

Technical Data Sheet



Product name: Helios Support

Helios Support is a “high heat” water-soluble PVA material which is engineered as support material for dual extrusion 3D printing in combination with engineering materials which require to be printed at higher temperatures and/or in heated build chambers. Helios support can be printed at nozzle temperatures up to 250° C without the risk of cross linking and nozzle clogging and adheres extremely well to styrene based materials such as ABS, TitanX, Crystal Flex, and ApolloX, but also to Python Flex and Volcano PLA.

Helios Support dissolves slightly slower in water than normal PVA, but the dissolving process can be sped up when using warm and circulating water.

Properties	Typical value	Test Method	Test condition
Physical			
Specific gravity	1.19 g/cc	ISO 1183	-
Melt flow rate	58 g/10min	ISO 1133	260° C/5Kg
Water absorption	-	-	-
Moisture absorption	-	-	-
Mechanical			
Impact strength	-	-	-
Tensile strength	-	-	-
Tensile modulus	-	-	-
Elongation at break	-	-	-
Flexural strength	-	-	-
Flexural modulus	-	-	-
Hardness	-	-	-
Thermal			
Print temperature	± 235 - 255° C	-	-
Melting temperature	-	-	-
Viscat softening temp.	-	-	-
Optical			
Haze	-	-	-
Transmittance	-	-	-
Gloss	-	-	-

Product details, certifications and compliance	
HS Code	39169090
REACH compliant	Yes
RoHS certified	Yes

Diameter	Tolerance	Roundness
1.75mm	± 0.05mm	≥ 95%
2.85mm	± 0.10mm	≥ 95%

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