

TECHNICAL DATE SHEET

FILOFlex HARD

BASE MATERIAL: Thermoplastic Polyester-Polyurethane (> 80%) - Shore D 55

PROPERTIES

PROPERTIES	VALUE	METOD AND CONDICTION	
PHYSICAL & MECHANICAL	Density	1,25 g/cm ³	DIN EN ISO 1183-1-A
	Elongation at break	500,00%	DIN 53504-S2 / ISO 37
	Tensile strength at break	45 Mpa	DIN 53504-S2 / ISO 37
	Stress at 20 % elongation	13 Mpa	DIN 53504-S2 / ISO 37
	Stress at 100 % elongation	16 Mpa	DIN 53504-S2 / ISO 37
	Stress at 300 % elongation	23 Mpa	DIN 53504-S2 / ISO 37
	Tear strength	150 N/mm	DIN ISO 34-1Bb
	Abrasion loss	25 mm ³	DIN ISO 4649-A
Charpy (notched)	no break	DIN EN ISO 179-1	
THERMAL	Compression set at room temperature	30%	DIN ISO 815
	Compression set at 70 °C	45%	DIN ISO 815

SUGGESTED PRINTER SETTING

PARAMETERS	VALUE	UNIT
Extruder Temperature	200-230	°C
Print Speed	15 - 40	mm/s
Bed Material	0 - 50	°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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