

Fillamentum Flexfill PEBA 90A

(Polyether-block-amide)

Printing temperature: 225 – 245 °C

Heated bed temperature: 70 – 90 °C

Speed: 20 – 40 mm/s (up to 50–60 mm/s)

Part cooling fan: 0 – 50%

Heated bed surface: mirror / glass, (PEI)

Adhesive: PVA glue, Magigoo PA

Raft / skirt / brim: Brim 5 mm

Heated chamber / enclosure: recommended

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- Adhesion** - It is recommended to use brim around the printed object. The best adhesion was achieved on the mirror / glass surface. It is also possible to print on PEI but could be a little bit challenging.
- Cooling** - It's necessary to slow down the part cooling fan. Too high part cooling fan speed or too fast cooling of the printed object can lead to warping. It is recommended to turn off the part cooling fan for several first layers.
- Storing** - Airtight bag with desiccant.
In the case of moist material, re-dry it in an appropriate device. The conditions to achieve an optimal level of moisture are 70 °C for 3 hours. Processing of moist filament may cause degradation of polymer chains, brittleness, poor layer adhesion, stringing, oozing, etc.
- Printing speed** - Although this material belongs to the Flexfill family, it can be processed relatively quickly. For the beginning it is good to start at 20–30 mm/s and then increase the speed, depending on your 3D printer and experiences.