

Technical Data Sheet

PolyDissolve™ S2

www.polymaker.com

V5.1



PolyDissolve™ S2

PolyDissolve™ S2 is a dissolvable support for PC, ABS and ASA based filaments from our portfolio. It is specifically engineered to have a perfect interface with these materials while also displaying good solubility.

PHISICAL PROPERTIES

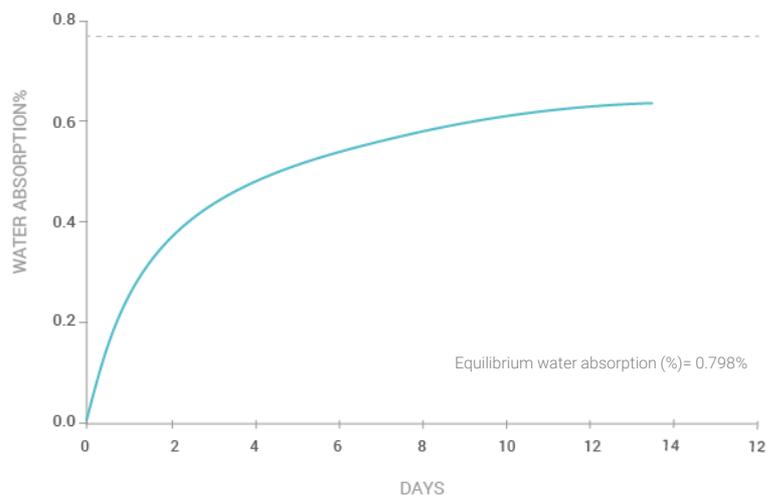
Property	Testing Method	Typical Value
Density	ISO1183, GB/T1033	1.1 g/cm ³ at 23 °C
Melt index	250°C, 2.16kg	4.4 g/10min

THERMAL PROPERTIES

Property	Testing Method	Typical Value
Glass transition temperature	DSC, 10°C/min	93 °C
Vicat softening temperature	ISO 306, GB/T 1633	113 °C

MOISTURE ABSORTION CURVE

PolyDissolve™ S2
70%RH - 23°C



Material Compatibility

Material	Adhesion with PolyDissolve™ S2
PLA based material from Polymaker's portfolio	N/A
PETG based material from Polymaker's portfolio	N/A
ABS based material from Polymaker's portfolio	++
ASA based material from Polymaker's portfolio	++
PC based material from Polymaker's portfolio	++
PVB based material from Polymaker's portfolio	N/A
TPU based material from Polymaker's portfolio	N/A
Nylon based material from Polymaker's portfolio	+

- ++ support the model very well
- + generally support the model depending on its geometry
- generally doesn't support the model depending on its geometry
- do not support the model

Warning: PolyDissolve S2 needs to be dissolved in 75°C lye, it isn't recommended to work with PVA and PLA based filaments

RECOMMENDED PRINTING CONDITIONS

* Based on 0.4 mm nozzle and Simplify 3D v.4.0. Printing conditions may vary with different nozzle diameters

Parameter	
Nozzle temperature	230 – 250 (°C)
Build surface material	BuildTak®, Glass
Build surface treatment	Glue
Build plate temperature	90 - 110 (°C)
Cooling fan	OFF
Printing speed	30-40 (mm/s)
Raft separation distance	0 (mm)
Retraction distance	1 (mm)
Retraction speed	20 (mm/s)
Environmental temperature	Room temperature

Note:

- PolyDissolve™ S2 can be used without moisture-proof treatment.

DISCLAIMER:

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End- use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

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