

# Fillamentum Flexfill TPE 96A Fillamentum Flexfill TPE 90A

(Thermoplastic elastomer based on polyolefins)

**Printing temperature:** 225 - 245 °C

**Heated bed temperature:** 50 - 60 °C

**Speed:** 15 - 25 mm/s (depending on Shore hardness,  
lower Shore needs to be printed slowly)

**Part cooling fan:** 50 - 100 %

**Heated bed surface:** PEI, mirror / glass

**Adhesive:** Magigoo PP, 3DLac, blue tape

**Raft / skirt / brim:** Brim recommended / skirt

**Heated chamber / enclosure:** not needed

**Extrusion multiplier:** 1 - 1.1

**Adhesion** - The best results were achieved while using Magigoo PP, which ensures perfect adhesion. It is recommended to use brim around the object.

**Bridges and overhangs** - Overhangs can be printed very well. Bridges can be little bit challenging. From start, it's better to use supports.

**Printing speed** - Regarding the Shore hardness, slow is the key. The softer material the lower speed is required.

**Storing** - Airtight bag with desiccant.

For perfect top / bottom surface, we recommend use 1.1 extrusion multiplier to ensure connection between top / bottom infill.

It is possible to achieve different hardness of printed object. Settings of infill and perimeters influences the final properties.