LUMAS POLYMERS

LUMAFUSE TPE-SEBS 1300 95A FILAMENT

RECOMMENDED PRINT SETTINGS

PRINT TEMPERATURE

- The optimal printing range is 230 – 270° 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 15-25 mm/s
- Wall speed of 15-25 mm/s
- Initial layer speed of 15-25 mm/s

COOLING

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

BED ADHESION

- Use a brim while printing on clean glass or a PEI sheet. No glue or extra adhesion method is necessary.

OTHER TIPS

- 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.
- Using a PTFE or fluoropolymer-lined tubing will help with printing. Using this type of tube will allow the print temperature to be lower.

If using Ultimaker Cura, enable the Lumas LumaFuse TPE-SEBS 1300 95A material profile available in the Marketplace or manually type in the settings from the information above.

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LUMAFUSE TPE-SEBS 1300 95A FILAMENT

LumaFuse TPE-SEBS 95A is a soft material great for prototyping where rubber-like or elastomeric properties and durability are required. LumaFuse TPE-SEBS 1300 95A is slightly firmer than LumaFuse TPE-SEBS 1300 85A for application requirements that call for flexibility but also need more rigidity to achieve the optimal finished part performance.

APPLICATIONS

- Automotive, aerospace, general manufacturing
- Parts that require toughness and resilience as well as some flexibility and fatigue resistance along with elastomeric properties that can bend, flex and stretch
- Complex geometries

Examples include:

- Automotive interior trim components
- Packaging closures
- Covers and housings
- Grips
- No slip feet for electronic and mechanical components
- Gap seals

ADVANTAGES

- High print success rates
- Very low warpage and curl
- No need for heated print bed or drying requirements
- Shore 95A elastomer
- High flexibility, bend and stretch
- Non-hygroscopic, does not absorb moisture
- Durable with repetitive motions
- Less visible layer lines, less warp

DIAMETERS

- 1.75mm
- 2.85mm

QUESTIONS? VISIT LUMASPOLYMERS.COM FOR THE LATEST PRINT PROFILES.