

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 properties	Value	Unit	Test method according to
Material density	1.07	g/cm ³	DIN EN ISO 1183-1-A

Mechanical properties	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	MPa	DIN 53504-S2
Stress at 100% elongation	2.5	MPa	DIN 53504-S2
Stress at 300% elongation	4.5	MPa	DIN 53504-S2
Tear strength	40	N/mm	DIN ISO 34-1Bb
Abrasion loss	45	mm ³	DIN ISO 4649-A
Compression set 23°C / 72 hours	40	%	DIN ISO 815
Compression set 70°C / 24 hours	25	%	DIN ISO 815

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 diameter	0.4 mm or higher
Retraction parameters	3.5 - 6.5 mm (speed 20 - 160 mm/s)