecanoic acid |
| | PA 12 | Lauro lactam |

AA/BB polymers:

- | | | |
|----|----------|--|
| 30 | PA 46 | Tetramethylenediamine, adipic acid |
| | PA 66 | Hexamethylenediamine, adipic acid |
| | PA 69 | Hexamethylenediamine, azelaic acid |
| | PA 610 | Hexamethylenediamine, sebacic acid |
| | PA 612 | Hexamethylenediamine, decanedicarboxylic acid |
| 35 | PA 613 | Hexamethylenediamine, undecanedicarboxylic acid |
| | PA 1212 | 1,12-Dodecanediamine, decanedicarboxylic acid |
| | PA 1313 | 1,13-Diaminotridecane, undecanedicarboxylic acid |
| | PA 6T | Hexamethylenediamine, terephthalic acid |
| | PA MXD6 | m-Xylylenediamine, adipic acid |
| 40 | | |
| | PA 6I | Hexamethylenediamine, isophthalic acid |
| | PA 6-3-T | Trimethylhexamethylenediamine, terephthalic acid |

22

	PA 6/6T	(see PA 6 and PA 6T)
	PA 6/66	(see PA 6 and PA 66)
	PA 6/12	(see PA 6 and PA 12)
	PA 66/6/610	(see PA 66, PA 6 and PA 610)
5	PA 6I/6T	(see PA 6I and PA 6T)
	PA PACM 6	Diaminodicyclohexylmethane, adipic acid
	PA PACM 12	Diaminodicyclohexylmethane, laurolactam
	PA 6I/6T/PACM	as PA 6I/6T + diaminodicyclohexylmethane
	PA 12/MACMI	Lauro lactam, dimethyldiaminodicyclohexylmethane, isophthalic acid
10	PA 12/MACMT	Lauro lactam, dimethyldiaminodicyclohexylmethane, terephthalic acid
	PA PDA-T	Phenylenediamine, terephthalic acid

Preferred polyamides are PA 6, PA 66 and PA PACM 6.

- 15 Vinyl aromatic polymers are polyolefins having unsubstituted or at least monosubstituted styrene as monomer unit. Suitable substituents are, for example, C₁-C₆-alkyls, F, Cl, Br and OH. Preferred vinyl aromatic polymers are selected from the group consisting of polystyrene, poly- α -methylstyrene and copolymers thereof with up to 30% by weight of comonomers selected from the group consisting of acrylic esters, acrylonitrile and methacrylonitrile.

Vinyl aromatic polymers are commercially available and known to the person skilled in the art. The preparation of these polymers is also known to the person skilled in the art.

- 25 Preferably, the vinyl aromatic polymers are prepared by free radical polymerization, for example by emulsion, bead, solution or bulk polymerization. Possible initiators are, depending on the monomers and the type of polymerization, free radical initiators such as peroxide compounds and azo compounds with the amounts of initiator generally being in the range from 0.001 to 0.5% by weight, based on the monomers.

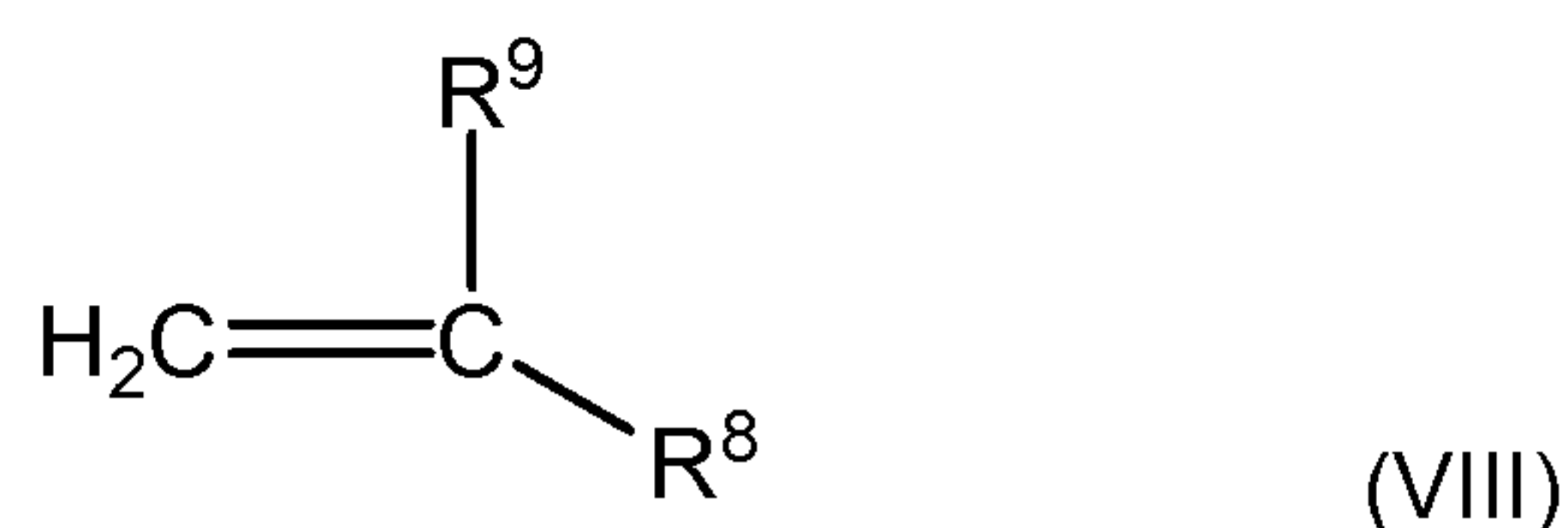
- 30 Poly(vinyl esters) and their preparation are known to the skilled person. Poly(vinyl esters) are preferably prepared by polymerization of vinyl esters. In a preferred embodiment of the present invention, the vinyl esters are vinyl esters of aliphatic C₁-C₆ carboxylic acids. Preferred monomers are vinyl acetate and vinyl propionate. These monomers form poly(vinyl acetate) and poly(vinyl propionate) polymers.

- 40 Poly(vinyl ethers) are prepared by polymerization of vinyl ether monomers. Poly(vinyl ethers) and their preparation are known to the skilled person. In a preferred embodiment, the vinyl ethers are vinyl ethers of aliphatic C₁-C₈ alkyl ethers. Preferred monomers are methyl vinyl ether and ethyl vinyl ether, forming poly(methyl vinyl ether) and poly(ethyl vinyl ether) during the polymerization.

23

Preferably, the poly(vinyl ethers) are prepared by free radical polymerization, for example by emulsion, bead, solution, suspension or bulk polymerization. Possible initiators are, depending on the monomers and the type of polymerization, free radical initiators such as peroxide compounds and azo compounds with the amounts of
 5 initiator generally being in the range from 0.001 to 0.5% by weight, based on the monomers.

Poly(alkyl(meth)acrylate) within the present invention comprises poly(alkyl acrylate), poly(alkyl methacrylates) and copolymers thereof. Poly(alkyl(meth)acrylate) comprises
 10 units derived from monomers of formula (VIII),



wherein

15

R^8 is selected from the group consisting of H and $\text{C}_1\text{-C}_8\text{-alkyl}$ and
 R^9 is a radical of formula (IX)



20 wherein

R^{10} is a $\text{C}_1\text{-C}_{14}\text{-alkyl}$.

Preferably, R^8 is selected from the group consisting of H and $\text{C}_1\text{-C}_4\text{-alkyl}$, particularly
 25 preferably R^8 is H or methyl. Preferably, R^{10} is a $\text{C}_1\text{-C}_8\text{-alkyl}$, particularly preferably, R^{10} is methyl or ethyl.

If R^8 in formula (VIII) is H and R^9 is a radical of formula (IX) and R^{10} in formula (IX) is methyl, then the monomer of formula (VIII) is methyl acrylate.

30

If R^8 in formula (VIII) is H and R^9 is a radical of formula (IX) and R^{10} in formula (IX) is ethyl, the monomer of formula (VIII) is ethyl acrylate.

If R^8 in formula (VIII) is methyl and R^9 is a radical of formula (IX), then the monomers of
 35 formula (VI) are methacrylic esters.

24

Poly(alkyl(meth)acrylates) comprise as monomers preferably 40 to 100% by weight of methacrylic esters, particularly preferably 70 to 100% by weight of methacrylic esters and more preferably from 80 to 100% by weight of methacrylic esters, each based on the total amount of the poly(alkyl(meth)acrylates).

5

In another preferred embodiment, the poly(alkyl(meth)acrylates) comprise as monomers from 20 to 100% by weight of methyl acrylate, ethyl acrylate or a mixture thereof, preferably from 40 to 100% by weight of methyl acrylate, ethyl acrylate or a mixture thereof and particularly preferably from 50 to 100% by weight of methyl
10 acrylate, ethyl acrylate or mixtures of thereof, each based on the total weight of the poly(alkyl(meth)acrylate).

Such polymers of monomers of the formula (VIII) with or without further monomers can be prepared in a conventional, preferably a free radical polymerization, for example an
15 emulsion, bead, solution or bulk polymerization (cf. Kirk-Othmer, Encyclopedia of Chemical Technology 3rd Ed., Vol. 1., pp. 330-342, Vol. 18, pp. 720-755, J. Wiley; H. Rauch-Puntigam, Th. Völker, Acryl- und Methacrylverbindungen). Possible initiators depending on the monomers and the type of polymerization are free radical initiators, such as peroxy or peroxo compounds and azo compounds. The amount of initiator
20 being in general within the range from 0.001 to 0.5% by weight, based on the monomers.

Suitable initiators for an emulsion polymerization are, for example, peroxydisulfates and redox systems for a bulk polymerization not only peroxides, such as dibenzoyl
25 peroxide or dilauroyl peroxide, but also azo compounds, for example azobisisobutyronitrile, similarly in the case of the solution or bead polymerization. The molecular weight may be regulated using conventional regulators, in particular mercaptans, e. g. dodecylmercaptan.

30 Preferably, the polymerization is carried out at elevated temperatures, for example above 50°C. The weight average molecular weight (M_w) is in general within the range of from 2 000 to 5 000 000 g/mol, preferably from 20 000 to 3 000 000 g/mol (determination by light scattering; cf. HoubenWeyl, Methoden der Org. Chemie, 4th edition, Volume 14/1, Georg Thieme-Verlag Stuttgart 1961).

35

The person skilled in the art knows that the monomers described above for the preparation of the components b1), b2) and b3) can undergo changes in their structure during the polymerization reaction. Consequently, the building units of the polymers are not the same as the monomers from which they are derived. However, the person
40 skilled in the art knows which monomers correspond to which building unit of the polymers.

25

Under the conditions of compounding or processing by fused filament fabrication, virtually no transacetalization occurs between component b1), the polyoxymethylene (POM), and component b3), the at least one further polymer (FP), i. e. virtually no exchange of comonomer units takes place.

5

In one embodiment of the invention the binder (B) in the core material (CM) comprises, besides b1), the components b2) and/or b3).

In a preferred embodiment, the binder (B) comprises besides b1), 2 to 35% by weight of component b2), based on the total weight of the binder (B), and/or from 2 to 40% by weight of component b3), based on the total weight of the binder (B).

In another embodiment of the invention the binder (B) comprises, besides b1), the components b2) and/or b3), wherein
b2) is at least one polyolefin (PO) and
b3) is at least one further polymer (FP), in case the at least one polymer (P) in component b) is a polyoxymethylene (POM).

The core material (CM) comprises as component c) 0 to 20% by volume, preferably 1.5 to 15% by volume, more preferably 2 to 10% by volume, based on the total volume of the core material (CM) of the at least one additive (A).

As component c), at least one additive (A) can be used. "At least one additive (A)" according to the present invention means precisely one additive (A) and also mixtures of two or more additives (A).

The additive (A) can be selected from among known dispersants. Examples are oligomeric polyethylene oxide having a low molecular weight of from 200 to 600 g/mol stearic acid, stearamides, hydroxystearic acids, fatty alcohols, fatty alcohol, fatty acid esters, sulfonates and block copolymers of ethylene oxide and propylene oxide and also, particularly preferably, polyisobutylene.

Further, the additive (A) may be selected from stabilizers, like UV-stabilizers and/or antioxidants.

35

The additive (A) may be selected from pigments, such as organic dyes and/or inorganic pigments.

The additive (A) may be selected from tackifiers, like polymers with a glass transition temperature below room temperature, which is preferably below 25° C and/or terpene-derivatives.

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26

The additive (A) may also be selected from the tackifiers as disclosed in WO 2013/117428 A1. An example for a commercially available tackifier is Acronal® A107.

Based on WO 2013/117428 A1 and applying the definitions of the components of the
5 tackifiers in WO 2013/117428 A1, as tackifiers preferably dispersions are applied comprising at least one in water soluble dispersed polymerisate with a weighted average molecular weight of less than 50000 and a glass transition temperature higher or equal to -40°C to lower or equal 0°C, preferably higher or equal -35°C or equal 0°C, preferable of a monomer mixture comprising

10

(a) at least 40 % by weight of at least one C1 to C20-alkyl (meth) acrylate

(b) 0 to 30 % by weight of at least one vinyl aromatic

15 (c) at least 0.1 % by weight of at least one acid monomer

(d) 0 to 50 % by weight of further monomers,

wherein the amounts of the monomers are based on the sum of all monomers.

20

Furthermore, tackifiers may be applied as disclosed in US 4,767,813 and as specified in the following 3 paragraphs.

According to US 4,767,813, the tackifier may be rosin or a derivative of rosin having a
25 ring and ball softening temperature from about 25° to 110° C., preferably from about 50° to 110° C.

Suitable tackifiers include rosin, hydrogenated rosin esters, glycerol of rosin such as triglycerol rosin esters, C₂₋₃ alkylene esters of rosin such as triethylene glycol esters of
30 rosin and tripropylene glycol esters of rosin; rosin salts, disproportionated rosin salts, pentaerythritol and the polyterpene resins including alpha and beta pinene. Suitable resins are sold under the tradenames Staybelite Ester 3, Staybelite Ester 10, Pentalyn H and Herculyn D.

35 The tackifier resin may be a C₅ or C₉ synthetic tackifier resin having a ring and ball softening point from about 10° to 100° C., preferably from about 50° to 100° C. Suitable resins are sold under the tradenames *Piccovar*, *Hercotac*, *Picconal* and *Piccolyte*. These tackifiers are polymerized from C₉ monomers, preferably aromatic and C₅ monomers, preferably aliphatic.

40

The shell material (SM) comprises the components d) to f).

27

Component d) comprises 75 to 100% by volume, preferably 85 to 100% by volume, more preferably 95 to 100% by volume, based on the total volume of the shell material (SM) of at least one thermoplastic polymer (TP).

- 5 As thermoplastic polymer (TP), the person skilled in the art may select any technical appropriate thermoplastic polymer.

The thermoplastic polymer (TP) may also be identical with one of the polymers used in the binder (B) of the core material (CM).

10

“At least one thermoplastic polymer (TP)” within the present invention means precisely one thermoplastic polymer (TP) and also mixtures of two or more thermoplastic polymers (TP).

- 15 The at least one thermoplastic polymer (TP) may comprise thermoplastic homopolymers, thermoplastic copolymers, as well as blends of thermoplastic polymers.

Preferably, the thermoplastic polymer (TP) is selected from the group of polyoxymethylene (POM), polyolefins (PE) such as polypropylene, polyurethanes (PU),
20 polyamides (PA), polyethers (PETH), polycarbonates (PC), and/or polyesters (PES), such as polylactic acid and blends thereof.

More preferably the thermoplastic polymer (TP) is selected from the group of polyoxymethylene (POM), polypropylene and/or polylactic acid (PLA) and blends
25 thereof.

Component e) consists of 0 to 20% by volume, based on the total volume of the shell material (SM), of the at least one inorganic powder (IP).

- 30 The at least one inorganic powder (IP) in the component e) is identical to the inorganic powder (IP) as defined for the component a) in the core material (CM).

Preferably, the component e) consists of 0% by volume, based on the total volume of the shell material (SM) of the at least one inorganic powder (IP) and therefore there is
35 preferably no component e) present in the shell material (CM).

However, in the embodiment of the invention wherein the component e) consists of preferably 0% by volume, based on the total volume of the shell material (SM) of the at least one inorganic powder (IP) there may be traces of inorganic powder (IP) present in
40 the shell material (SM) of less than 1% by volume, based on the total volume of the shell material (SM).

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Component f) comprises 0 to 25% by volume, preferably 0 to 15% by volume, more preferably 0 to 5% by volume, based on the total weight of the shell material (SM) of the at least one additive (A).

- 5 The at least one additive (A) in the component f) is selected from the same compounds as the additive (A) in the component c). The at least one additive (A) of component f) or the combination of additives (A) in component f), may differ individually from the at least one additive (A) of component c) or combination of additives (A) of component c) or be the same in a single embodiment of the invention.

10

In one embodiment of the invention the core material (CM) comprises the components a), b) and c)

- 15 a) 30 to 80% by volume, preferably 40 to 68% by volume, more preferably 50 to 65% by volume, based on the total volume of the core material (CM), of at least one inorganic powder (IP),

- 20 b) 20 to 70% by volume, preferably 20 to 60% by volume, more preferably 20 to 50% by volume based on the total volume of the core material (CM) of the at least one binder b) comprising component b1)

b1) at least one polymer (P)

- 25 c) 0 to 20% by volume, preferably 1.5 to 15% by volume, more preferably 2 to 10% by volume, based on the total volume of the core material (CM) of the at least one additive (A),

and the shell material(SM) comprises the components d) and f)

- 30 d) 75 to 100% by volume, based on the total weight of the shell material (SM) of at least one thermoplastic polymer (TP)

- e) 0 to 20 % by volume, based on the total volume of the shell material (SM) of the at least one inorganic powder (IP),

35

- f) 0 to 25% by volume, preferably 0 to 10% by volume, more preferably 0 to 5% by volume, most preferably 0 to 3% by volume, based on the total volume of the shell material (SM) of the at least one additive (A), wherein the thickness of the layer of shell material (SM) is 0.05 to 0.5 mm, preferably 0.09 to 0.3 mm, more preferably 0.1 to 0.25 mm.

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In a further embodiment of the invention the core material (CM) comprises the components a), b) and c)

5 a) 30 to 80% by volume, preferably 40 to 68% by volume, more preferably 50 to 65% by volume, based on the total volume of the core material (CM), of at least one inorganic powder (IP),

10 b) 20 to 70% by volume, preferably 20 to 60% by volume, more preferably 20 to 50% by volume based on the total volume of the core material (CM) of the at least one binder b) comprising component b1)

b1) at least one polymer (P)

15 c) 0 to 20% by volume, preferably 1.5 to 15% by volume, more preferably 2 to 10% by volume, based on the total volume of the core material (CM) of the at least one additive (A),

and the shell material (SM) comprises the components d) and f)

20 d) 75 to 100% by volume, based on the total weight of the shell material (SM) of at least one thermoplastic polymer (TP)

25 e) 0 to 20 % by volume, based on the total volume of the shell material (SM) of the at least one inorganic powder (IP),

f) 0 to 25% by volume, preferably 0 to 10% by volume, more preferably 0 to 5% by volume, most preferably 0 to 3% by volume, based on the total volume of the shell material (SM) of the at least one additive (A).

30 In another embodiment of the invention the core material (CM) comprises the components a) and b)

35 a) 30 to 80% by volume, preferably 40 to 68% by volume, more preferably 50 to 65% by volume, based on the total volume of the core material (CM), of at least one inorganic powder (IP),

40 b) 20 to 70% by volume, 20 to 60% by volume, more preferably 20 to 50% by volume based on the total volume of the core material (CM) of the at least one binder b) comprising component b1)

b1) at least one polymer (P)

30

- c) 0 to 20% by volume, preferably 1.5 to 15% by volume, more preferably 2 to 10% by volume, based on the total volume of the core material (CM) of the at least one additive (A),
- 5 and the shell material(SM) comprises the component d)
- d) 100% by volume, based on the total weight of the shell material (SM) of at least one thermoplastic polymer (TP)
- 10 e) 0% by volume, based on the total volume of the shell material (SM) of the at least one inorganic powder (IP),
- f) 0% by volume, based on the total volume of the shell material (SM) of the at least one additive (A), wherein the thickness of the layer of shell material (SM) is 0.05
- 15 to 0.5 mm, preferably 0.09 to 0.3 mm, more preferably 0.1 to 0.25 mm.

In a further embodiment, of the invention the core material (CM) comprises the components a) and b)

- 20 a) 30 to 80% by volume, preferably 40 to 68% by volume, more preferably 50 to 65% by volume, based on the total volume of the core material (CM), of at least one inorganic powder (IP),
- b) 20 to 70% by volume, 20 to 60% by volume, more preferably 20 to 50% by
- 25 volume based on the total volume of the core material (CM) of the at least one binder b) comprising component b1)
- b1) at least one polymer (P)
- 30 c) 0 to 20% by volume, preferably 1.5 to 15% by volume, more preferably 2 to 10% by volume, based on the total volume of the core material (CM) of the at least one additive (A),
- and the shell material(SM) comprises the component d)
- 35 d) 100% by volume, based on the total weight of the shell material (SM) of at least one thermoplastic polymer (TP)
- e) 0% by volume, based on the total volume of the shell material (SM) of the at least
- 40 one inorganic powder (IP),

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- f) 0% by volume, based on the total volume of the shell material (SM) of the at least one additive (A).

A further subject of the invention is a process for the preparation of the filament,
 5 wherein a core material (CM) is coated with a layer of a shell material (SM) by co-extrusion of the core material (CM) with the shell material (SM).

The co-extrusion technique as such is known to the person skilled in the art.

- 10 Based on the applied materials for the core and the shell material, the person skilled in the art may choose the respective appropriate co-extrusion temperatures and process parameters.

Another subject of the invention is a process for preparation of a three-dimensional
 15 green body by a fused filament fabrication process, comprising at least the steps a), b), c),

- a) providing the filament on a spool to a nozzle,
 b) heating the filament to a temperature (T_M),
 20 c) depositing of the heated filament obtained in step b) in a build chamber using a layer based additive technique in order to form the three dimensional green-body.

The fused filament fabrication process for the production of three-dimensional objects
 25 is well known in the state of the art and detailed explained in the above cited documents. The fused filament fabrication process is also denominated as 3D-printing process.

According to step a), the filament according to the present invention, is provided on a
 30 spool to a nozzle. If the three-dimensional object to be prepared comprises a metal alloy, the filament can either comprise a powder of the already prepared metal alloy or a mixture of powders of the individual metal alloy constituents, i. e. the metal and the other element as described above. The metal alloy will then form during the preparation of the three-dimensional object.

35 According to step b), the filament is heated to a temperature (T_M). The temperature (T_M) is above the melting point of the binder (B). Methods for the determination of the melting point of the binder (B) are known to the skilled person. For example, the melting point of the binder (B) can be estimated by differential scanning
 40 calorimetry (DSC).

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In a preferred embodiment according to the present invention, in process step b) the filament is heated to a temperature (T_M) that is at least 1°C, preferably at least 5°C and particularly preferably at least 10°C above the melting point of the binder (B).

- 5 In another preferred embodiment the filament is heated to a temperature (T_M) in the range of from 140 to 240°C, preferably of from 160 to 220°C.

Another subject of the present invention is therefore a process for the production of a three-dimensional green body, wherein the temperature (T_M) in step b) is from 140 to
10 240 °C.

According to step c), the filament is deposited into a build chamber using the layer-based additive technique. The temperature of the build chamber is usually in the range of from 30 to 100 °C, preferably of from 40 to 90 °C and particularly preferably of from
15 50 to 80 °C.

In other words, in step a) to c) of the inventive process, the filament generally is initially present in a solid state and thereafter melted and printed to form a three-dimensional
20 object comprising the filament. The so prepared three-dimensional object is also called “three-dimensional green body”.

In one embodiment of the present invention, process step c) is followed by a process step d) in which at least a part of the binder (B) and/or at least a part of the shell
25 material (SM) are removed from the three-dimensional green body.

Another subject of the present invention is therefore a process for the production of a three-dimensional green body, wherein step c) is followed by a step d), in which at least a part of the acid sensitive components of the binder (B) and/or at least a part of
30 the acid sensitive components of the shell material (CM) are removed from the three-dimensional green body to form a three-dimensional brown body.

After the at least partial removal of the binder (B) and/or at least a part of the shell material (SM), the resulting three-dimensional object is called a “three-dimensional
35 brown body”. The three-dimensional brown body comprises the inorganic powder (IP), the fraction of the binder (B) and the fraction of the shell material (SM) which were not removed during the step d). The person skilled in the art knows that a three-dimensional brown body comprising a ceramic material as inorganic powder (IP) is also called a three-dimensional white body. However, for the purpose of the present
40 invention, the terms “three-dimensional brown body” and “three-dimensional white body” are used synonymous and are interchangeably.

33

To remove at least part of the binder (B) in process step d) and/or at least a part of the of the shell material (SM), the three-dimensional green body obtained by the fused filament fabrication process is preferably treated with a gaseous acid comprising
5 atmosphere. Appropriate processes are described, for example, in US 2009/0288739 and US 5,145,900. This process step d) is, according to the invention, preferably carried out at temperatures below the melting temperature of the binder (B). Process step d) is preferably carried out at a temperature at least 1°C below the melting point of the binder (B), preferably at least 5°C below the melting point of the binder (B) and
10 particularly preferably at least 10°C below the melting point of the binder (B).

Another subject of the present invention is therefore a process for the production of a three-dimensional green body, wherein in step d) at least a part of the binder (B) and/or at least a part of the shell material (SM) is removed at a temperature below the melting
15 point of the binder (B) and/or the shell material (SM).

In general, the process step d) is carried out at a temperature in the range of from 20 to 180°C and particularly preferably of from 100 to 150°C. Preferably, process step d) is carried out for a period of from 0.1 to 24h, particularly preferably of from 0.5 to 12h.

20

The treatment time required depends on the treatment temperature and the concentration of the acid in the treatment atmosphere and also on the size of the three-dimensional object.

25 Another subject of the present invention is therefore a process for the production of a three-dimensional green body, wherein in step d) at least a part of the binder and/or at least a part of the shell material (SM) are removed by acidic treatment.

Suitable acids for process step d) of the present invention are, for example, inorganic
30 acids which are either gaseous at room temperature or can be vaporized at the treatment temperature or below. Examples are hydrogen halides and nitric acid. Hydrogen halides are hydrogen fluoride, hydrogen chloride, hydrogen bromide and hydrogen iodide. Suitable organic acids are those, which have a boiling point at atmosphere pressure of less than 130°C, e. g. formic acid, acetic acid or trifluoroacetic
35 acid and mixtures thereof. Acids with boiling points above 130°C, for example methanesulfonic acid, can also be utilized in process step d) when dosed as a mixture with a lower boiling acid and/or water. Preferred acids for process step d) are nitric acid, a 10% by weight solution of oxalic acid in water or a mixture of 50% by volume of methanesulfonic acid in water.

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Furthermore, BF_3 and its adducts with inorganic ethers can be used as acids.

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If a carrier gas is used, the carrier gas is generally passed through the acid and loaded with the acid beforehand. The carrier gas, which has been loaded in this way with the acid, is then brought to the temperature at which process step d) is carried out. This temperature is advantageously higher than the loading temperature in order to avoid
5 condensation of the acids. Preferably, the temperature at which process step d) is carried out is at least 1°C, particularly preferably at least 5°C and most preferably at least 10°C higher than the loading temperature.

Preference is given to mixing the acid into the carrier gas by means of a metering
10 device and heating the gas mixture to such a temperature that the acid can no longer condense. Preferably, the temperature is at least 1°C, particularly preferably at least 5°C and most preferably at least 10°C higher than the sublimation and/or vaporization temperature of the acid and/or the carrier gas.

15 The carrier gas in general is any gas that is inert under the reaction conditions of the step d). A preferred carrier gas according to the present invention is nitrogen.

It is known to the person skilled in the art that not all components which may be comprised by the binder (B) and/or the shell material (SM) in different embodiments of
20 the invention are removable in step d) due to their chemical and physical properties.

Therefore, the part of binder (B) and/or shell material (SM) which can be removed in step d) in different embodiments of the invention may vary dependent on the specific compounds used.

25

Preferably, the step d) is continued until the binder (B) and/or the shell material (SM) have been removed to an extend of at least 40% by weight, more preferably at least 60% by weight, most preferably at least 80% by weight, particularly preferably at least 90% by weight and more particularly preferably at least 95% by weight based on the
30 total weight of the binder (B) and/or the shell material (SM). This can be checked, for example, with the height of the weight decrease.

It is known to the person skilled in the art that at the temperatures of the step d) step, the inorganic powder (IP) comprised in the three-dimensional green body can undergo
35 chemical and/or physical reactions. In particular, the particles of the inorganic powder (IP) can fuse together and the inorganic powder can undergo solid state phase transitions.

The same holds true for the binder (B) and the shell material (SM). During the step d)
40 step the composition of the binder (B) can change.

35

Consequently, in one embodiment of the present invention, the inorganic powder (IP), the binder (B) and/or the shell material (SM) comprised in the three-dimensional green body obtained in process step d) differs from the inorganic powder (IP) and/or the binder (B) comprised in the three-dimensional brown body obtained in process step c).

5

Process step d) can be followed by a process step e) in which the three-dimensional brown body is sintered. Process step e) is also called sintering. The terms "process step e)" and "sintering" for the purpose of the present invention are synonymous and are used interchangeably throughout the present invention.

10

Another subject of the present invention is therefore a process for the production of a three-dimensional green body, wherein step d) is followed by a step e), in which the three-dimensional brown body is sintered to form a three-dimensional sintered body.

15 After the sintering, the three-dimensional object is a three-dimensional sintered body. The three-dimensional sintered body comprises the inorganic powder (IP) and is essentially free of the binder (B) and the shell material (SM).

"Essentially free of the binder (B) and the shell material (SM)" according to the present invention means that the three-dimensional sintered body comprises less than 5 % by volume, preferably less than 2 % by volume, particularly preferably less than 0.5 % by volume and most preferably less than 0.01 % by volume of the binder (B) and the shell material (SM).

25 It is known to the skilled person that during the sintering process the inorganic powder (IP) is sintered together to give a sintered inorganic powder. Furthermore, during the sintering process the inorganic powder (IP) can undergo chemical and/or physical reactions. Consequently, the inorganic powder (IP) comprised in the three-dimensional brown body usually differs from the sintered inorganic powder comprised in the three-dimensional sintered body.

In one embodiment of the present invention, after process step d) and before process step e), the three-dimensional brown body obtained in process step d) is heated for preferably 0.1 to 12h, particularly preferably from 0.3 to 6h, at a temperature of preferably from 250 to 700°C, particularly preferably from 250 to 600°C to remove the residual binder (B) and the residual shell material (SM) completely.

The temperature as well as the duration and the atmosphere during process step e) depends on the inorganic powder comprised in the mixture filament as component a).
40 The temperature program of the sintering process, the duration and the atmosphere is in general adapted to the needs of the inorganic powder (IP) comprised in the filament

36

as component a). Suitable conditions for process step e) are known to the skilled person.

In general, process step e) is carried out under the atmosphere of a gas that is inert with regard to the inorganic powder (IP) and the binder (B). Typical inert gases are for example nitrogen and/or argon.

Depending on the inorganic powder (IP) comprised in the filament, it is also possible to carry out process step e) in air, under vacuum or in hydrogen atmosphere.

10

The temperature in process step e) is in general in the range of from 750 to 1600°C, preferably of from 800 to 1500°C and particularly preferably of from 850 to 1450 °C.

Further subjects of the invention are also the three-dimensional green body, the three-dimensional brown-body and the three-dimensional sintered body prepared by the processes as specified above.

The following examples further illustrate the invention.

20 The filaments in the examples 1) to 3) (according to the invention) were prepared by co-extrusion of the core material and the shell material applying the following materials, equipment and processing parameters.

Materials:

25

Core material for all examples 1) to 3) (according to the invention):

Core-60: 60 vol% 17-4PH stainless steel powder (D50 = 12 micron), 4.9 vol% LDPE, 7 vol% poly(1,3-dioxepane) and 28.1 vol% polyacetal (POM)

30

Shell material:

Example 1) (according to the invention): POM (Polyacetal; tradename: Ultraform)

Example 2) (according to the invention): PP HP 500N (polypropylene)

35 Example 3) (according to the invention): PLA Ingeo 4043D (polylactic acid)

Equipment:

Extrusion equipment: 2 Teach-Line E20T extruders with a Polyolefin Screw 8/6/11 with compression 3.08

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Die: modified blow-film die matrix Ø 3,6mm

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Additional equipment: Waterbath
Conveyor BAW130T
Zumbach diameter measurement

5

Processing parameters:

All polymers were dried before processing at 80°C using an air dryer and conveyor speed of 7 m/min

10

Example 1:

Core of core material:

15 Extruder with "Core-60"

Zone 1 185°C, Zone 2 190°C, Skin Adapter 190°C Die 190°C

Screw speed 35 RPM

Outside Layer of shell material:

20

Co-extrusion with POM Ultraform Z2320

Zone 1 175°C, Zone 2 185°C, Skin adapter 190°C

Screw speed 45 RPM

25 Filament properties:

Diameter 2.7mm, Ovality 0.03 mm

Core diameter: 2.5mm

Outside layer thickness: 0.2mm

30

Example 2:

Core of core material

35 Extruder with "Core-60"

Zone 1 185°C, Zone 2 190°C, Skin Adapter 190°C Die 190°C

Screw speed 35 RPM

Outside layer of shell material:

40

Co-extrusion with PP HP 500N

Zone 1 185°C, Zone 2 190°C, Skin adapter 190°C

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Screw speed 65 RPM

Filament properties:

- 5 Diameter 2.7mm, Ovality 0.03 mm
Core diameter: 2.5mm
Outside layer thickness: 0.2mm

Example 3:

10

Core of core material:

Extruder with "Core-60"

Zone 1 185°C, Zone 2 190°C, Skin Adapter 190°C Die 190°C

- 15 Screw speed 35 RPM

Outside layer of shell material:

Co-extrusion with PLA Ingeo 4043D

- 20 Zone 1 185°C, Zone 2 190°C, Skin adapter 190°C
Screw speed 45 RPM

Filament properties:

- Diameter 2.7mm, Ovality 0.03 mm
25 Core diameter: 2.5mm
Outside layer thickness: 0.2mm

New set of claims

- 5 1. A filament comprising a core material (CM) coated with a layer of shell material (SM), wherein
- the core material (CM) comprises the components a) to c)
- 10 a) 30 to 80% by volume, based on the total volume of the core material (CM) of at least one inorganic powder (IP),
- b) 20 to 70% by volume, based on the total volume of the core material (CM) of at least one binder (B) comprising component b1)
- 15 b1) at least one polymer (P)
- c) 0 to 20% by volume, based on the total volume of the core material (CM) of at least one additive (A),
- 20 wherein the at least one polymer (P) is a polyoxymethylene (POM) homopolymer, a polyoxymethylene (POM) copolymer or polyoxymethylene (POM) terpolymer and wherein at least some of the OH-end groups of the polyoxymethylene (POM) homopolymer are capped,
- 25 and the shell material(SM) comprises the components d) to f)
- d) 75 to 100% by volume, based on the total volume of the shell material (SM) of at least one thermoplastic polymer (TP)
- e) 0 to 20% by volume, based on the total volume of the shell material (SM) of the at least one inorganic powder (IP),
- 30 f) 0 to 25% by volume, based on the total weight of the shell material (SM) of the at least one additive (A), wherein the thickness of the layer of shell material is 0.05 to 0.5 mm.
- 35 2. The filament according to claim 1, wherein the binder (B)
- i) comprises from 50 to 96% by weight or the at least one polymer (P), based on the total weight of the binder.

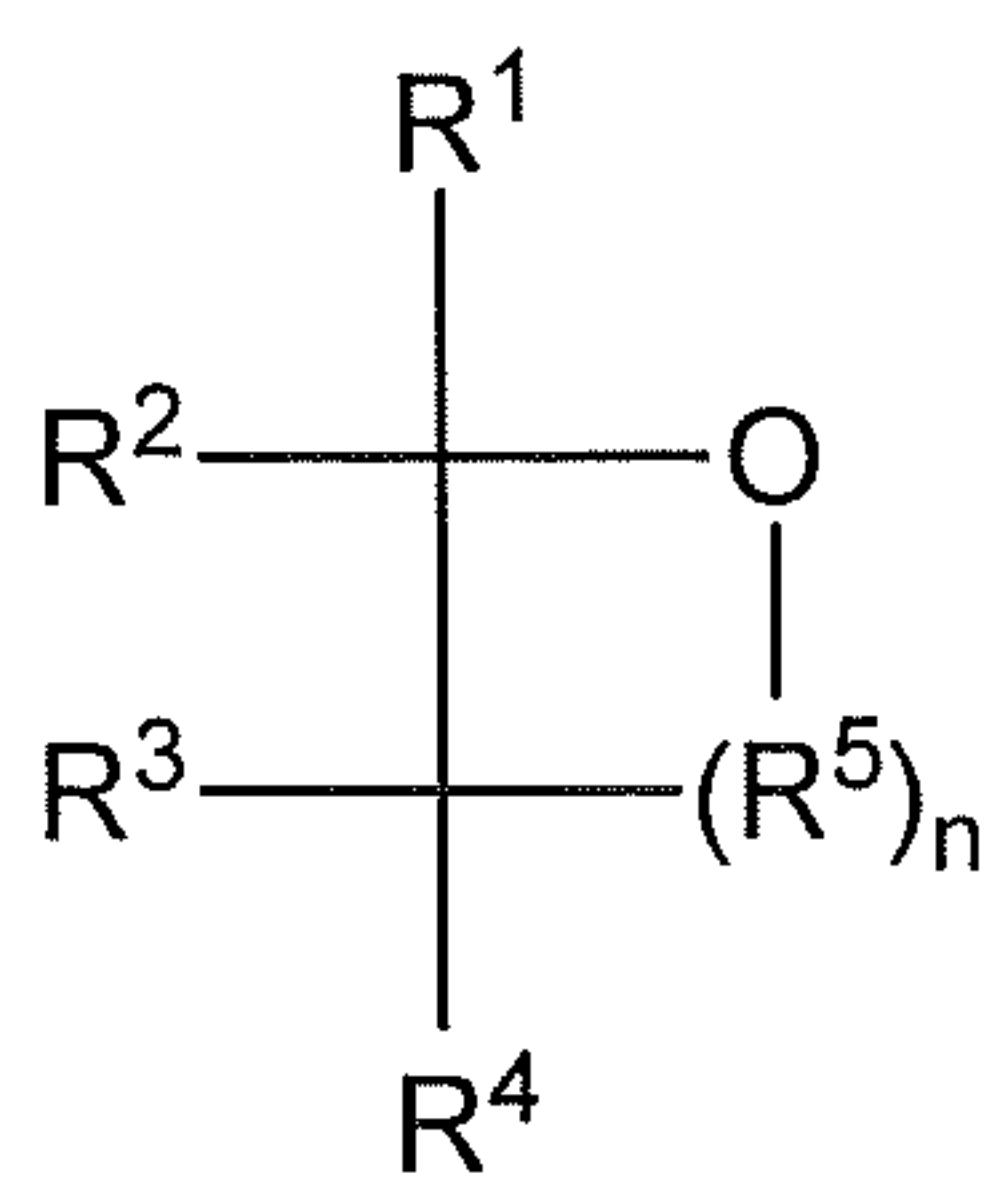
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3. The filament according to any of claims 1 or 2, wherein the binder (B) in the core material (CM) further comprises components b2) and/or b3)
- 5 b2) at least one polyolefin (PO),
 b3) at least one further polymer (FP), in case component b) is a polyoxymethylene (POM).
- 10 4. The filament according to claim 3, wherein the binder (B) comprises 2 to 35% by weight of component b2), based on the total weight of the binder (B), and/or from 2 to 40% by weight of component b3), based on the total weight of the binder (B).
5. The filament according to any of claims 1 to 4, wherein
- 15 i) the diameter of the filament is 1.5 to 3.5 mm, preferably 2.0 to 3.1 mm, more preferably 2.6 to 3.0 mm, and/or
 ii) the diameter of the core material is 1.5 to 3.0 mm, preferably 1.9 to 2.7 mm, more preferably 2.2 to 2.7 mm, and /or
 iii) the thickness of the layer of shell material (SM) is 0.09 to 0.3 mm, preferably 0.1 to 0.25 mm, and/or
 20 iv) the particle size of the inorganic powder (IP) is from 0.1 to 80 µm, preferably from 0.5 to 50 µm, more preferably from 0.1 to 30 µm, and/or
 v) the inorganic powder (IP) is a powder of at least one inorganic material selected from the group consisting of a metal, a metal alloy and a ceramic material, and/or
 25 vi) the at least one thermoplastic polymer (TP) of the shell material (SM) is selected from the group of polyoxymethylene (POM), polyolefins (PE) such as polypropylene or polyethylene, polyurethanes (PU), polyamides (PA), polyethers (PETH), polycarbonates (PC), and/or polyesters (PES) such as polylactic acid and blends thereof.
- 30 6. The filament according to any one of claims 1 to 5, wherein the polymer (P) in component (b1) is a polyoxymethylene (POM) copolymer which is prepared by polymerization of
- 35 - from at least 50 mol-% of a formaldehyde source (b1a),
 - from 0.01 to 20 mol-% of at least one first comonomer (b1b) of the general formula (II)

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(II),

wherein

5 R^1 to R^4 are each independently of one another selected from the group consisting of H, C_1 - C_4 -alkyl and halogen-substituted C_1 - C_4 -alkyl;

10 R^5 is selected from the group consisting of a chemical bond, a $(-CR^{5a}R^{5b}-)$ group and a $(-CR^{5a}R^{5b}O-)$ group,

wherein

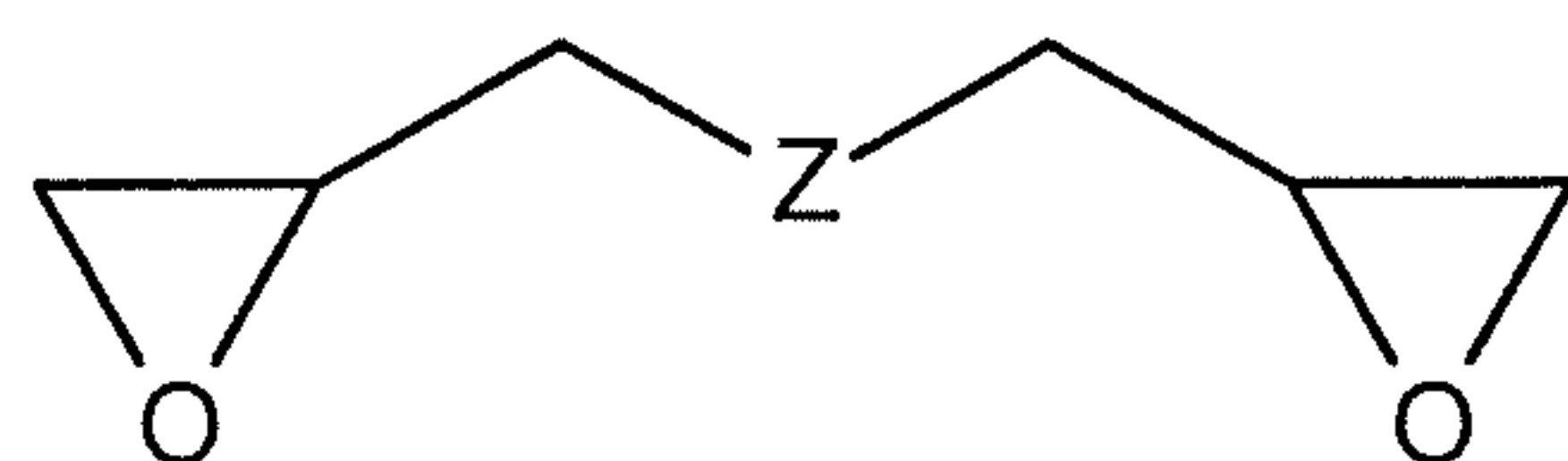
15 R^{5a} and R^{5b} are each independently of one another selected from the group consisting of H and unsubstituted or at least monosubstituted C_1 - C_4 -alkyl,

wherein the substituents are selected from the group consisting of F, Cl, Br, OH and C_1 - C_4 -alkyl;

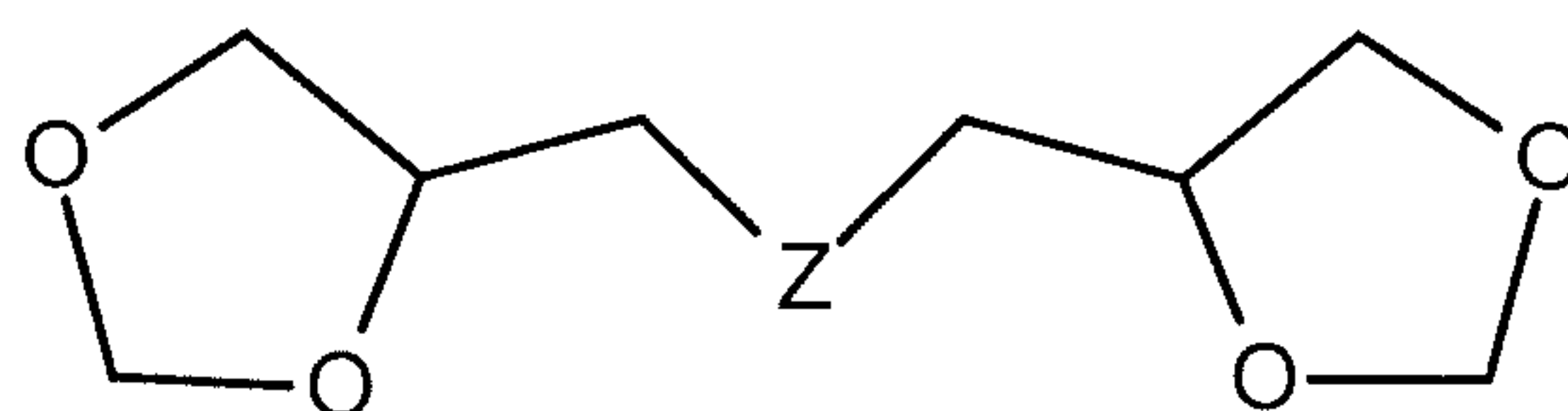
20 n is 0, 1, 2 or 3;

and

25 - from 0 to 20 mol-% of at least one second comonomer (b1c) selected from the group consisting of a compound of formula (III) and a compound of formula (IV)



(III),



(IV),

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wherein

5 Z is selected from the group consisting of a chemical bond, an (-
O-) group and an (-O-R⁶-O-) group,

wherein

10 R⁶ is selected from the group consisting of unsubstituted
C₁-C₈-alkylene and C₃-C₈-cycloalkylene.

7. The filament according to claim 3, wherein the further polymer (FP) is at least one
further polymer (FP) selected from the group consisting of a polyether, a
polyurethane, a polyepoxide, a polyamide, a vinyl aromatic polymer, a poly(vinyl
15 ester), a poly(vinyl ether), a poly(alkyl (meth)acrylate) and copolymers thereof.

8. A process for the preparation of a filament according to any of the claims 1 to 7,
wherein a core material (CM) is coated with a layer of a shell material (SM) by co-
extrusion of the core material (CM) with the shell material (SM).
20

9. A process for preparation of a three-dimensional green body, by a fused filament
fabrication process, comprising at least the steps a), b), c),

25 a) providing the filament according to any of claims 1 to 7 on a spool to a
nozzle,
b) heating the filament to a temperature (T_M),
c) depositing of the heated filament obtained in step b) in a build chamber
using a layer based additive technique in order to form the three
dimensional green-body.
30

10. The process according to claim 9, wherein the temperature (T_M) in step b) is 140
to 240°C.

35 11. The process according to claim 9 or 10, wherein step c) is followed by a step d)
in which at least a part of the binder (B) and/or at least a part of the shell material
(SM) is removed from the three-dimensional green body in order to form a three-
dimensional brown body.

40 12. The process according to claim 11, wherein in step d)

i) the binder (B) and/or the shell material (SM) is removed by acidic treatment
and/or

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- ii) the binder (B) and/or the shell material (SM) is removed at a temperature below the melting point of the binder (B) and/or the shell material (SM).

5 13. The process according to any of claims 11 or 12, wherein step d) is followed by a step e), in which the three-dimensional brown body is sintered to form a three-dimensional sintered body.

10 14. A three-dimensional green-body, prepared by the process according to claim 9 or 10.