

## FLEXIBLE PLA+ (FPLA+) PRINT RECOMMENDATIONS

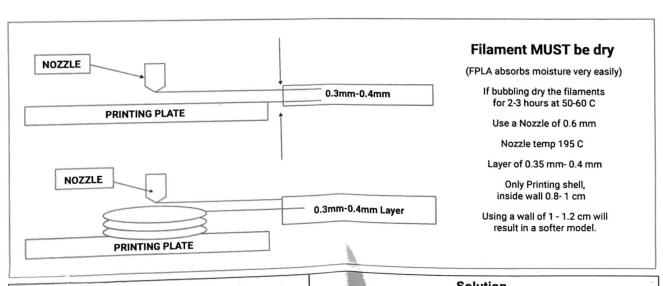
FPLA+ Technical details			
Printing Temp	190-220 °C	Tensile strength (X-Y)	8.8-9.3 Mpa
Bed Temp	0-40°C	Bending strength	30000lb/in2
Density (g/cm³)	1.21-1.30g/cm3	Elongation at break (X-Y)	500-600 (%)
Retraction distance	1mm	Melting Point	137°C
Retraction speed	20mm/s	Melt Volume Rate	6.38 (170°C, 2.16 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.
- To help the Customer maintain in dry stage, Ataraxia Art has provided each filament reel with its latest
   V2 Vacuum bag which can easily store two filament reels. 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 deg C for 2 to 3 hours and then use it for best results.

## Use following parameters to prevent Stringing & Adhesion





Issue	Solution	
layer is difficult to remove and stretches leaving a	Ataraxia Art 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.	
white colored texture on the print.  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.	