TECHNICAL DATA SHEET

V5.5



PolySupport™

PolySupport™ is a break away support for Polymaker PLA based filaments. It has a perfect interface with PLA, strong enough to support it and easily removable by hand.

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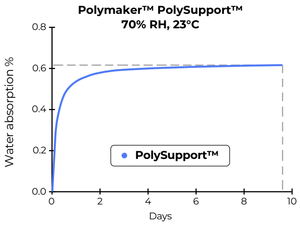
PHYSICAL PROPERTIES

PROPERTY	TESTING METHOD	TYPICAL VALUE
Density	ISO1183, GB/T 1033	1.22 g/cm^3 at 23°C
Melt index	220°C, 2.16 kg	3-6 g/10min

MOISTURE ABSORPTION CURVE



Equilibrium water absorption (%)= 0.64%

CHEMICAL RESISTANCE DATA

PROPERTY	TYPICAL VALUE
Effect of weak acids	Good
Effect of strong acids	Poor
Effect of weak alkalis	Fair
Effect of strong alkalis	Poor
Effect of oils and grease	Good

Good:
Material may get minor attack after long periods of storage with chemical at ambient temperature

Fair:
Material can be used for short time contact with chemicals at ambient temperature

Poor:
Material becomes unstable on contact with chemical at ambient temperature

RECOMMENDED PRINTING CONDITIONS

Nozzle temperature	230-260°C
Build plate temperature	70-80°C
Build surface treatment	PC and Textured PEI
Cooling fan	OFF-20%
Closure chamber	Not needed

Printing speed	50-100mm/s
Drying temp. and time	65°C/6H
Retraction distance	1-3 (mm)
Retraction speed	20-40 (mm/s)

*Based on 0.4mm nozzle. Printing conditions may vary with different nozzle diameters.

MATERIAL COMPATIBILITY

MATERIAL	ADHESION WITH POLYSUPPORT™
PLA based material from Polymaker's portfolio	Supports the model very well
PETG based material from Polymaker's portfolio	Generally doesn't support the model depending on its geometry
ABS based material from Polymaker's portfolio	Generally doesn't support the model depending on its geometry
PC based material from Polymaker's portfolio	Generally supports the model depending on its geometry
PVB based material from Polymaker's portfolio	Generally supports the model depending on its geometry
TPU based material from Polymaker's portfolio	Generally supports the model depending on its geometry
Nylon based material from Polymaker's portfolio	Does not support the model



PolyBox™ or PolyDryer™ Box

NOTE
It is highly recommended to use the PolyBox™ or PolyDryer™ Box when printing or storing.

*Based on testing with Polymaker™ PolySupport™ (SKU: PD04001)

DISCLAIMER

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End- use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.
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