

Technical Data Sheet

Ultrafuse TPE 60D

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Version No.: 1.2

General information

Components

BASF's Thermoplastic Elastomer based filament for Fused Filament Fabrication.

Product Description

Ultrafuse TPE 60D is made from Ecovio®, a BASF material and completely biodegradable plastic, suitable for 3D printing. Ecovio® is made of renewable raw materials and of Ecoflex®, a BASF biodegradable plastic on a petrochemical basis. Especially suitable for printing flexible parts like miniature tires, drive belts, bracelets and parts that have to be extremely flexible and have to be bent often.

Delivery form and warehousing

Ultrafuse TPE 60D filament should be stored at 15 - 25°C in its originally sealed package in a clean and dry environment. If the recommended storage conditions are observed the products will have a minimum shelf life of 12 months.

Product safety

Recommended: Process materials in a well ventilated room, or use professional extraction systems. For further and more detailed information please consult the corresponding material safety data sheets.

Notice

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

Recommended 3D-Print processing parameters

Nozzle Temperature	210 – 230 °C / 410 – 446 °F
Build Chamber Temperature	-
Bed Temperature	30 - 60 °C / 86 – 140 °F
Bed Material	Tape, glue
Nozzle Diameter	≥ 0.4 mm
Print Speed	40 – 80 mm/s

Drying Recommendations

Drying recommendations to ensure printability	60 °C in a hot air dryer or vacuum oven for 4 to 16 hours
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Please note: To ensure constant material properties the material should always be kept dry.

General Properties

Standard

Density	1250 kg/m ³ / 78.0 lb/ft ³	ISO 1183-1
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Thermal Properties

Standard

Melting Temperature	140 – 155 °C / 284 – 311 °F	ISO 11357-3
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