

TECHNICAL DATA SHEET

ODS-20

ODS-20 - compared to water-soluble materials, ODS-20 is a mixture of polymers based on acrylate and is soluble in a mild alkaline solution. As a result, prints are less sensitive to moisture, have higher durability and consistent quality over time. ODS-20 is characterized by very good adhesion to models made e.g. of PEEK, PA, PC, ABS / PC, TPE, ASA, ABS or PET.

PHYSICAL PROPERTIES

	VALUE	UNIT	TEST METHOD
Density	1,1	g/cm ³	-
Minimum pH value to dissolve	>10		

THERMAL PROPERTIES

	VALUE	UNIT	TEST METHOD
Glass transition temperature	108	°C	-
MFI (MFR) 200°C/10kg	1-10	g/10 min	-

RECOMMENDED PRINTING PARAMETERS



Nozzle temperature

220-260°C



Bed temperature

60-80°C



Print speed

30-60mm/s



Temperature to dissolve

20 - 30°C