

# Flexible 98A TDS

## Thermoplastic Polyuretane (TPU) for FDM Printers

### Product Description

AzureFilm flexible filament consistency and printability outperforms other polyurethane materials. With its core formula and ultra resistant materials used as base mixture, allows printing at a high speed while maintaining firm and smooth outprints. Filament can be used for most types of 3D printers, with emphasis on direct driven extruders.

### Properties

Property of 3D printed specimens	Test method	Value
Material	Thermoplastic Polyuretane	Color White
Density	DIN 53516	1,15 – 1,17 g/cm <sup>3</sup>
Tear strenght	DIN 53515	120 N/MM
Tensile modulus 300%	DIN 53515	15 MPa
Tensile strength	DIN 53504	45 MPa
Abrasion resistance	DIN 53516	30 mm <sup>3</sup>
Elongation at break	DIN 53504	350%
Hardness	DIN 53505	98 Shore A

### Test specimens print settings

3D printer: AzureFilm	Infill: 100 %	Nozzle temperature: 230 °C
Slicer: Cura	Retraction: 0	Bed temperature: 60 °C
Nozzle: 0,4 mm	Layer height: 0,2 mm	Print speed: 30 mm/s

### Printing Recommendations

Nozzle temperature: 200 – 230°C

Heated bed: recommended 60 °C

Print speed: 10 – 30 mm/s

Build platform: Blue tape, Kapton tape. Recommended: Glass bed + Dimafix spray