

# PVA-M



PVA-M filament is our preferred, cold water soluble, supporting material for dual extruder 3D printing. The modification on the raw material results in a filament that is much more thermally stable than a regular PVA. It also bonds well to PLA, ABS and PET-G, which enlarges the application field significantly. This polyvinyl alcohol-based filament is non toxic and biodegradable once dissolved in water. Easy printing, much less failures and easy removability makes this the supporting material you should try.

## Material features:

- Improved formula with enhanced stability in printing
- Excellent water solubility
- Thermally much more stable than a regular PVA
- Good bonding to PLA, PET-G and ABS
- Biodegradable when dissolved in water



## Colours:

PVA-M is available in its natural colour. For specific applications PVA-M is available in colours on request

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## Packaging:

PVA-M is available in nearly any type of packaging and labelling, but will be supplied always in a vacuum bag, due to the moisture sensitivity of PVA. Ask our team to help you customizing your product.

## Filament specs.

Size	Ø tolerance	Roundness
1,75mm	± 0,05mm	≥ 95%
2,85mm	± 0,10mm	≥ 95%

## Material properties

Description	Testmethod	Typical value
Specific gravity	ASTM D1505	1,22 g/cc
MFR 220°C	-	2,3 gr/10 min
Tensile (E) modulus	ISO 527	3500 Mpa
Impact Strength Charpy method 23°C	ISO 179	1,7 kJ/m2
Printing temp.	DF	215±10°C
Melting temp.	-	163°C
Vicat softening temp.	ISO 306	60,2°C

## Additional info:

Recommended temperature for heated bed is ± 35-60°C. Do not exceed a printing temperature of 225°C, because then PVA crystallizes quickly and it will no longer flow and/or dissolve in water.

The speed at which the product dissolves in water is dependent on the volume of the printed object and the temperature of the water. PVA-M dissolves in cold water. Higher water temperature (up to 70°C is no problem) will accelerate the dissolution.

PVA-M can be used on all common desktop FDM or FFF technology 3D printers.

Storage: Cool and dry (15-25°C) and away from UV light. This enhances the shelf life significantly.