

# AquaPrint

## MATERIAL PROPERTIES

Bulk density	0.6-0.9 g/cm <sup>3</sup>
Melt flow index	60-90 g/10min (200°C, 21.6kg)
Melting temperature	180-190°C
Glass transition temperature	60-65°C
Volatiles content	<1% wt.
Methanol content	<1% wt.

## GUIDELINE FOR PRINT SETTINGS\*

Nozzle temperature	190 - 215°C
Bed temperature	25 - 70°C
Active cooling fan	0 - 50%
Layer height**	0.05 - 0.3 mm
Shell thickness**	0.4 - 2.7 mm
Print speed**	20 - 50 mm/s
Closed chamber	not necessary
Dry box	Yes
Ruby or hardened nozzle	No

\* settings are based on a 0.4mm nozzle

\*\* depending on the geometrical complexity

### Disclaimer

The product- and technical data provided in this datasheet is correct to the best of Spectrum Group Sp. z o.o. knowledge and are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary according to printing conditions, model complexity, environmental conditions, etc. The user assumes all responsibility for the use of all information provided and shall verify quality and other properties or any consequence from the use of all such information. Typical values are indicative only and are not to be construed as being binding specifications. Spectrum Group Sp. z o.o. shall not be made liable for any damage, injury or loss induced from the use of Spectrum Group Sp. z o.o. materials in any particular application.

## DESCRIPTION

AquaPrint is a water-soluble support material designed for complex multi-extrusion 3D printing. AquaPrint boasts a flow rate almost four times higher in comparison to PVA based support filaments and reduces dissolving time in water by half. However, the standout feature of AquaPrint is its exceptional adhesion to different materials like PLA, PETG, PA and TPU, offering twice the bonding strength compared to PVA.

## FEAUTURES

- Excellent cold water solubility
- Biodegradable, allowing for responsible disposal through standard wastewater sinks
- Great structural rigidity
- Flow rate nearly 4x higher than PVA-based support filaments

## STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.

## SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at [support@spectrumfilaments.com](mailto:support@spectrumfilaments.com)