



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	°C	215-235	internal
plate temp	°C	45-90	internal
min. nozzle diameter	mm.	0,35	internal
fan	%	0-30	internal
print speed	mm/l°	25-40	internal
PROPERTY			
Physical			
Specific gravity	g/cm <sup>3</sup>	1.11	ISO 1183
Water absorption	%	0,8	ISO 62
Mechanical at 23°C / 50% rh			
Tensile strain at break	%	>825	ISO 527
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
Flexural modulus	MPa	32	ISO 178
Hardness	sh/A - sh/D	90-42	ISO 62
Thermal			
Vicat softening temp.	°C	185	ISO 306

### Disclaimer

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### ADDITIONAL INFORMATIONS

In general filaments made with ULTRAFLEXX+ (TPE) can be processed on conventional 3D printer using FDM / FFF technology.

ULTRAFLEXX+ (TPE) is a special copolyester elastomer 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 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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