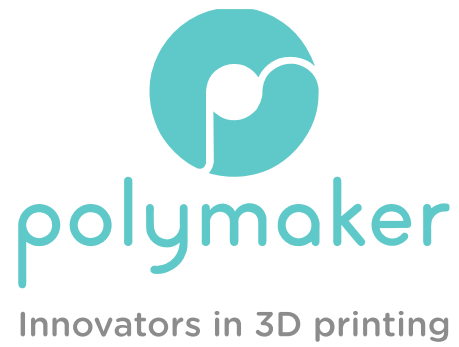




## *Technical Data Sheet*

# *PolySupport™*

[www.polymaker.com](http://www.polymaker.com)  
V5.0



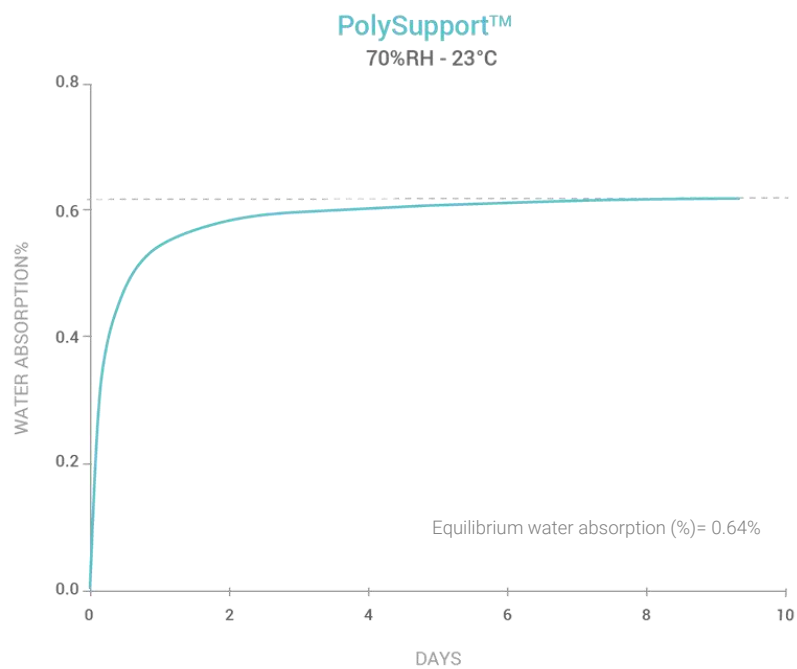
**PolySupport™**

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.

### ***PHYSICAL PROPERTIES***

| Property           | Testing Method    | Typical Value                  |
|--------------------|-------------------|--------------------------------|
| Density            | ISO1183, GB/T1033 | 1.22 g/cm <sup>3</sup> at 23°C |
| Melt index         | 220°C, 2.16kg     | 3-6 g/10min                    |
| Light transmission | N/A               | N/A                            |
| Flame retardancy   | N/A               | N/A                            |

### ***MOISTURE ABSORPTION CURVE***



## Material Compatibility

| Material                                        | Adhesion with PolySupport™ |
|-------------------------------------------------|----------------------------|
| PLA based material from Polymaker's portfolio   | ++                         |
| PETG based material from Polymaker's portfolio  | -                          |
| ABS based material from Polymaker's portfolio   | -                          |
| PC based material from Polymaker's portfolio    | +                          |
| PVB based material from Polymaker's portfolio   | +                          |
| TPU based material from Polymaker's portfolio   | +                          |
| Nylon based material from Polymaker's portfolio | --                         |

++ support the model very well

+ generally support the model depending on its geometry

- generally doesn't support the model depending on its geometry

-- do not support the model

## RECOMMENDED PRINTING CONDITIONS

\* Based on 0.4 mm nozzle and Simplify 3D v.4.0. Printing conditions may vary with different nozzle diameters

| Parameter                 |                             |
|---------------------------|-----------------------------|
| Nozzle temperature        | 220 – 230 (°C)              |
| Build surface material    | BuildTak®, Glass, Blue Tape |
| Build surface treatment   | Glue                        |
| Build plate temperature   | 25 - 60 (°C)                |
| Cooling fan               | ON                          |
| Printing speed            | 20-40 (mm/s)                |
| Raft separation distance  | 0 (mm)                      |
| Retraction distance       | 1 (mm)                      |
| Retraction speed          | 20 (mm/s)                   |
| Environmental temperature | Room temperature            |

## 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.

Each user is responsible for determining the safety, lawfulness, technical suitability, and disposal/ recycling practices of Polymaker materials for the intended application. Polymaker makes no warranty of any kind, unless announced separately, to the fitness for any use or application. Polymaker shall not be made liable for any damage, injury or loss induced from the use of Polymaker materials in any application.