

TECHNICAL DATA SHEET

FILAFLEX 60A 'PRO'

Description

Filaflex is a Thermoplastic Polyether-Polyurethane elastomer with additives that allow high printability in FDM printers. Filaflex® has a remarkable hydrolysis resistance, high resistance to bacteria and low temperature flexibility properties in printed parts.

Physical Property	Value	Unit	Test method according to
Material density	1,07	g/cm ³	ISO 1183

Mechanical Property	Value	Unit	Test method according to
Hardness	63	shore A	DIN ISO 7619-1 (3s)
Tensile strength	26	MPa	DIN 53504-S2
Elongation at break	950	%	DIN 53504-S2
Stress at 20% elongation	1	%	DIN 53504-S2
Stress at 100% elongation	3	%	DIN 53504-S2
Stress at 300% elongation	5	%	DIN 53504-S2
Tear strength	40	N/mm	ISO 34-1
Abrasion resistant	45	mm ³	ISO 4649
Compression set 23°C/72 hours	40	%	ISO 815
Compression set 70°C/24 hours	25	%	ISO 815

Thermal Property	Value	Unit	Test method according to
Glass Transition Temperature 10°C/min	-54	°C	ISO 11357-1/-2
VST Vicat Softening Temperature	70	°C	Método Vicat A: 10 Nw, 120°C/h

Printing Properties	Recommended
Printing temperatures	215-235°C
Printing speed	20-30 mm/s
Hot-bed temperature	21°C
Optimal layer height	0,2 mm
Minimal nozzle	0,4 mm or higher
Retractions	3,5-6,5 mm (speed 20 - 160mm/s)