

Print third-party materials on an industrial 3D printing platform with modular hardware and advanced print settings.

Quickly swap between a model extruder for highly repeatable, dimensionally accurate parts with MakerBot Materials, to the LABS GEN 2 Experimental Extruder for dozens of verified third-party material options and unlimited open-materials experimentation.

The MakerBot LABS Experimental Extruder for METHOD is an experimental product and not covered under MakerCare or warranty.



JABIL

PETG ESD

	Model PETG	Advanced Settings			
	Support PVA				
	Print Mode Balanced	Chamber Temp	55°C	Extruder 1 Temp Raft Base	270°C
		Extruder 1 Temp	260°C	Extruder 1 Print Speed - Sparse	40 mm/s
				Extruder 1 Print Speed - Outlines	25 mm/s

Additional Steps

- Apply a glue stick to the build plate.
- It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.

SEBS 95A for Method Series

	Model PETG Support PVA	Advanced Settings			
	Print Mode Balanced	Extruder 1 Temp	260°C	Extruder 1 Temp Raft Base Print Speed - Raft Base	270°C 20 mm/s

Additional Steps

- Build plate may require PP tape for large prints.

KIMYA

Additive Manufacturing by AR&O R

ABS CARBON FIBER

	Model ABS Support SR-30
	Print Mode Balanced

ABS EC

Model ABS		Advanced Settings			
Support SR-30					
	Print Mode Balanced	Chamber Temp	85°C	Extruder 1 Temp Raft Base	275°C
		Extruder 1 Temp	270°C	Top Fill Speed	40 mm/s

ABS ESD

	Model ABS	Advanced Settings			
	Support SR-30	Chamber Temp	90°C		
		Extruder 1 Temp	260°C	Roof Surface Speed	10 mm/s
	Print Mode Balanced	Roof Solid Speed	20 mm/s	Shell Fan	50%

ABS KEVLAR

	Model ABS Support SR-30	Advanced Settings		
	Print Mode Balanced	Extruder 1 Temp	250°C	

mitsubishi

CHEMICAL

DURABIO

	Model ABS Support SR-30
	Print Mode Balanced

polymaker

PolyLite PC

	Model ABS Support SR-30	Advanced Settings		
	Print Mode Balanced	Chamber Temp	95°C	

Additional Steps

- It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.
- Make sure to clean the nozzle if using a darker color prior to PolyLite™ PC
- Please make sure to clean the nozzle in between prints. You may see burn marks on your print if material accumulates on the nozzle

Polymax PC

	Model ABS	Advanced Settings			
	Support SR-30	Chamber Temp	85°C	Extruder 1 Temp Raft Base	250°C
		Extruder 1 Temp	250°C	E1 Print Speed - Floor Surface	40 mm/s

Additional Steps

- It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.

Polymax PC-FR

	Model ABS Support SR-30	Advanced Settings		
	Print Mode Balanced	Chamber Temp	95°C	

Additional Steps

- It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.
- If stringiness is observed, please dry the material.
- PC-FR sticks extremely well to the Grip Surface of the METHOD build plate, so you will have to replace it more frequently than with ABS.
- When printing sharp overhangs, it is recommend to change the following additional custom settings:

Extruder 1 Temp	270°C				
Number of Shells	4				
Extruder 1 Cooling Fan Speed Outlines	30%				

Polymax PC-PBT

	Model ABS Support SR-30	Advanced Settings		
	Print Mode Balanced	Chamber Temp	95°C	

Additional Steps

- It is recommended to use a material caddy, such as the Polybox Edition 2, since the material absorbs moisture from the air.
- If stringiness is observed, please dry the material.
- PC-PBT sticks extremely well to the Grip Surface of the METHOD build plate, so you will have to replace it more frequently than with ABS.
- Parts larger than 4x4 inches may result in minor curl.
- When printing sharp overhangs, it is recommend to change the following additional custom settings:

Extruder 1 Temp	290°C				
Number of Shells	4				
Extruder 1 Cooling Fan Speed Outlines	30%				