

TECHNICAL DATA SHEET

FILAFLEX FOAMY

Physical Property	Value	Unit	Test method according to
Filament density	1,050	g/cm ³	ISO 1183
	1050	kg/m ³	ISO 1183
	82	shore A	DIN ISO 7619-1 (3s)
Printing density 250°C 90% Flow	0,945	g/cm ³	ISO 1183
	945	kg/m ³	ISO 1183
	78	shore A	DIN ISO 7619-1 (3s)
Printing density 250°C 80% Flow	0,814	g/cm ³	ISO 1183
	814	kg/m ³	ISO 1183
	61	shore A	DIN ISO 7619-1 (3s)
	70	shore A	DIN ISO 7619-1 (3s)
Printing density 250°C 70% Flow	0,709	g/cm ³	ISO 1183
	709	kg/m ³	ISO 1183
	60	shore A	DIN ISO 7619-1 (3s)

Mechanical Property ⁽¹⁾	Value	Unit	Test method according to
Tensile strength	37	MPa	DIN 53504-S2
Elongation at break	740	%	DIN 53504-S2
VST Vicat Softening Temperature	94,0	°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