

## Raise3D Industrial PPA Support Technical Data Sheet

Raise3D Industrial PPA Support Filament is a break-away support material specially developed for PPA filament. During FFF 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; After a print is finished, the support structure can be easily removed (break-away) by hands from the printed parts.

### Filament Specifications

Property	Testing Method	Typical Value
Density (g/cm <sup>3</sup> at 21.5°C)	ISO 1183	1.26
Melt index (g/10 min)	280°C, 2.16 kg	17.5
Odor	/	Almost odorless
Solubility	/	Insoluble in water

### Material Compatibility

Material	Compatibility
PPA neat	++
PPA based filament	++
PPA based CF and GF filaments	++
Other PA based 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:

- It is recommended to use hardening steel nozzle and above grade nozzles.
- PPA Support is sensitive to moisture and should always be stored and used under dry conditions (relative humidity below 15%).
- Dry PPA support in the oven at 80-100°C for 6 hours before printing.



## 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 Raise3D materials for the intended application. Raise3D makes no warranty of any kind, unless announced separately, to the fitness for any particular use or application. Raise3D shall not be made liable for any damage, injury or loss induced from the use of Raise3D materials in any particular application.

