

gembird^{3®}

Gembird Europe B.V.

Wittevrouwen 56, 1358CD Almere, The Netherlands.

FLEXIBLE PLA+ (FPLA+) PRINT RECOMMENDATIONS

FPLA+ Technical details			
Printing Temp	190-220 ° C	Tensile strength (X-Y)	8.8-9.3 Mpa
Bed Temp	0-40 ° C	Bending strength	30000 lb/in2
Density (g/cm³)	1.21-1.30 g/cm ³	Elongation at break (X-Y)	500-600 (%)
Retraction distance	1 cm	Melting Point	137 ℃
Retraction speed	20 mm/s	Melt Volume Rate	6.38 (170 °C , 2.16 kg)
Glass transition temp.	54 °C	Printing speed	40-80mm/S

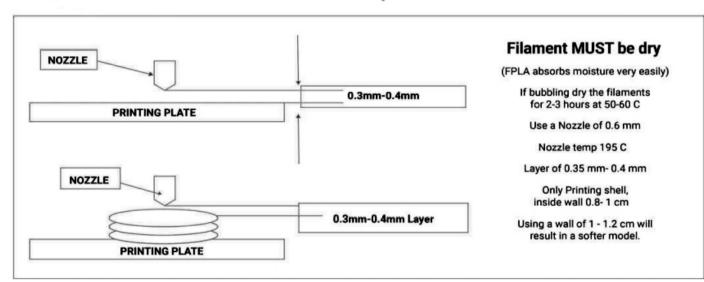
Moisture absorption resistance of FPLA⁺ Filament

• Since Flexible PLA⁺ (FPLA⁺) comes from the PLA family and since it is soft, it will easily absorb moisture.

• We strongly recommend that the filament be kept in the vacuum bag immediately after its use and not be kept outside.

• If the humidity in the filament persists, it is recommended to dry the filament at 50 °C for 2 to 3 hours and then use it for best results.

Use following parameters to prevent Stringing & Adhesion



IssueSolutionThe Filament is adhering a lot. This stuff adheres too well to
textured PEI treated beds. The bottom layer is difficult to
remove and stretches leaving a
white colored texture on the print.Recommends using PVB globe in the plate or lower the print temperature to
180 to 190 deg C. U can also use a small layer of baby powder on the bed as
well.The FPLA is stringing and oozing.We recommend for you to use a 0.6 mm nozzle and print at a
nozzle temperature of 190°C with a bed temperature of 40°C.

Nozzle 0.5mm/0.6mm