

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