



JABIL




PETG ESD for Method Series

 Model PETG	Advanced Settings			
 Support PVA				
 Print Mode Balanced	Chamber Temp	55°C	Extruder 1 Temp Raft Base	270°C
	Extruder 1 Temp	260°C	Extruder 1 Print Speed - Sparse	40 mm/s
			Extruder 1 Print Speed - Outlines	25 mm/s

Additional Steps

-Apply a glue stick to the build plate.
-It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.

SEBS 95A for Method Series

 Model PETG	Advanced Settings			
 Support PVA				
 Print Mode Balanced	Extruder 1 Temp	260°C	Extruder 1 Temp Raft Base	270°C
			Print Speed - Raft Base	20 mm/s




Additional Steps

-Build plate may require PP tape for large prints.




KIMVA

Additive Manufacturing by AMR (3D-C) K




ABS CARBON FIBER for Method X

 Model ABS	
 Support SR-30	
 Print Mode Balanced	




ABS EC for Method X

 Model ABS	Advanced Settings			
 Support SR-30				
 Print Mode Balanced	Chamber Temp	85°C	Extruder 1 Temp Raft Base	275°C
	Extruder 1 Temp	270°C	Top Fill Speed	40 mm/s

ABS ESD for Method X




 Model ABS	Advanced Settings			
 Support SR-30				
 Print Mode Balanced	Chamber Temp	90°C	Roof Surface Speed	10 mm/s
	Extruder 1 Temp	260°C	Shell Fan	50%
	Roof Solid Speed	20 mm/s		

ABS KEVLAR for Method X

 Model ABS	Advanced Settings			
 Support SR-30				
 Print Mode Balanced	Extruder 1 Temp	250°C		




MITSUBISHI CHEMICAL

DURABIO for Method X

 Model ABS	
 Support SR-30	
 Print Mode Balanced	

polymaker




PolyLite PC for Method X

 Model ABS	Advanced Settings			
 Support SR-30				
 Print Mode Balanced	Chamber Temp	95°C		
	Extruder 1 Temp	260°C		

Additional Steps

-It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.
-Make sure to clean the nozzle if using a darker color prior to PolyLite™ PC
-Please make sure to clean the nozzle in between prints. You may see burn marks on your print if material accumulates on the nozzle




Polymax PC for Method X

 Model ABS	Advanced Settings			
 Support SR-30				
 Print Mode Balanced	Chamber Temp	85°C	Extruder 1 Temp Raft Base	250°C
	Extruder 1 Temp	250°C	E1 Print Speed - Floor Surface	40 mm/s
	Support Type	Column	E1 Print Speed - Outlines	50 mm/s

Additional Steps

-It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.

Polymax PC-FR for Method X




 Model ABS	Advanced Settings			
 Support SR-30				
 Print Mode Balanced	Chamber Temp	95°C		
	Extruder 1 Temp	270°C		

Additional Steps

-It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.
-If stringiness is observed, please dry the material.
PC-FR sticks extremely well to the Grip Surface of the METHOD build plate, so you will have to replace it more frequently than with ABS.
-When printing sharp overhangs, it is recommend to change the following additional custom settings:

Extruder 1 Temp	270°C
Number of Shells	4
Extruder 1 Cooling Fan Speed Outlines	30%

Polymax PC-PBT for Method X

 Model ABS	Advanced Settings			
 Support SR-30				
 Print Mode Balanced	Chamber Temp	95°C		
	Extruder 1 Temp	270°C		

Additional Steps

-It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.
-If stringiness is observed, please dry the material.
PC-PBT sticks extremely well to the Grip Surface of the METHOD build plate, so you will have to replace it more frequently than with ABS.
-Parts larger than 4x4 inches may result in minor curl.
-When printing sharp overhangs, it is recommend to change the following additional custom settings:

Extruder 1 Temp	290°C
Number of Shells	4
Extruder 1 Cooling Fan Speed Outlines	30%