

# TPU 90A FILAMENT

## RECOMMENDED PRINT SETTINGS



### PRINT TEMPERATURE

- The optimal printing range is 220 – 230° C



### BED TEMPERATURE

- Up to 50° C



### PRINTING SPEED

- Base printing speed of 20 mm/s
- Infill speed of 15 mm/s
- Wall speed of 18 mm/s
- Initial layer speed of 15 mm/s



### COOLING

- For the best results cool to 100%.



### BED ADHESION

- Use a heated build plate, brim, or PVA glue stick.



### OTHER TIPS

- Use low extruder motor tension.

If using Ultimaker Cura, enable the Lumas TPU 90A material profile available in the Marketplace or manually type in the settings from the information above.

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## PETG FILAMENT

TPU 90A is an easy processing, standard product for printing jobs requiring rubber-like elasticity. This filament is ideal when low scratch and mar or soft touch feel are needed along with improved impact strength. It delivers rubber-like elasticity and is resistant to abrasions and performs well even at low temperatures.

### APPLICATIONS

- Automotive, aerospace, general manufacturing
- Can be used for parts that need to maintain flexibility and/or require a resistance to oils, greases, and other solvents

Examples include:

- Jigs, fixtures, and tooling
- Touch pads
- Grips
- Soft feet with low coefficient of friction (CoF)
- Seals

### ADVANTAGES

- Easy printability, very consistent results
- Abrasion resistance
- Soft-touch properties
- Impact strength
- Elastomeric properties
- Operating temperature range of  $-40^{\circ}\text{C}$  to  $95^{\circ}\text{C}$
- Good chemical resistance to oils, greases, and other solvents

### DIAMETERS

- 1.75mm
- 2.85mm



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