

Technical Data Sheet

InnoFlex 60 by Innofil3D BV

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

IDENTIFICATION OF THE MATERIAL

Trade name	InnoFlex 60
Chemical name	Ecovio; compound of Polyester and Polylactic Acid.
Chemical family	Thermoplastic copolymer
Use	3D-Printing
Origin	Innofil3D BV

GUIDELINE FOR PRINT SETTINGS

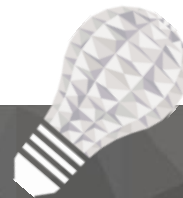
Nozzle temperature	220 ± 10 °C
Bed temperature	30 – 60 °C
Bed modification	Heated bed or tape.
Active cooling fan	Yes (up to 100%)
Layer height	0.1 – 0.2 mm
Shell thickness	0.08 – 2.0 mm
Print speed	40 – 80 mm/s

Settings are based on a 0.4 mm nozzle

MATERIAL PROPERTIES

MATERIAL PROPERTIES		Test Method
Melt temperature (T _m)	140 – 155 °C	ASTM D3418
Glass transition temperature (T _g)	Not determined.	ASTM D3418
Melt Flow Rate (MFR) ¹	Not determined.	ISO 1133
Melt Volume Rate (MVR) ¹	Not determined.	ISO 1133
Density (ρ)	1.25 g/cm ³	ASTM D1505
Odor	Odorless.	/
Solubility	Insoluble in water.	/

¹Test conditions: T=210°C; m=2.16kg



FILAMENT SPECIFICATIONS		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
Net weight on reel	750 g \pm 2%	Innofil3D