

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




Additional Steps

- Build plate may require PP tape for large prints.




KIMYA

Additive Manufacturing by AR&O



ABS CARBON FIBER

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

ABS KEVLAR

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




mitsubishi chemical

DURABIO

 Model ABS	Advanced Settings		
 Support SR-30			
 Print Mode Balanced			

polymaker




PolyLite PC

 Model ABS	Advanced Settings		
 Support SR-30			
 Print Mode Balanced	Chamber Temp	95°C	
	Extruder 1 Temp	260°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			
 Print Mode Balanced	Chamber Temp	85°C	Extruder 1 Temp Raft Base 250°C
	Extruder 1 Temp	250°C	E1 Print Speed - Floor Surface 40 mm/s
	Support Type	Column	E1 Print Speed - Outlines 50 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	Advanced Settings		
 Support SR-30			
 Print Mode Balanced	Chamber Temp	95°C	
	Extruder 1 Temp	270°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	Advanced Settings		
 Support SR-30			
 Print Mode Balanced	Chamber Temp	95°C	
	Extruder 1 Temp	270°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%