

## AquaSys® 120 Soluble Support for Additive Manufacturing

Rev 2: 8/27/19

FEATURE	ADVANTAGE	BENEFIT
Temperature Resistance	Stable with build chamber temperatures of up to 120 °C.	Compatible with several engineering thermoplastics including: PETG, CPE, ABS, Nylon, PC, PC/ABS, TPU, PP and various filled materials.
Water Soluble	Rapidly dissolves in standard tap water at temperatures of 70-80 °C.	No additional chemicals or custom dissolution baths are required.
Adhesion	AquaSys 120 has excellent adhesion to a variety of build materials and build plates including PETG, CPE, Nylon, ABS, TPU, PC, PP and various filled materials.	Allows the production of more uniform parts with fewer defects.
Shrinkage	Very low shrinkage.	Support does not curl during printing.
Shelf Life	If properly stored, AquaSys 120 does not pick up significant moisture.	No unique handling or drying is required if properly stored and kept dry. Drying is required at 70-80°C if material picks up moisture.

### PHYSICAL PROPERTIES

24 hour moisture absorption @ 50% RH and 25 °C	0.3%
Specific Gravity	1.32 g/cm3
Dissolution Rate @ 80 °C in water	15 min to dissolve 1cm cube
Typical printing conditions	220-245 °C extruder temperature Up to RT-130 °C build plate temperature 80-120 °C chamber temperature

### MATERIAL SPECIFICATIONS

Standard Product Forms: 3 mm pellet, 1.75 mm and 2.85 mm filament
Color is natural amber color
Intentionally formulated using environmentally safe materials
Typical printing temperatures

### GENERAL INSTALLATION, USAGE, AND CARE OVERVIEW

Storage and Preparation: Store AquaSys 120 in metallized foil packaging with desiccant. Reseal after use.
See MSDS/SDS for material handling.

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