



PRINT SETTINGS TPU 98A

Nozzle Temp	220°C-230°C
Bed Temp	60°C-80°C
Heated Enclosure	Not required
Bed Adhesion	Hairspray, glue stick, or increased bed temperature
Drying Settings	60°C for 6 hours

Preferred Print Parameters

0.4mm Nozzle – 0.2mm Layer Height
225°C Extruder 60°C Bed
35mm/s

Printing Considerations

- Temperature variations: Larger nozzle diameters, higher volumetric flow, and faster print speeds will require higher nozzle temperatures.
- TPU is flexible so slower print speed and limited retraction are keys to success.
- TPU is also susceptible to moisture absorption, drying is recommended.
- For best success with TPU use blue painters tape. If using glass or PEI build surface, use hairspray or glue to prevent material from fusing to bed.