

FLEXIBLE PBAT BASED FILAMENT

Flexible PLA Filament

1.75 mm · 1 kg spool · ± 0.03 mm tolerance

Flexible, rubber like filament based on PBAT that prints at PLA temperatures, for soft, bendable parts.

✓ Elongation 400–600 %

✓ Prints at PLA temperatures

✓ No break on impact

✓ Print slowly, 10–30 mm/s

Recommended Print Settings

Nozzle temperature 180–220 °C

Bed temperature 25–60 °C

Print speed 10–30 mm/s

Support material PVA (as support interface)

i Print slowly with a direct drive extruder and reduced retraction for best results.

Filament Specifications

Material PBAT based flexible filament

Diameter 1.75 mm

Diameter tolerance ± 0.03 mm

Net filament weight 1 kg

Spool & Packaging

Empty spool weight 150 g

Spool with filament 1.15 kg

Spool outer diameter 200 mm

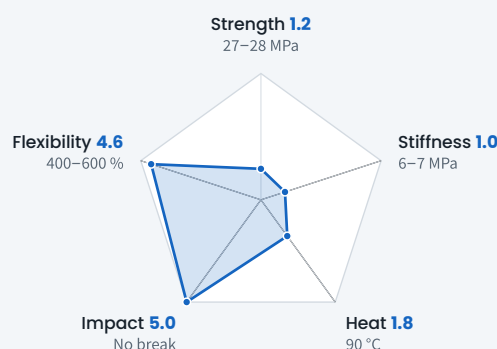
Hub diameter 52 mm

Spool width 65 mm

Shipping weight 1.3 kg

Box dimensions 210 × 220 × 75 mm

Property Profile



Scores from 1 to 5 relative to the OzFDM filament range, based on the typical values in this sheet (stiffness and impact on a log scale).

Storage & Handling

Drying

60 °C for 6+ hours in a filament dryer or food dehydrator.

Storage

Airtight bag or container with desiccant in a cool, dark and dry area to prevent moisture absorption. For optimal long term storage we recommend drying the filament prior to sealing the filament spool in a vacuum bag with desiccant.

Mechanical Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Tensile strength	ISO 527	27–28 MPa
Elongation at break	ISO 527	400–600 %
Tensile modulus	ISO 527	6–7 MPa
Flexural strength	ISO 178	7–9 MPa
Impact strength	ISO 180	No break

Physical Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Density	ISO 1183	1.25–1.26 g/cm ³
Melt flow rate (190 °C, 2.16 kg)	ISO 1133	6–10 g/10min
Moisture absorption (23 °C, 24 h)	ISO 62	<0.5 %

Thermal Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Heat deflection temperature (0.455 MPa)	ISO 75	90 °C
Continuous use temperature	IEC 60216	85 °C

Available Colours 14

							
Red	Green	Blue	Black	White	Grey	Yellow	Orange
							
Pink	Purple	Brown	Gold	Silver	Natural		

Swatches are indicative only. Colours vary between screens and with print settings.

NOTES

Values shown are typical results measured on test specimens and are provided for guidance only. They are not guaranteed specifications and should not be used as design limits. Printed part properties vary with printer, settings, print orientation and part geometry. Test your parts for suitability before use in critical applications.