

TECHNICAL DATA SHEET

Prima Creator Select BVOH

Product code:	Revision Number:	Revision date:	TDS No.:
Select BVOH	01	15/07/2024	KT055

Characteristic:

Water soluble support material|Faster dissolution rate|Support multiple materials

IDENTIFICATION OF THE MATERIAL

Trade name	Select BVOH
Chemical name	Polyvinyl alcohol compound
Use	3D Printing
Origin	Prima Creator

GUIDELINE FOR PRINT SETTINGS

Nozzle temperature	210~230℃
Bed temperature	30~60℃
Bed modification	Tape or glue below 60℃
Active cooling fan	ON
Layer height	0.2mm
Shell thickness	≥0.8mm
Print speed	40~100mm/s

Settings are based on a 0.4mm nozzle.

MATERIAL PROPERTIES

		Test Method
Melt flow rate (MFR) ¹	10-15g/10min	ISO 1133
Heat deflection temperature(HDT) ²	53.8℃	ISO 75
Vicat softening temperature(VST) ³	62.9℃	ISO 306
density	1.09g/cm ³	ISO 1183
Odor	Odorless	/
Solubility	Dissolve in water	/

1.test conditions: T= 220℃; m= 2.16kg.

2. test conditions:0.45MPa;120℃/h.

3. test conditions:10N; 120℃/h.

MECHANICAL PROPERTIES|TENSILE TEST

Test Method ISO 527

All test specimens were printed using an

Bambu Lab X1C under the

following conditions:

Printing temperature: 220°C

Heated bed temperature: 55°C

Print speed: 100mm/s

Shell thickness: 1.2mm

Infill under 45°



Printed horizontal X,Y-axis

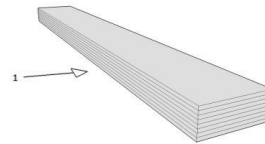
Infill	100%
Tensile strength (Mpa)	30-40
Elongation at break (%)	18-25
E modulus (Mpa)	1800-2200

MECHANICAL PROPERTIES|IMPACT TEST

Test Method ISO 179

The same conditions as tensile test.

1→impact direction



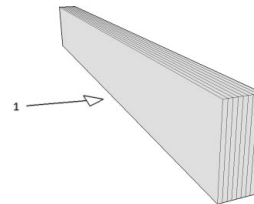
Infill	100%
Impact strength (KJ/m ²)	13-15
Notch impact strength ¹ (KJ/m ²)	1-5

MECHANICAL PROPERTIES |FLEXURAL TEST

Test Method ISO 178

The same conditions as tensile test.

1→bending direction



Infill	100%
Maximum force (Mpa)	45-55
Flexural modulus (Mpa)	1300-1800

1. notch type: type A

FILAMENT SPECIFICATION		Test Method
Diameter 1.75mm	1.75±0.03mm	EX1125
Diameter 2.85mm	2.85±0.03mm	EX1125
Max roundness deviation (1.75)	0.03mm	EX1125
Max roundness deviation (2.85)	0.03mm	EX1125
Net weight on reel	1kg	EX1125