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FLEXIBLE PLA+ (FPLA+) PRINT RECOMMENDATIONS

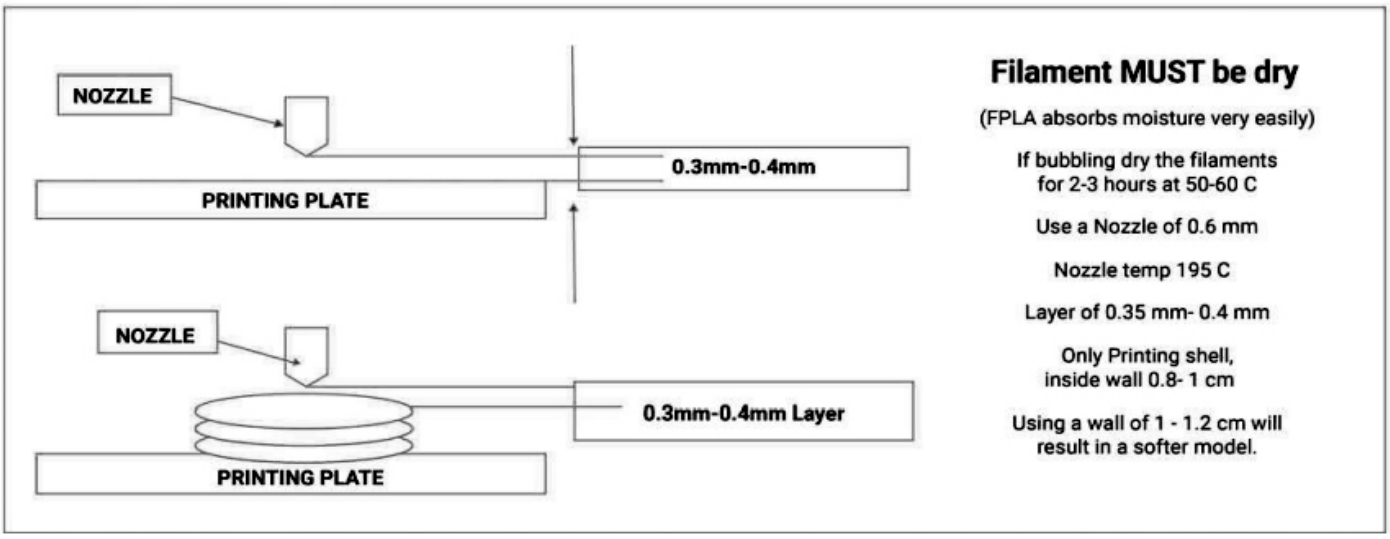
FPLA+ Technical details			
Printing Temp	190-220 °C	Tensile strength (X-Y)	8.8-9.3 Mpa
Bed Temp	0-40 °C	Bending strength	30000 lb/in2
Density (g/cm³)	1.21-1.30 g/cm³	Elongation at break (X-Y)	500-600（%）
Retraction distance	1 cm	Melting Point	137 ºC
Retraction speed	20 mm/s	Melt Volume Rate	6.38 (170 ºC, 2.16 kg)
Glass transition temp.	54 ºC	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 ºC for 2 to 3 hours and then use it for best results.

Use following parameters to prevent Stringing & Adhesion

Nozzle 0.5mm/0.6mm



Issue	Solution
The 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℃.