

ABS-EC



ABS-EC
Polímeros estirénicos.



ABS-EC

El filamento Kimya ABS-EC 3D pertenece a la familia de polímeros estirénicos. El conductor eléctrico resultante es una combinación de ABS y aditivos eléctricamente activos como los nanotubos de carbono. ABS-EC es resistente al impacto, al calor y al envejecimiento. Se utiliza en las industrias automotriz y electrónica.



PETG ESD



Model PETG
Support PVA

Advanced Settings



Print Mode Balanced

Chamber Temp **55°C**
Extruder 1 Temp **260°C**

Extruder 1 Temp Raft Base **270°C**
Extruder 1 Print Speed - Sparse **40 mm/s**
Extruder 1 Print Speed - Outlines **25 mm/s**

Additional Steps

-Apply a glue stick to the build plate.
-It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.

SEBS 95A for Method Series



Model PETG
Support PVA

Advanced Settings



Print Mode Balanced

Extruder 1 Temp **260°C**

Extruder 1 Temp Raft Base **270°C**
Print Speed - Raft Base **20 mm/s**

Additional Steps

-Build plate may require PP tape for large prints.



ABS CARBON FIBER

Model ABS

Support SR-30

Print Mode Balanced

ABS EC

Model ABS

Support SR-30

Print Mode Balanced

Advanced Settings

Chamber Temp	85°C	Extruder 1 Temp Raft Base	275°C
Extruder 1 Temp	270°C	Top Fill Speed	40 mm/s

ABS ESD

Model ABS

Support SR-30

Print Mode Balanced

Advanced Settings

Chamber Temp	90°C	Roof Surface Speed	10 mm/s
Extruder 1 Temp	260°C	Shell Fan	50%
Roof Solid Speed	20 mm/s		

ABS KEVLAR

Model ABS

Support SR-30

Print Mode Balanced

Advanced Settings

Extruder 1 Temp	250°C
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DURABIO



Model ABS
Support SR-30



Print Mode Balanced



Polylite PC

Model ABS
Support SR-30

Advanced Settings

Print Mode Balanced

Chamber Temp	95°C
Extruder 1 Temp	260°C

Additional Steps

- It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.
- Make sure to clean the nozzle if using a darker color prior to PolyLite™ PC
- Please make sure to clean the nozzle in between prints. You may see burn marks on your print if material accumulates on the nozzle

Polymax PC

Model ABS
Support SR-30

Advanced Settings

Print Mode Balanced

Chamber Temp	85°C	Extruder 1 Temp Raft Base	250°C
Extruder 1 Temp	250°C	E1 Print Speed - Floor Surface	40 mm/s
Support Type	Column	E1 Print Speed - Outlines	50 mm/s

- It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.

Polymax PC-FR

Model ABS

Advanced Settings

Support SR-30

Print Mode Balanced

Chamber Temp **95°C**
Extruder 1 Temp **270°C**

Additional Steps

- It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.
- If stringiness is observed, please dry the material.
- PC-FR sticks extremely well to the Grip Surface of the METHOD build plate, so you will have to replace it more frequently than with ABS.
- When printing sharp overhangs, it is recommend to change the following additional custom settings:

Extruder 1 Temp **270°C**
Number of Shells **4**
Extruder 1 Cooling Fan Speed Outlines **30%**

Polymax PC-PBT

Model ABS

Advanced Settings

Support SR-30

Print Mode Balanced

Chamber Temp **95°C**
Extruder 1 Temp **270°C**

Additional Steps

- It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.
- If stringiness is observed, please dry the material.
- PC-PBT sticks extremely well to the Grip Surface of the METHOD build plate, so you will have to replace it more frequently than with ABS.
- Parts larger than 4x4 inches may result in minor curl.
- When printing sharp overhangs, it is recommend to change the following additional custom settings:

Extruder 1 Temp **290°C**
Number of Shells **4**
Extruder 1 Cooling Fan Speed Outlines **30%**

