

BUILDING YOUR RECIPE



PolyJet Support Removal



DEMI

PG 1

① AGITATION



Use with delicate features and thin walls <1/8" 3mm



Use with robust features and thin walls <1/8" 3mm

② TEMPERATURE



Temperature is material & geometry dependant.

Find your material and your respective recommendations.

ABS

Delicate	95°F	35°C
Robust	110°F	43°C

AGILUS

Delicate	95°F	35°C
Robust	110°F	43°C

DURUS

Delicate	90°F	32°C
Robust	105°F	41°C

RIGUR

Delicate	95°F	35°C
Robust	110°F	43°C

TANGO

Delicate	90°F	32°C
Robust	105°F	41°C

VERO

Delicate	90°F	32°C
Robust	105°F	41°C

③ TIME

Choosing your cycle time is heavily dependent on the maximum thickness of support material.



HH:MM

MAXIMUM SUPPORT THICKNESS

1/16 inch 1.6 mm

1/8 inch 3.1 mm

1/4 inch 6.4 mm

1/2 inch 12.7 mm

ESTIMATED CYCLE TIME

1 hour

2 hours

4 hours

8 hours

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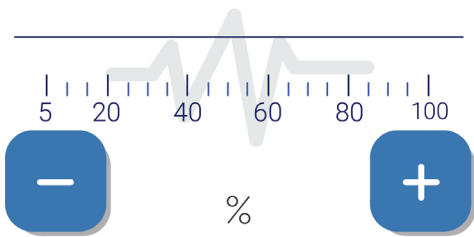
SLA Resin Removal



DEMI

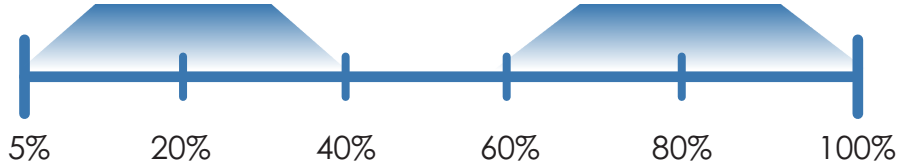
PG 1.2

① ULTRASONICS



Use with basic geometries and no internal channels

Use with complex geometries and internal channels



② TEMPERATURE



Temperature is material & geometry dependant.

Find your material and your respective recommendations.

3D Systems

95°F 35°C

Formlabs

90°F 32°C

Carbon

95°F 35°C

DSM

90°F 32°C

③ TIME

Choosing your cycle time will vary depending on the complexity of the geometry.



The listed resins may be completed much faster and require extra caution when processing.



MM:SS



THE MAJORITY OF RESINS REQUIRE A **MAXIMUM CYCLE TIME OF 10 MINUTES.**

CHECK PROGRESS **EVERY 2 MINUTES** FOR UNIQUE AND FRAGILE GEOMETRIES.

Carbon

CE
EPU 40
EPU 41
UMA 90
PR 25

3D Systems

Figure 4 ELAST BLK
Figure 4 ELAST BLK 10

Formlabs

Flexible