# Technical Document

## RS PRO - PVA HT+

**Stock numbers:**
**174-0078 / 174-0079**

EN

**PVA HT+ is our specially developed water soluble solution for dual extrusion when you need to print with styrene based materials. PVA HT+ has an excellent adherence to ABS, ABS-X, ASA-X, GLASSBEND and TPU98A. PVA HT+ dissolves slightly slower than regular PVA and it is advised to dissolve in luke-warm water, preferably in circulated water. PVA HT+ can handle higher nozzle temperatures (<250˚C) without the risk of cross linking and clogging the nozzle and is therefore perfect for printing with styrene based materials which typically print at higher temperatures.**


**Material features:**

- Great adhesion to styrene based materials
- Stable at higher nozzle temperatures (<250˚C)
- Good dissolvability in luke warm water
- Biodegradable when dissolved in water
- Performs in heated environments up to 55-60 ˚C

**Colours:**
RS PRO - PVA HT+ is available in its natural colour.

**Packaging:**
RS PRO - PVA HT+ is available in 500 grams packaging and will be supplied in a vacuum bag, due to the moisture sensitivity of PVA HT+

| Filament specs. | | |
|---|---|---|
| Size | Ø tolerance | Roundness |
| 1,75mm | ± 0,05mm | ≥ 95% |
| 2,85mm | ± 0,10mm | ≥ 95% |
| **Material properties** | | |
| Description | Testmethod | Typical value |
| Specific gravity | ISO 1183 | 1,19 g/cc |
| MFI 190˚C / 21,6kg | ISO 1133 | 58 g/10min |
| Printing temp. | Print Lab | 245±10˚C |

**Additional information:**
PVA HT+ works with most adhesion techniques used for technical materials, but is best used with specialized 3d printing adhesion sprays or a glue stick.
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 HT+ can be used on most Dual printing 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.