

# Fillamentum Flexfill TPU 98A Fillamentum Flexfill TPU 92A

(Thermoplastic polyurethane)

**Printing temperature:** 220 – 240 °C

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

**Speed:** 15 – 30 mm/s (depending on Shore hardness,  
lower Shore needs to be printed slowly)

**Part cooling fan:** 70 – 100 %

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

**Adhesive:** PVA gluestick, Magigoo

**Raft / skirt / brim:** skirt

**Heated chamber / enclosure:** not needed

**Extrusion multiplier:** 1.05 – 1.1

- Adhesion** - It is recommended to use PVA gluestick for build plate, because TPU sticks very well to PEI, glass / mirror. Using PVA separation layer ensures easy removing of printed object from the build plate.
- Bridges and overhangs** - Overhangs can be printed very well. Bridges can be little bit challenging.
- Printing speed** - Regarding the Shore hardness, slow is the key. The softer material the lower speed is required.
- Storing** - Airtight bag with desiccant. TPU absorbs moisture from air. If the filament is wet, you can see bubbles, stringing etc. at the printed object. Conditions for re-drying of the wet filament depend on the hardness: 92A at 80 °C for 3–4 hours / 98A at 100 °C for 3–4 hours.

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.