Introducing High-Performance Soluble Support
AquaSys 12O is a patent-pending soluble support that can be used in conjunction with engineering thermoplastics in additive manufacturing processes. The support material is made of non-toxic ingredients and can be easily removed by exposure to warm water.

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

- 24 hour moisture absorption @ 50% RH and 25 ºC: 0.3%
- Specific Gravity: 1.32 g/cm3
- Dissolution Rate @ 80 ºC in water: 15 min to dissolve 1cm cube

**TYPICAL PRINTING CONDITIONS**

- 220-245 ºC extruder temperature
- Up to RT-130 ºC build plate temperature
- 80-120 ºC 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.