



Bilby 3D

MATERIAL DATA SAFETY SHEET

Issued in Australia by Bilby 3D Pty Ltd.

The attached Material Data Safety Sheet has been prepared by the manufacturer outside Australia.

In accordance with Australia WHS regulations the following Australian contact details apply

Section 1: AUSTRALIAN COMPANY DETAILS

In Australia the product is imported and distributed by:
Bilby 3D Pty Ltd

Mailing Address :

Kingsgrove Business Centre, 7/192 Kingsgrove Rd, Kingsgrove NSW 2208

Head Office Address :

Kingsgrove Business Centre, 7/192 Kingsgrove Rd, Kingsgrove NSW 2208

Contact Phone: 1800 847 333

Section 2: AUSTRALIAN EMERGENCY CONTACT

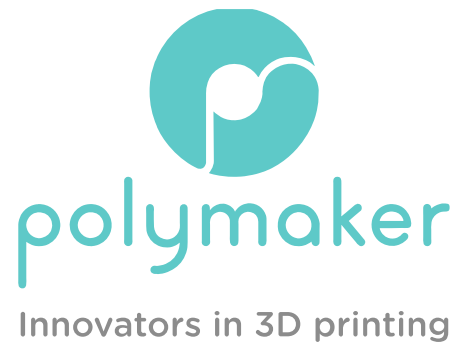
Emergency Contact

In the event of an emergency please contact:

Poisons Information Centre 24 hour Telephone Advice Line on 13 11 26

Section 3: AUSTRALIAN ISSUE DATA

Date of Issue : 1 March 2020



Technical Data Sheet

PolyDissolve™ S1

www.polymaker.com

V5.1



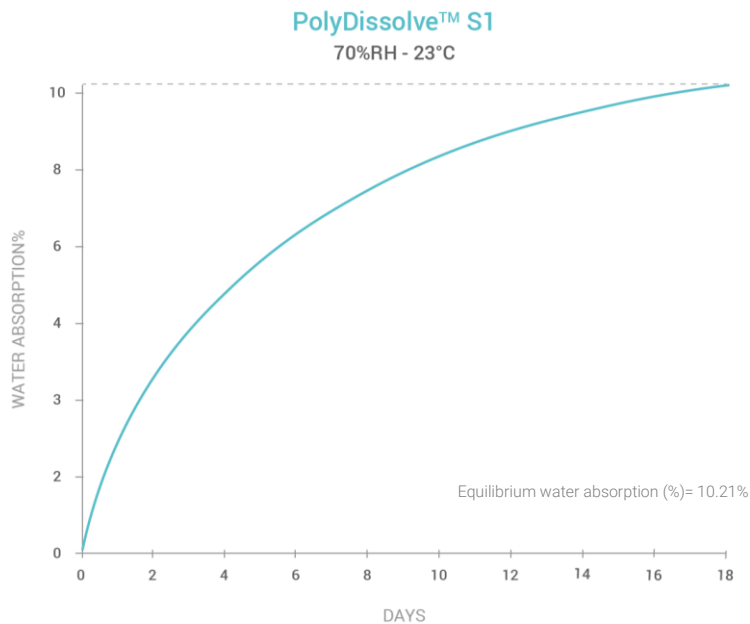
PolyDissolve™ S1

PolyDissolve™ S1 is a water dissolvable support for PLA, TPU, PVB and Nylon based filaments from our portfolio. It is specifically engineered to have a perfect interface with these materials while also displaying good solubility.

PHYSICAL PROPERTIES

Property	Testing Method	Typical Value
Density	ISO1183, GB/T1033	1.13 g/cm ³ at 23 °C
Melt index	220°C, 2.16kg	7.8 g/10min
Light transmission	N/A	N/A
Flame retardancy	N/A	N/A

MOISTURE ABSORPTION CURVE



Material Compatibility

Material	Adhesion with PolyDissolve™ S1
PLA based material from Polymaker's portfolio	++
PETG based material from Polymaker's portfolio	+
ABS based material from Polymaker's portfolio	--
PC based material from Polymaker's portfolio	--
PVB based material from Polymaker's portfolio	++
TPU based material from Polymaker's portfolio	++
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

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	215 – 225 (°C)
Build surface material	BuildTak®, Glass, Blue Tape
Build surface treatment	Glue
Build plate temperature	25 - 60 (°C)
Cooling fan	ON
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:

- It is highly recommended to use the PolyBox™ when printing with PolyDissolve™ S1 and to store it in the resealable bag.

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.

Each user is responsible for determining the safety, lawfulness, technical suitability, and disposal/ recycling practices of Polymaker materials for the intended application. Polymaker makes no warranty of any kind, unless announced separately, to the fitness for any use or application. Polymaker shall not be made liable for any damage, injury or loss induced from the use of Polymaker materials in any application.