

## TECHNICAL DATE SHEET

## FILOFlex SOFT

BASE MATERIAL: Thermoplastic Polyester-Polyurethane (> 80%) - Shore A 81

### PROPERTIES

PROPERTIES	VALUE	METOD AND CONDICTION	
PHYSICAL & MECHANICAL	Density	1,22 g/cm <sup>3</sup>	DIN EN ISO 1183-1-A
	Elongation at break	750,00%	DIN 53504-S2 / ISO 37
	Tensile strength at break	50 Mpa	DIN 53504-S2 / ISO 37
	Stress at 20 % elongation	2 Mpa	DIN 53504-S2 / ISO 37
	Stress at 100 % elongation	4 Mpa	DIN 53504-S2 / ISO 37
	Stress at 300 % elongation	8 Mpa	DIN 53504-S2 / ISO 37
	Tear strength	60 N/mm	DIN ISO 34-1Bb
THERMAL	Abrasion loss	40 mm <sup>3</sup>	DIN ISO 4649-A
	Charpy (notched)	no break	DIN EN ISO 179-1
	Compression set at room temperature	25%	DIN ISO 815
	Compression set at 70 °C	35%	DIN ISO 815

### SUGGESTED PRINTER SETTING

PARAMETERS	VALUE	UNIT
Extruder Temperature	200-230	°C
Print Speed	15 - 40	mm/s
Bed Material	0 - 40	°C
Drying Temperature	100 °C for 4-6 hr	dry conditions is recommended

### PRODUCT DETAILS & CERTIFICATION

Diameter	1,75 mm 2,85 mm	Tolerance ± 0,05mm Tolerance ± 0,10mm
REACH compliant		compliant
ROHS certified		compliant
FDA compliant		not compliant

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