



PolyFlex™ TPU95

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My first print

1) Prepare the gcode

Download the MyFirstPrint.stl on www.polymaker.com

Load the stl file in your favorite slicer.

Enter the correct settings for PolyFlex™ TPU95;

Property	Value
Nozzle temperature	210°C - 230°C
Bed temperature	25°C - 60°C
Nozzle speed	20mm/s – 40mm/s
Cooling fan	ON
Layer height	0.1
Infill	20%
Number of outlines (shell)	3
Top/Bottom layers	4

Note: It is recommended to slightly increase the extrusion multiplier (+0.05) to ensure a more consistent extrusion.

2) Prepare the printer

- Clean the build plate and prepare it with the right surface:
We recommend to print **PolyFlex™ TPU95** on BuildTak®, glass with glue or painters tape.
- Level the build plate.
- It is recommended to clean the nozzle when you change the material to prevent partial clog.

Note: It is recommended to place the printer in a well ventilated area.

3) Prepare the filament

- Carefully open the resealable bag, remove the spool and close the bag back to preserve the desiccant bag.
- It is recommended to store **PolyFlex™ TPU95** in the **PolyBox™** to prevent moisture absorption which will lower the quality and the mechanical properties of the print.
- Load the filament in your printer and wait until you have a consistent extrusion.
- At the end of the print, make sure to correctly store the filament back in the resealable bag if you are not using the **PolyBox™**.

4) Start the print

When the print begins, make sure the first layer is correctly laid down and sticking well to the bed before leaving the printer to finish the print.

PolyFlex™ TPU95

PolyFlex™ TPU95 is a thermoplastic polyurethane (TPU) based filament specifically engineered to work on most desktop 3D printers. It has a shore hardness of 95A and can stretch more than 3 times its original length.

Available colors:      

Physical properties

Property	Testing method	Typical value
Density	ASTM D792 (ISO 1183, GB/T 1033)	1.20 – 1.24 (g/cm ³ at 21.5 °C)
Melt Index	210 °C, 1.2 kg	3-6 (g/10 min)

Mechanical properties

Property	Testing method	Typical value
100% modulus (X-Y)	ASTM D638 (ISO 527, GB/T 1040)	9.4 ± 0.3 (MPa)
Tensile strength (X-Y)	ASTM D638 (ISO 527, GB/T 1040)	29.0 ± 2.8 (MPa)
Elongation at break (X-Y)	ASTM D638 (ISO 527, GB/T 1040)	330.1 ± 14.9 (%)
Shore hardness	ASTM D2240 (ISO 7619, GB/T 31)	-95A

Drying settings

70 °C for 12h

Diameter accuracy (2.85/1.75 mm):

70%	is within	+/- 0.01
97%	is within	+/- 0.02
99%	is within	+/- 0.03
99.9%	is within	+/- 0.04

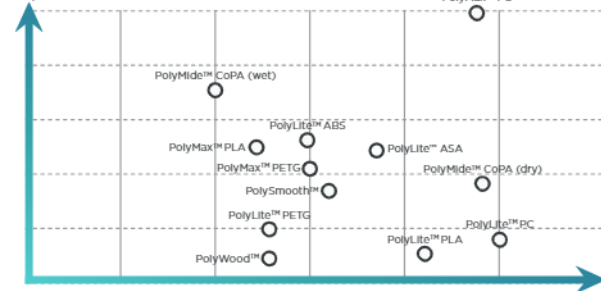
Weight accuracy:

600g	+/-	20g
750g	+/-	20g
1000g	+/-	30g
3000g	+/-	60g

TOUGHNESS

Impact Strength

25kJ/m²



STIFFNESS

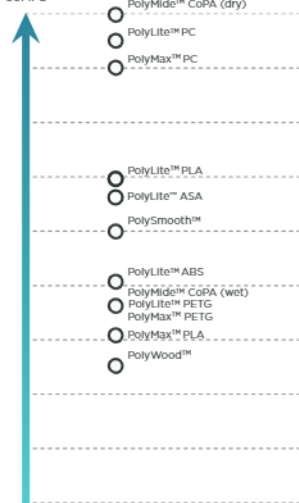
Bending Strength

100MPa

STRENGTH

Tensile Strength

66MPa



HEAT RESISTANCE

Heat Softening Temp

180°C

160°C

140°C

120°C

100°C

80°C

60°C

40°C

20°C

0°C

PolyMide™ CoPA (dry)

PolyMax™ PC

PolyLite™ PC

PolyLite™ ASA

PolyLite™ ABS

PolyLite™ PETG

PolyMax™ PETG

PolySmooth™

PolyLite™ PLA

PolyMax™ PLA

PolyWood™

Product Families



PolyLite™

ABS, PETG, PLA, PC, ASA

PolyLite™ is a family of 3D printing filaments made with the best raw materials to deliver exceptional quality and reliability. PolyLite™ covers the most popular 3D printing materials to meet your everyday needs in design and prototyping.



PolyMax™

PLA, PC, PETG,  PC-FR

The PolyMax™ is a family of advanced 3D printing filaments produced with Polymaker's Nano-reinforcement technology, to deliver exceptional mechanical properties and printing quality.



PolyFlex™

TPU95

PolyFlex™ is a family of high-quality flexible materials. It provides the perfect solution for applications where high flexibility and durability are required.



PolyMide™

CoPA, ⚙ PA6-CF, ⚙ PA6-GF

PolyMide™ is a family of Nylon/polyamide based filaments. Produced with Polymaker's Warp-Free™ technology, PolyMide™ filaments deliver engineering properties intrinsic to Nylon and ease of printing.



PolyDissolve™

S1, S2

PolyDissolve™ is a family of dissolvable support filaments. This family offers support solution for our portfolio of filaments. It enables a greater design freedom.



Specialty

PolyWood™, PolySupport™, PolySmooth™, PolyCast™

⚙ Polymaker™ PC-ABS, ⚙ Polymaker™ PC-PBT

The Specialty family provides unique filaments from Polymaker to unlock new 3D printing applications.



Hardware

Polysher™, PolyBox™

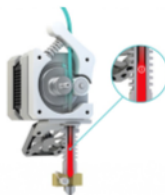
Polymaker offers 3D printing accessories to optimize the user experience with their filaments.

Technologies

JAM-FREE™

Jam-Free™ technology improves the heat stability of Polymaker's PLA filaments with softening temperatures over 140 °C. As a result, Polymaker's PLA filaments show minimal softening in the "cold end" and can melt rapidly once entering the heating zone, leading to excellent printing quality with zero risk of nozzle jams.

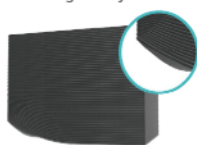
Regular PLA



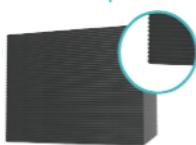
With Jam-Free™



Regular Nylon



With Warp-Free™



WARP-FREE™

Warp-Free™ technology enables the production of Nylon-based filaments that can be 3D printed with excellent dimensional stability and near-zero warpage. This is achieved by the fine control of micro-structure and crystallization behavior of Nylon, which enables the material to fully release the internal stress before solidification.

ASH-FREE™

Ash-Free™ technology allows Polymaker's filament which has been designed for investment casting to burn off cleanly without any residue, enabling defect-free metal parts. 3D printing has been used to produce investment casting patterns as it cuts down both the cost and lead time for small-volume production runs.

Without Ash-Free™

Ash content: 0.5%



With Ash-Free™

Ash content: 0.003%



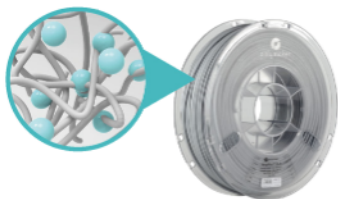
LAYER-FREE™

Layer-Free™ technology involves exposing a 3D printed part to an aerosol of micro-sized alcohol droplets, generated by a rapidly vibrating, perforated membrane called the nebulizer. The aerosol will then be adsorbed by the surface of the 3D printed part and render it smooth and layer-free.

Rough surface



With Layer-Free™



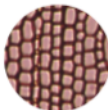
NANO-REINFORCEMENT

Nano-reinforcement technology is applied to produce filaments with excellent mechanical properties and printing quality. It dramatically improves the toughness of the material by increasing its impact resistance.

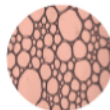
STABILIZED FOAMING™

Stabilized Foaming™ technology is used to produce foamed filaments, whose foam structure can survive the printing process and be inherited by the printed parts. This enables light weight 3D printed parts with unprecedented surface finish.

Wood



Stabilized Foaming™



Hardware

Polymaker offers 3D printing accessories to optimize the user experience with their filaments.

PolyBox™

PolyBox™ is a dry storage box designed to provide the optimum environment for 3D printing filaments. The PolyBox™ is compatible with all 3D printers and can house two 1kg spools or one 3kg spool.



Polysher™

The Polysher™ is a desktop post processing unit designed to remove layer lines from PolySmooth™ and PolyCast™ prints. The Polysher™ uses Polymaker's Layer-Free™ technology to create a fine mist of alcohol which evenly smooths the model.



Monitor your prints from anywhere with



THE SPAGHETTI DETECTIVE

The Spaghetti Detective's automatic failure detection can give added peace of mind, help prevent messy failures, and keep your printer up and running longer.

Advantages



MANAGE
PRINTING
REMOTELY



CATCH PRINT
HAZARDS
EARLY

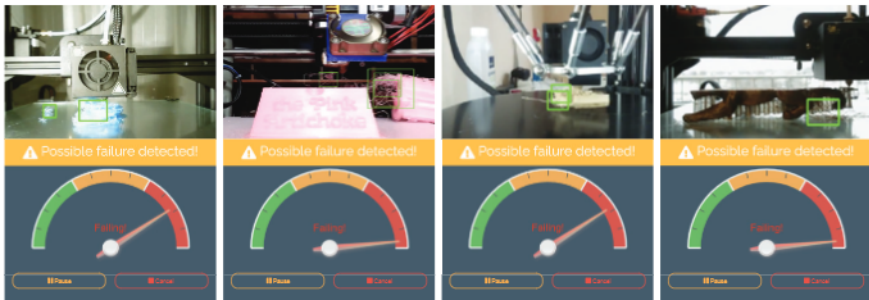


MANAGE
EQUIPMENT
DAMAGE RISK



SAVE
TIME &
MONEY

Overview



Scan to Learn More

thespaghettidetector.com/polymaker.html

Polymaker hereby declares that our company and the above-mentioned company are only for commercial cooperation. There is no affiliation between Polymaker and the above-mentioned company, and Polymaker does not act as an agent of the above-mentioned company.

About Polymaker

Who We Are?

Polymaker is an international team passionate about 3D printing. We produce the very best 3D printing materials by controlling every stage of production. With a diverse portfolio of materials ranging from high performance plastics to unique aesthetic solutions, Polymaker will continue to add cutting edge materials to its ever-growing portfolio.

Mission & Vision

Our mission is to create the best in class when it comes to 3D printing materials. We believe that materials are the enabling factor which will realise 3D printing as a final production tool. Our high performance materials offer solutions that will develop 3D printing into a mainstream manufacturing method.

Locations

Polymaker is a global company head-quartered in Shanghai. With distribution centers located in North America, Europe & Asia, our materials have penetrated every corner of the globe. Our worldwide presence is closely managed through our relationships with our local distributors and resellers. Polymaker is a regular exhibitor at 3D printing exhibitions on 4 continents.

Research & Development

At the core of Polymaker is our research & development laboratory, this is where all our materials are formulated and fine-tuned from the ground up to create the best in class 3D printing materials. Our precision testing equipment combines the latest advancements in technology to ensure we are ahead of the game.

Quality Control

Polymaker implements a rigorous quality control check on all materials. Utilizing our state of the art technology, we measure both the roundness and diameter of our filaments many thousand times a second, monitoring our processes with strict tolerances. We also have a number of processes and technologies that set apart Polymaker materials.

Contact us

For any inquiries or technical support,
please contact: support@polymaker.com

The information provided in this document is intended to serve as basic guidelines on how particular product can be used. Users can adjust the printing conditions based on their needs and actual situations. It is normal for the product to be used outside of the recommended ranges of conditions. Each user is responsible for determining the safety, lawfulness, technical suitability, and disposal/recycling practices of Polymaker materials for the intended application. Polymaker makes no warranty of any kind, unless announced separately, to the fitness for any particular use or application. Polymaker shall not be made liable for any damage, injury or loss induced from the use of Polymaker materials in any particular application

