Which support interface material works with each filament?

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Abstract. Print only the interface in a material that won't bond: PETG under PLA, PLA under PETG, ABS or ASA under nylon. Makers then allow a 0 mm top Z distance.

Keywords: supports, pla, petg

1 Which support interface material works with each filament?

Print the support in your part's material and switch only the top interface layers to one that does not bond to it: PETG under PLA, PLA under PETG, a dedicated ABS support under ABS, ABS or ASA under nylon. Set it as "Support/raft interface" in Bambu Studio or OrcaSlicer, and makers allow a 0 mm top Z distance.

1.1 The number

Table 1. The number

Your part	Interface material	Listed by
PLA	PETG	Bambu Lab, Prusa
PLA	Breakaway support: Support for PLA, Support for PLA/PETG, UltiMaker Breakaway, PolySupport for PLA	Bambu Lab, UltiMaker, Polymaker
PLA	PVA, dissolves in water	Bambu Lab, UltiMaker
PETG	PLA	Bambu Lab, Prusa
PETG	Breakaway support: Support for PLA/PETG, UltiMaker Breakaway	Bambu Lab, UltiMaker
PETG	PVA, dissolves in water	Bambu Lab
PETG	HIPS, dissolves in limonene	Prusa
ABS	Support for ABS, dissolves in limonene	Bambu Lab
ABS	UltiMaker Breakaway	UltiMaker
Nylon: PA6-GF	ABS	Bambu Lab
Nylon: PA6-CF, PAHT-CF	ASA, printed as the whole support	Bambu Lab
Nylon	UltiMaker Breakaway, PVA	UltiMaker
Nylon: PA12 and other long-chain nylon	PolySupport for PA12	Polymaker
PC	PolySupport for PLA, rated to support "depending on its geometry"	Polymaker
PC	None: UltiMaker PC is flagged compatible with neither PVA nor Breakaway	UltiMaker
TPU	PLA	Bambu Studio and OrcaSlicer pairing rules

Bambu Lab rows come from its Support wiki page, its PLA and PETG support guide and its store pages for Support

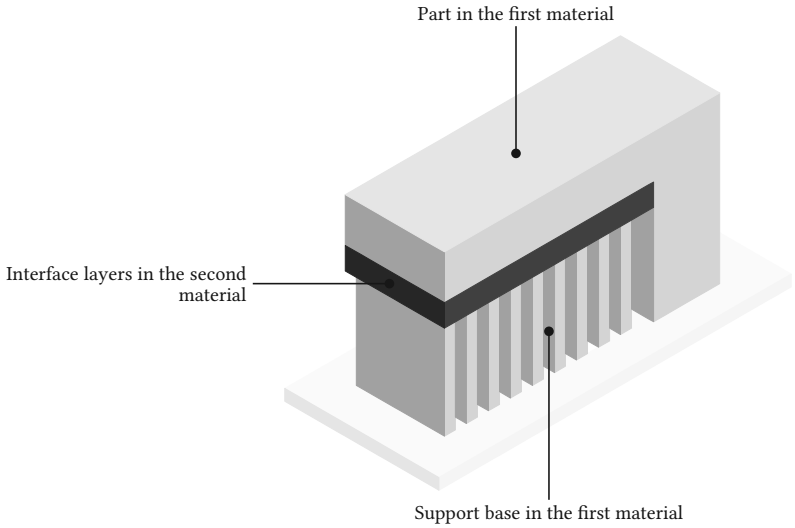


Figure 1. Only the interface layers that touch the part are switched to the second material, while the support base and the part stay in the first.

for PLA/PETG, Support for ABS and Support for PA/PET. UltiMaker rows come from the material profiles in its fdm_materials repository at tag 5.14.0 and its Breakaway data sheet, Prusa rows from its Knowledge Base, and Polymaker rows from the compatibility tables in its wiki data sheets. The TPU row is from the pairing rules in Bambu Studio v02.09.01.70 and OrcaSlicer v2.5.0.

1.2 Why does a different interface material peel off cleaner?

Because the two plastics barely fuse, the support can touch the part with no gap. In one material, support and part weld together, so slicers leave an air gap called the top Z distance. Its field default is 0.2 mm in Bambu Studio, OrcaSlicer and PrusaSlicer. Bambu Lab's wiki keeps about 0.2 mm when the interface is the body filament, or the support is "really hard to remove".

With a dedicated support filament, Bambu Lab says the gap can be 0 and the supported surface comes out smooth. It says PLA and PETG "don't bond well to each other", and its Support for PLA/PETG is formulated to minimize fusion with both "thanks to differences in polarity".

Only the interface needs the second material. Bambu Lab puts support filament on the interface alone, with the base in the main filament, to save time and filament. Its PLA and PETG guide adds that a full base in the second material lengthens the print and risks the support falling off.

1.3 What support interface material works for PLA and PETG?

For PLA: PETG, a PLA breakaway support or PVA (polyvinyl alcohol). For PETG: PLA, Support for PLA/PETG, UltiMaker Breakaway or PVA. The makers' own lists set two limits:

- **Not every PLA or PETG qualifies.** Bambu Lab's guide covers only PLA Basic with PETG HF or PETG Basic. It excludes PLA Matte, PLA Silk, PLA-CF, PETG Translucent, PETG-CF and third-party spools. Its store adds that PETG Matte is not recommended as a support for PLA.
- **A PLA support is not a PETG support.** Bambu Lab lists its Support for PLA for PLA only. Polymaker rates its PolySupport for PLA "-" on PETG, meaning it generally doesn't support the part. Support for PLA/PETG covers both; with tree supports, Bambu Lab says to keep it off the "Support/raft base".

For water-soluble interfaces, see PVA soluble supports.

1.4 What support interface material works for ABS?

Use Bambu Lab's Support for ABS, which it lists for ABS only, or UltiMaker Breakaway. Bambu Lab says Support for ABS allows a 0 top Z distance and 0 top interface spacing. When the part needs layer strength, Bambu Lab raises the flushing volume above 800 mm³, because incomplete flushing weakens the layers level with the support surface. It warns of styrene fumes: print it in an enclosed printer in a ventilated room.

HIPS (high-impact polystyrene) dissolves in limonene and is also printed under ABS. Prusa marks it unsuitable for ABS or ASA supports, because those plastics partially dissolve in the same solvent. If you use it anyway, Prusa says to loosen the supports with a brief dip and pull them by hand. PVA is not an ABS option: UltiMaker's PVA lists PLA, CPE (its co-polyester) and nylon, and Polymaker rates its PolyDissolve S1 "do not support" on ABS.

1.5 What support interface material works for nylon?

For nylon (PA), Bambu Lab now points to its ABS and ASA: ABS for PA6-GF, ASA for PA6-CF and PAHT-CF. It has dis-

continued its Support for PA/PET. Its tests found ASA holds PA6-CF and PAHT-CF weakly, so an ASA interface alone can fall off; print the whole support in ASA. It also warns that these pairs warp at the edges on high-infill parts, where it suggests self-support.

UltiMaker lists Breakaway and PVA as matching supports for its Nylon. Polymaker rates its PolySupport for PA12 for long-chain nylon only, not short-chain nylon. Nylon and its supports absorb moisture: Bambu Lab says to remove supports within 2 hours of the print ending, and to dry the part first if they have stuck.

1.6 Is there a support interface material for PC?

Few makers list one for polycarbonate (PC). Polymaker rates its PolySupport for PLA "+" on its PC filaments, meaning it supports the part depending on geometry, and reports positive feedback on small PC parts. It advises against swapping the two in a single nozzle because of clogs, and recommends an IDEX (independent dual extruder) or tool-changer printer.

UltiMaker flags its PC as compatible with neither PVA nor Breakaway, and Polymaker rates its PolyDissolve S1 "do not support" on PC. Bambu Lab's support guide names no PC interface and warns that its Support for PLA under ABS, ASA, PC or PAHT-CF can clog the extruder or nozzle. Without a listed pair, support PC in PC and keep a top Z gap.

1.7 How do you set a support interface in a different material?

Assign the second material to the interface only and leave the base on the part's own material:

- **Bambu Studio and OrcaSlicer:** Process, Support tab. Set "Support/raft interface" to the second filament and leave "Support/raft base" on Default, which uses the filament of the current layer. For a dedicated support filament, PETG under PLA, or PLA under PETG or TPU, both slicers offer to set top Z distance and top interface spacing to 0. The same offer switches the interface pattern to Rectilinear Interlaced and "Independent support layer height" off, and Bambu Studio adds thick bridges off. Both warn that non-soluble support materials are not recommended for the support base.
- **PrusaSlicer:** Print Settings, Multiple Extruders. Set "Support material/raft interface extruder" to the second extruder and "Support material/raft/skirt extruder" to 0, the current extruder. Under Support material, set "Top contact Z distance" to "0 (soluble)". With a wipe tower and non-organic supports, PrusaSlicer 2.9.7 then requires "Synchronize with object layers", and at any other contact distance it refuses a separate support extruder.
- **UltiMaker Cura:** turn on "Enable Support Interface", then pick the extruder in "Support Interface Extruder", or "Support Roof Extruder" for the top only. Cura's "Support Top Distance" follows the "Support Z Distance" of the roof extruder, so set the gap in that extruder's settings.

Drop the top Z distance to 0 only for a pair a maker lists. For every other case, see choosing the gap.

2 Can you use PETG as support for PLA?

Yes. Bambu Lab and Prusa both list PETG as a support for PLA: the two bond poorly, so it peels off cleanly. Bambu Lab's guide prints PETG only as the interface over a PLA base at 0 mm top Z distance, with PETG HF at 265 °C, PLA at 230 °C and the bed at 60 °C.

2.1 What settings does Bambu Lab give for PETG supports on PLA prints?

Table 2. What settings does Bambu Lab give for PETG supports on PLA prints?

Setting	PLA Basic part, PETG interface
Support/raft base	PLA, the part's filament
Support/raft interface	PETG HF or PETG Basic
Top Z distance, Bottom Z distance	0 mm
Top interface layers	3
Top interface spacing	0 mm
Nozzle temperature, all layers	PLA Basic 230 °C, PETG HF 265 °C, PETG Basic at its default
Bed temperature	60 °C on a Smooth PEI or Textured PEI plate
PETG max volumetric speed	10 mm^3/s
Enclosed printer	Door or top cover open

Every row is from Bambu Lab's PLA and PETG support guide and its settings screenshot. It says to dry both spools first, since PETG prints hot enough that moisture in the PLA causes stringing and oozing.

Prusa's version, for the Original Prusa XL, prints the whole support in the second material. Its "SOLUBLE FULL" print profile sets "Top contact Z distance" to 0, 3 top interface layers and 0.1 mm "Interface pattern spacing". Prusa suggests unticking "With sheath around the support", a perimeter wall that otherwise makes the supports very hard to remove.

2.2 Can you use PLA as support for PETG?

Yes, the same pair reversed. Bambu Lab's guide prints PLA Basic only as the interface on a PETG base. PLA runs at 230 °C on all layers and PETG at its default, both on a 60 °C bed. On enclosed printers, open the door or top cover so the chamber does not get too hot for PLA.

In Bambu Lab's test print, the PLA interface left a cleaner surface than PETG supports. It also finished 1 hour 20 minutes sooner than an all-PLA support, because the printer switched nozzles less often. Prusa reports the pair tested with success.

2.3 How to check it on your own print

1. **Match the exact filament, not just its type,** to a pair in the table. Makers' guides leave out some lines, as Bambu Lab's does with matte and silk PLA.
2. **Dry both spools.** Bambu Lab's guide asks for it before its PLA and PETG pair.

3. **Set the interface filament** as above and leave the base on the part's material. Accept the slicer's zero-gap suggestion only for a pair a maker lists.
4. **Slice and check the preview by filament.** The second material should appear only in the layers touching the part.
5. **On a single nozzle, purge fully between materials,** or use two nozzles as Polymaker recommends (clogs after a PETG to PLA swap).
6. **Pull the supports soon after the print,** within 2 hours for nylon and PVA by Bambu Lab's advice. If they still stick, see why supports are hard to remove.

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