

## Technical Data Sheet

# PolyFlex™ TPU95-HF

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V5.4



PolyFlex™ TPU95-HF, created from Covestro's Addigy® family, is a TPU with high flow properties making it ideal for high-speed printing. Combined with its UV resistance, PolyFlex™ TPU95-HF unlocks new applications for flexible materials in manufacturing.

## PHYSICAL PROPERTIES

Property	Testing Method	Typical Value
Density	ISO1183, GB/T1033	1.16 g/cm <sup>3</sup> at 23 °C
Melt index	185°C, 1.2 kg	9.3 g/10min
Light transmission	N/A	N/A
Flame retardancy	N/A	N/A

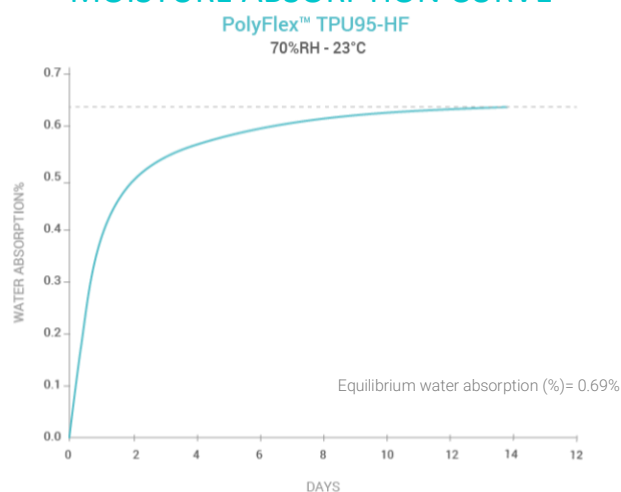
## CHEMICAL RESISTANCE DATA

Property	Typical Value
Effect of weak acids	Fair
Effect of strong acids	Poor
Effect of weak alkalis	Fair
Effect of strong alkalis	Poor
Effect of oils and grease	Good

### Note:

- Good: Material may get minor attack after long periods of storage with chemical at ambient temperature
- Fair: Material can be used for short time contact with chemical at ambient temperature
- Poor: Material becomes unstable on contact with chemical at ambient temperature

## MOISTURE ABSORPTION CURVE



## MECHANICAL PROPERTIES

Property	Testing Method	Typical Value
Stress at 100% strain (X-Y)	ISO 37, GB/T 528	15.5 ± 0.7 MPa
Stress at 200% strain (X-Y)	ISO 37, GB/T 528	19.9 ± 0.8 MPa
Stress at 300% strain (X-Y)	ISO 37, GB/T 528	23.0 ± 0.5 MPa
Stress at 400% strain (X-Y)	ISO 37, GB/T 528	24.2 ± 0.6 MPa
Tensile strength (X-Y)	ISO 37, GB/T 528	26.6 ± 0.6 MPa
Elongation at break (X-Y)	ISO 37, GB/T 528	495.8 ± 16.2 %
Shore hardness	ISO 7619-1, GB/T 531.1	95A

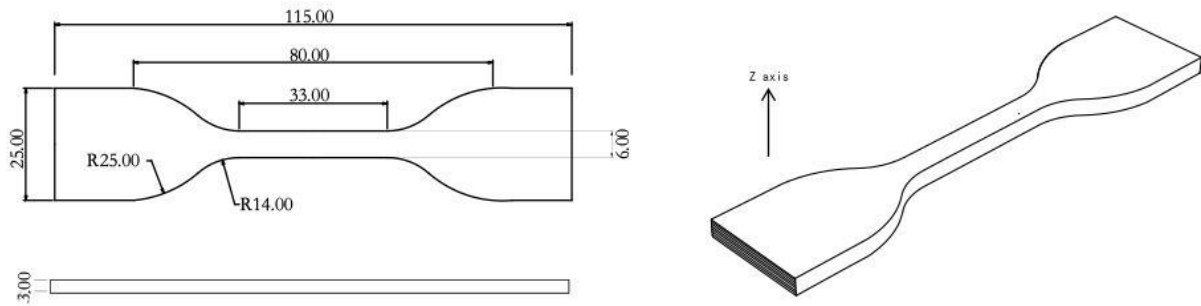
## RECOMMENDED PRINTING CONDITIONS

Parameter	
Nozzle temperature	200 – 230 (°C)
Build surface treatment	PC and Texture PEI (Glue when needed)
Build plate temperature	25 - 50 (°C)
Cooling fan	ON
Printing speed	30 – 100 (mm/s)
Retraction distance	3 - 6 (mm)
Retraction speed	40 - 60 (mm/s)
Closure Chamber	No Needed
Recommended support material	PolySupport™ and PolyDissolve™ S1
Drying setting	70°C for 8h
Annealing setting	-

\* Based on 0.4 mm nozzle. Printing conditions may vary with different nozzle diameters

## TENSILE TESTING SPECIMEN

ISO 37, GB/T 528



## HOW TO MAKE SPECIMENS

Printing temperature	230 °C
Bed temperature	50 °C
Shell	2
Top & bottom layer	3
Infill	100%
Environmental temperature	Ambient temperature
Cooling fan	ON

**DISCLAIMER:**

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End- use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

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