

PolyDissolve™ S2 is a dissolvable support designed to work with high temperature materials such as PC, ABS and ASA based filaments from our portfolio. It can withstand the high heated chamber temperatures required to print these materials while also providing the perfect interface surface. You will require some additional equipment to dissolve S2 support which will be detailed out along with the process in this document.

## Printing PolyDissolve™ S2

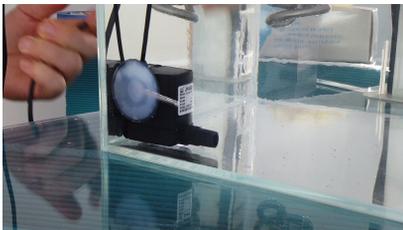
Nozzle Temperature: 230°C – 250°C  
Printing Speed: 30mm/s – 40mm/s  
Bed Temperature: 90°C – 110°C  
Bed Surface: Work on most surfaces designed for high temperature materials.  
Cooling Fan: OFF

## Equipment Required for Dissolving:

3D Wash Solvent  
Water Heater  
Temperature Controller  
Water Tank  
pH Paper  
PPE  
Tongs

## Process of Dissolving PolyDissolve™ S2 Support

1. Install water pump
2. Install water heater and temperature controller, set temperature to 70-85°C
3. Create alkaline solution, You will require an equal weight of 3D wash to PolyDissolve™ S2 printed support. E.g. If you need to dissolve 100g of printed support, add 100g of 3D wash to 4l of water.
4. Check pH (Target 10.5)
5. Submerge parts
6. Rinse in cold water



### Solution Ratios:

Printed Support: 1  
PolyDissolve™ Solute: 1  
Water: 40  
Solute Concentration: 2.5%

## Disposal of support solution

Check your local environmental guidelines on the disposal of alkaline solutions. This changes from region to region, however, it is good practice to neutralize the alkaline solution before disposal.

If your local regulations require a lower pH level, use citric acid (0.5%-1%) to neutralise the pH level. 20-40g of citric acid per 4 liters of water will return the pH to 7-8