



## Material Specification Print Sheet

**Flex EcoPLA**

Flexible PLA

Maker Geeks



**Not Yet Printed**

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### **Pre and Post Processing:**

A heated build plate is sufficient to get Ecoflex to adhere to your build platform.

Heat polishing can help clean up strings if any are present. A clipper will be required to remove skirt material, as it will not pull off.

### **HAZARDS (rating 1-10)**

Ecoflex is very safe, although not approved for food safety.



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<p style="text-align: center;"><b>Settings to print with</b></p> <p>Temp Range: 230-250°C (ideal 235)          Recommended flow multiplier: 1.000          Recommended layer size: .1-.3          Build Plate Temp: 70°C          Recommended Fan: 100%</p>	<p style="text-align: center;"><b>Prime/Unprime:</b></p> <table border="1" style="width: 100%;"> <tr> <td>Steps: 100</td> <td>Steps: 100</td> </tr> <tr> <td>Rate: 10,000</td> <td>Rate: 10,000</td> </tr> <tr> <td>Time (ms): 25</td> <td>Time (ms): 20</td> </tr> <tr> <td>Primes after Tool Change: 1</td> <td>Primes after Tool Change: 1</td> </tr> </table>	Steps: 100	Steps: 100	Rate: 10,000	Rate: 10,000	Time (ms): 25	Time (ms): 20	Primes after Tool Change: 1	Primes after Tool Change: 1
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<p style="text-align: center;"><b>How well it handles prints</b></p> <p>Overhangs: ~35°          Retraction: 4          Circles: 4          Layer change: 4          Fine detail: 3          Curling: 3</p>	<p style="text-align: center;"><b>Properties of Material</b></p> <p>Modulus of Elasticity:          Yield Strength:          Fracture Point:          Modulus of Elasticity in Bending:  <i>All parts done with a ___% infill</i></p>								

Chemical	Water	Vinegar	HCl	Acetone	HF	Sulfuric Acid
Resistance (High/Limited/None)						
Chemical	Aqua Regia	Bleach	Gasoline	Methyl Alcohol	Ethyl Alcohol	NaOH
Resistance (High/Limited/None)						

Images (Left to right, top to bottom): Single walled vase, Artifact/Feature size test, Retraction/Feature size test, arch, top of overhang test, bottom of overhang test.

Overhang: Minimum angle to the horizontal at which layers are relatively unperturbed.

Print handling parameters: 5-optimal, 4-very good, 3-fair, 2-passable, 1-very poor

Chemical Resistance: High-no observable affect after a long period of time, Limited-Slight affects over time (swelling, discoloration, slight softening, etc), None-very severely affected by chemical.



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### **NOTES:**

-Ecoflex does not handle corners very well, so if you are printing with sharp angles or corners, slow down the print for those parts a lot. Otherwise this material is fairly forgiving to work with.