



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	190-210	internal
plate temp	C°	cold to 40	internal
min. nozzle diameter	mm.	0,35	internal
fan	%	0-30	internal
print speed	mm/l°	40-50	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.4	ISO 1183
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	19.6	ISO 527
Tensile strength at yield	MPa	13	ISO 527
Tensile strain at yield	%	19	ISO 527
Elongation at F max	%	450	ISO 527
Hardness	sh/D	47	ISO 868

Disclaimer

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ADDITIONAL INFORMATIONS

In general filaments made with KYOTOFLEX can be processed on conventional 3D printer using FDM / FFF technology.

KYOTOFLEX is a special biodegradable elastomer developed for 3D printing and to obtain best results we recommend pre drying the filaments at 60° for 2 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 170°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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