



# Technical Data Sheet

## InnoFlex 60

Monofilament suitable for all commercially available leading brands 3D FDM/FFF printers

| IDENTIFICATION OF THE MATERIAL |                                                                   |
|--------------------------------|-------------------------------------------------------------------|
| Trade name                     | InnoFlex 60                                                       |
| Chemical name                  | Ecovio                                                            |
| Chemical family                | Compound of biodegradable copolyester Ecoflex and Polylactic Acid |
| Use                            | 3D-Printing                                                       |
| Company                        | Innofil3D BV                                                      |

| MATERIAL PROPERTIES |                                      | Test Method |
|---------------------|--------------------------------------|-------------|
| Melting point       | 140-155 °C                           | DSC         |
| Mass density        | 1.24-1.26 g/cm <sup>3</sup>          | ISO 1183    |
| Tensile strength    | 39/30 MPa                            | ISO 527     |
| Ultimate elongation | 330/430 %                            | ISO 527     |
| Tensile modulus     | 840/280 MPa                          | ISO 527     |
| Shore D hardness    | 59                                   | ISO 868     |
| Food contact        | Natural grade is EU and FDA approved |             |

| MONOFILAMENT DATA             |                | Test Method |
|-------------------------------|----------------|-------------|
| Diameter 1.75                 | 1.75 ± 0.05 mm | Innofil3D   |
| Diameter 2.85                 | 2.85 ± 0.10 mm | Innofil3D   |
| Max. roundness deviation 1.75 | 0.05 mm        | Innofil3D   |
| Max. roundness deviation 2.85 | 0.10 mm        | Innofil3D   |
| Color (RAL)                   | N.A.           | Innofil3D   |
| Print temperature guideline   | 220 ± 10°C     | Innofil3D   |
| Print speed guideline         | 40 - 80 mm/s   | Innofil3D   |