

TECHNICAL DATA SHEET

FILAFLEX FOAMY

| Physical Property | Value | Unit | Test method according to |
|---------------------------------|--------------|-------------------|---------------------------------|
| Filament density | 1,200 | g/cm ³ | ISO 1183 |
| | 1200 | kg/m ³ | ISO 1183 |
| | 95 | shore A | DIN ISO 7619-1 (3s) |
| Printing density 250°C 90% Flow | 1,080 | g/cm ³ | ISO 1183 |
| | 1080 | kg/m ³ | ISO 1183 |
| | 90 | shore A | DIN ISO 7619-1 (3s) |
| Printing density 250°C 80% Flow | 0,950 | g/cm ³ | ISO 1183 |
| | 950 | kg/m ³ | ISO 1183 |
| | 61 | shore A | DIN ISO 7619-1 (3s) |
| | 65 | shore A | DIN ISO 7619-1 (3s) |
| Printing density 250°C 70% Flow | 0,800 | g/cm ³ | ISO 1183 |
| | 800 | kg/m ³ | ISO 1183 |
| | 70 | shore A | DIN ISO 7619-1 (3s) |

| Mechanical Property ⁽¹⁾ | Value | Unit | Test method according to |
|---|--------------|-------------|---------------------------------|
| Tensile strength | 33 | MPa | DIN 53504-S2 |
| Elongation at break | 400 | % | DIN 53504-S2 |
| VST Vicat Softening Temperature | 115,0 | °C | Vicat A Method: 10 Nw, 120°C/h |

(1) Characterization of the non-foamed filament that can be affected depending on the printing parameters.

| Printing Propierties | Recomnended |
|-----------------------------|--------------------------------------|
| Printing temperatures | 245-255°C |
| Printing speed | 20-40 mm/s |
| Optimal layer height | 0,2 mm |
| Retractions speed | 35-50 mm/s at a distance of 2,5-6 mm |
| Travelling | 160-200 mm/s |
| Tolerance | 0,04 mm |