

Technical Data Sheet Plexiwire Flex 90A

Description

Plexiwire FLEX is a Term Polyurethane 3D printing filament for FDM/FFF printers, available in 300m, 200m and 100m spools.

Material Properties

Density	1,22 g/cm ³	DIN 53479
Shore hardness A	90	DIN 53505
Tensile Strength (Machine Direction)	35 MPa	DIN 53504
Elongation at Rupture (Machine Direction)	500,00%	DIN 53515
Tear Propagation Strength (Machine Direction)	90 N/mm	DIN 53515
Abrasion Resistance	35 mm ³	DIN 53516

Guideline for print settings*

Nozzle temperature	230-250°C
Bed temperature	50-80°C
Active cooling fan	YES (up to 100%)
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	15-50 mm/s
Closed chamber	not necessary
Dry box	recommended
Ruby or hardened nozzle	not necessary

* settings are based on a 0,4 mm nozzle.

** depending on the geometrical complexity

Filament Specification

Nominal diameter	1,75mm
Diameter tolerance	+3%
Ovality	$\geq 97\%$
Available colors	black
Netto filament weight	300m = 0,9kg $\pm 5\%$, 200m = 0,6kg $\pm 5\%$, 100m = 0,3kg $\pm 5\%$