Raise3D Pro2 Series PVA Setup

PVA (polyvinyl alcohol) material is a notoriously difficult water soluble material that can be used as an easily-removable support material for complex prints.
The following guide will instruct you in the best practices for setting up the PVA side of your dual extrusion print.
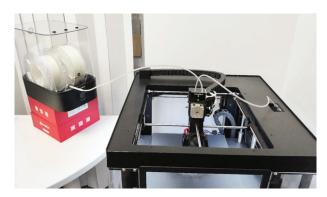
Best practices for printing with PVA Material.

- For best results, use Raise3D PVA filament with a PolyBox.

-Always print PVA from the right hot-end.
- Ensure your 3D Printing Build Surface is clean and has a fresh coat of PVA Glue applied to it.
*Elmer's PVA Glue stick recommended

- When printing with PVA, always print with your printer's lid removed.

- PVA material is sensitive to moisture. Additional drying may be required if the spool has been opened or exposed to high humidity for an extended period of time. You do not need to dry Raise3D PVA filament when opening a new spool of Raise3D PVA.

- If you have left your Raise3D PVA loaded into your machine for more than 12 hours without printing, unload the filament and trim the exposed filament back to the spool. This includes any unspooled material that has been sitting in the feed tube and entering the print head. Discard this section of filament.

- Always store your PVA in a sealed bag with desiccant when not in use.

Position The PolyBox
Install a new spool of Raise3D PVA into the PolyBox.
The PolyBox should be positioned about 6-8" from the printer.

The feed holes should face the direction of the printer, and should be about 1-3" above the top lip of the machine.

*** It is not recommended to place your PolyBox above or below your Raise3D Pro2 3D Printer when printing PVA

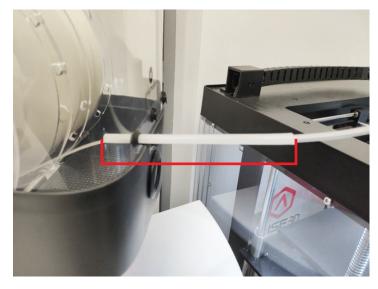## Insert Feed Tube

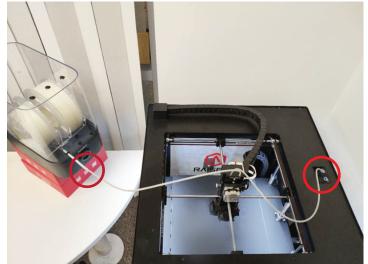Cut a 5-7" length of the 6mm feed tube that comes with the PolyBox.
Insert this tube into the opening located in front of your spool.

*** Do not use the feed holes located on top of the PolyBox

Disconnect the right hot end's feed tube from the blue coupler located on the right side of the machine. Press and hold the blue ring on the coupler to release and slowly remove the tube

Insert the tube end into the 6mm feed tube that you just installed into the PolyBox. Insert it 2-3" into the tube.

Feed Material

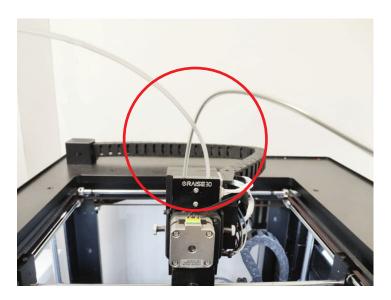At this point you can feed Your Raise3D PVA filament through the feed tube to prepare for loading.

*** Ensure that your spool is located directly in front of the associated feed tube and that the filament is feeding from under the spool. Filament should NOT feed over the top of the spool.

Load Material

Ensure the feed tube from the PolyBox crosses
IN FRONT of the feed tube going to the left hot-end.
Load your PVA material into the right hot-end.
and load your Raise3D PVA filament in to the right
hot-end.
*** The recommended load temperature for Raise3D PVA is
225- 235 C

For additional information on filament loading and PLA material, refer to the video link available below.

Unboxing Video Instruction
available at: youtu.be/20qeZe1jDaQ