Durabio

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Material con alto grado de transparencia

Durabio

DURABIO ™ es un material de impresión 3D de ingeniería sin BPA y de base biológica desarrollado por Mitsubishi Chemical. Con alta transparencia similar al PMMA pero mejor comportamiento al impacto y mejor resistencia al calor.

JABIL

PETG ESD

Model PETG
Support PVA
Print Mode Balanced

Advanced Settings

Chamber Temp	**55°C**	Extruder 1 Temp Raft Base	**270°C**
Extruder 1 Temp	**260°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
Print Mode Balanced

Advanced Settings

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.

KIMYA
Additive Manufacturing by ARMOR

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

ABS KEVLAR

Model ABS
Support SR-30

Print Mode Balanced

Advanced Settings

Extruder 1 Temp	**250°C**

DURABIO

Model ABS
Support SR-30

Print Mode Balanced

Polylite PC

Model ABS
Support SR-30

Print Mode Balanced

Advanced Settings

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

Print Mode Balanced

Advanced Settings

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
Support SR-30
Print Mode Balanced

Advanced Settings

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
Support SR-30
Print Mode Balanced

Advanced Settings

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%**