Raise3D Industrial PET Support Technical Data Sheet

Raise3D Industrial PET Support Filament is a break-away support material specially designed for PET CF & PET GF. During 3D printing process, it creates a stable support structure, provides proper adhesion to interface with printed parts, and counteract with the warpage tendency, therefore it improves the surface quality for overhangs and cavities of the printed parts significantly; ,The support structure can be easily removed (break-away) by hands from the printed parts after printing process. This support material exhibits a broad compatibility with Raise3D OFP (Open Filament Program) certified carbon fiber reinforced composite filaments and is more cost-effective comparing with water-soluble support material.

Filament Specifications

Property	Testing Method	Roundnes Typical Values
Density (g/cm^3 at 21.5 °C)	ASTM D792	1.16
Melt index (g/10 min)	260 °C, 2.16 kg	5.1
Moisture content (%)	ISO 62: Method	0.4
Odor	/	Almost odorless
Solubility	/	Insoluble in water

Material Compatibility

Material	Compatibility
Raise3D Industrial PET CF & PET GF	++
PET based CF filament	++
PA based Fiber filaments	+
Other CF filaments	+

++ 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.

Note:

1. It is recommended to use hardening steel nozzle, tungsten steel or ruby nozzle to avoid nozzle abrasion.
2. PET Support is sensitive to moisture and should always be stored and used under dry conditions (relative humidity below 15%).
3. Dry PET Support at 70 - 80°C for 4-6 hours before printing, moisture content is crucial for final printed part quality.

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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