



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	215-235	internal
plate temp	C°	cold to 45	internal
min. nozzle diameter	mm.	0,3	internal
fan	%	0-50	internal
print speed	mm/l°	25-35	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.24	ISO 1183
Mechanical at 23°C / 50% rh			
Tensile strain	MPa	55	ISO 37
Charpy impact (23°C)	kJ/m <sup>2</sup>	no break	ISO 179
Charpy impact (-30°C)	kJ/m <sup>2</sup>	no break	ISO 179
Elongation at break	%	600	ISO 37
Compression set (70°C)	%	45	ISO 815
Abrasion loss	mm <sup>3</sup>	30	ISO 4649
Hardness	sh/A	90	ISO 62

### Disclaimer

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### ADDITIONAL INFORMATIONS

In General filaments made with Flexmark 9 (TPU) can be processed on conventional 3D printer using FDM / FFF technology.

Flexmark 9 (TPU) is a special polyurethane developed for 3D printing and to obtain best results we recommend pre drying the filaments at 70° for 2 h. Increase drying time for spools up 1 kg.  
More than 3 hours can change melt flow index.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 180°, 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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