

Fillamentum Flexfill TPE 96A Fillamentum Flexfill TPE 90A

(Thermoplastic elastomer based on polyolefins)

Printing temperature: 225 - 245 °C

Heated bed temperature: 50 - 60 °C

Speed: 15 - 25 mm/s (depending on Shore hardness,
lower Shore needs to be printed slowly)

Part cooling fan: 50 - 100 %

Heated bed surface: PEI, mirror / glass

Adhesive: PP, 3DLac, blue tape

Raft / skirt / brim: Brim recommended, skirt

Heated chamber / enclosure: not needed

Extrusion multiplier: 1-1.1

Adhesion

- The best results were achieved while using Magigoo PP, which ensures perfect adhesion.
- It is recommended to use brim around the object.

Bridges and overhangs

- Overhangs can be printed very well. Bridges can be little bit challenging. From start, it's better to use supports.

Printing speed

- Regarding the Shore hardness, slow is the key. The softer material the lower speed is required.

Storing

- Airtight bag with desiccant.
- For perfect top/bottom surface, we recommend use 1.1 extrusion multiplier to ensure connection between top/bottom infill.
- It is possible to achieve different hardness of printed object. Settings of infill and perimeters influences the final properties.