



HIGHEST RATED FILAMENT ON AMAZON  
60-DAY MONEY BACK GUARANTEE

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### Description:

A cold-water soluble thermoplastic polyvinyl alcohol support filament that is perfect for being a support material for primary filaments that print on a bed at less than 50°C.

A suitable primary material would be rigid.ink PLA.

An unsuitable primary material would be a filament such as rigid.ink ABS as that requires a bed temperature (90°C) that is above the Glass Temperature (62°C) of the PVA support filament.

### Applications:

Dissolvable support material for complex objects where self-supporting prints are not viable.

### Recommended Print Settings:

Printing Temps 1.75mm	190-205°C
Printing Temps 2.85mm	195-210°C
Heated Bed Temp	None-45°C
Cooling Fans	As primary material, preferably 100%
Ideal Build Volume	Doors and covers open/removed
Extrusion Multiplier	x1.0 (100%)
Retraction (direct drive)	Try 1mm as a starting point at 20-30mm/s
Retraction (bowden feed)	Speed as above, but try 3mm as a starting point
Print Speed Advisory	Print slow – 50% or less than primary material
Print Surface Advisory	Degrease print surface thoroughly
Print Layer Advisory	None
Other	Extremely hygroscopic (absorbs moisture readily from the air)

## General Advice:

Do not keep the filament idle in the nozzle at 180°C or over for more than 5 minutes as it will hydrolyse in the nozzle and may block the nozzle.

Must be kept in sealed bag or container with active desiccant when not in use.

It is advisable to dry this filament before each use.

## Properties:

Typical Properties <sup>(1)</sup>	Value
Density	0.75g/cm <sup>3</sup>
Glass Transition Temperature	62°C
Melt Flow Rate (190°C, 21.6kg)	14-20g/10 min
Melting Temperature	163°C
Volatile Content [w%]	1 (0.2)
Methanol Content [w%]	<1
Solubility	Cold Water

(1) NOT to be construed as specifications

## Other Info:

Damp filament can be dried at 50-55°C for 8-12 hours in a circulating air dryer.

## Print Surface Materials:

Some bed surfaces may need extra help in maintaining good adhesion. Use of a washable surface treatment such as 3DLAC or PVA filament dissolved in a little water and applied to the bed before printing can improve the situation drastically.

Always degrease the print surface before each print.

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Please note that the information given in this Technical Data Sheet, including, but not limited to, data, statements and typical values, are given in good faith. They are provided as an aid for material selection purposes only. The values and information presented on this sheet are typical values and should not be interpreted as being absolute or precise specifications. Colour pigments may induce variance in printing settings between filament colours.