

PETG ESD



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Material con una excelente tenacidad y durabilidad.



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Los filamentos PETg 0800 ESD son de fácil procesamiento y disipadores electrostáticos (ESD) con un buen equilibrio de propiedades en las direcciones XY y XYZ. Este filamento proporciona una excelente tenacidad y durabilidad.



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
Extruder 1 Temp

85°C
270°C

Extruder 1 Temp Raft Base
Top Fill Speed

275°C
40 mm/s

ABS ESD

Model ABS

Support SR-30

Print Mode Balanced

Advanced Settings

Chamber Temp
Extruder 1 Temp
Roof Solid Speed

90°C
260°C
20 mm/s

Roof Surface Speed
Shell Fan

10 mm/s
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

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%**

