



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	°C	230-250	internal
plate temp	°C	85-100	internal
min. nozzle diameter	mm.	0.4	internal
fan	%	0-30	internal
print speed	mm/l°	30-40	internal
PROPERTY			
Physical			
Specific gravity	g/cm ³	1	ISO 1183
Water absorption	%	0.5	ISO 62
Mechanical at 23°C / 50% rh			
Tensile strain at break	MPa	40	ISO 527
Charpy impact (23°C)	kJ/m ²	no break	ISO 179
Charpy impact (-30°C)	kJ/m ²	no break	ISO 179
Hardness	sh/A - sh/D	90 - 42	ISO 62
Thermal			
Melting point	°C	160	ISO 11357
Vicat softening temp.	°C	131	ISO 306

Disclaimer

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ADDITIONAL INFORMATIONS

In General filaments made with Flexibility+ (TPA) can be processed on conventional 3D printer using FDM / FFF technology.

Flexibility (TPA) is a special elastomer polyamide based developed for 3D printing and to obtain best results we recommend pre drying the filaments at 65° for 2 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 210°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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