

TPE-SEBS I300 85A FILAMENT

RECOMMENDED PRINT SETTINGS



PRINT TEMPERATURE

- The optimal printing range is 240 – 250° C



BED TEMPERATURE

- A bed temperature of 70°C will provide the best adhesion during printing.



PRINTING SPEED

- Base printing speed of 25 mm/s
- Infill speed of 25-30 mm/s
- Wall speed of 25-30 mm/s
- Initial Layer speed of 10 mm/s



COOLING

- For best results do not use a cooling fan while printing with TPE-SEBS.



BED ADHESION

- Use a brim when printing on clean glass. When using a PEI sheet, use a skirt on a clean plate. There is no need for any additional adhesion methods.



OTHER TIPS

- For best results, print TPE-SEBS 85A on a direct-drive printer. If attempting to print on a Bowden-style printer, using a PTFE or fluoropolymer-lined Bowden tube will increase success.
- If the material starts to short feed or bind up in the extruder, turn down the feeder wheel tension. It is recommended to start with as little tension as possible.

If using Ultimaker Cura, enable the Lumas TPE-SEBS 1300 85A material profile available in the Marketplace or manually type in the settings from the information above.

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TPE-SEBS I300 85A FILAMENT

TPE SEBS 85A is a soft material great for prototyping where rubber-like or elastomeric properties and durability are required. TPE SEBS properties are similar to rubber and other thermoplastic elastomers, including being soft to the touch while maintaining a strong and flexible durability.

APPLICATIONS

- Automotive, aerospace, general manufacturing
- Complex geometries
- Parts that need to dampen vibrations
- Products that need to retain flexible properties under weather or heat exposure

Examples include:

- Seals
- Gaskets
- No skid / no mark feet
- No slip mats for auto interiors
- Soft touch grip for power tools

ADVANTAGES

- Easier to print than TPU filaments
- Shore 85A elastomer
- High flexibility, bend and stretch (can stretch over 500%)
- Low moisture absorption
- Less visible layer lines
- Does not require drying to process
- Works on all open platform direct-drive 3D printers (including desktop with PTFE Bowden tubes)

DIAMETERS

- 2.85mm



QUESTIONS? VISIT [LUMASPOLYMERS.COM](https://lumaspolymers.com) FOR THE LATEST PRINT PROFILES.