



# Ultrafuse® TPU 64D

Flexible Filament based on BASF Elastollan®

Ultrafuse® TPU 64D combines the best of two worlds by being a strong yet flexible filament for Fused Filament Fabrication, suitable for all FFF printers. Building on BASF's decades of experience in flexible materials, this material is based on the established thermoplastic polyurethane Elastollan®, standing for maximum reliability, consistent product quality and cost efficiency. Ultrafuse® TPU 64D is easily compatible with water soluble support. Thanks to its property profile, Ultrafuse® TPU 64D presents an excellent alternative to rubber and ABS for the manufacturing of tools, jigs and fixtures.

## Benefits at a Glance

- High resistance to oils, greases, oxygen and ozone
- High wear and abrasion resistance
- High impact resistance
- Compatible with water soluble support
- Printable on direct drive and bowden style printers

## Example Applications

- Functional flexible parts
- Wear and tear application
- Tooling, jigs and fixtures

## Material Properties

Shore D Hardness	58
Abrasion Resistance	43 mm <sup>3</sup>
Compression set at 23°C, 72 h:	25 %
Stress at Break:	37 MPa (XY), 19 MPa (ZX)
Elongation at Break:	399 % (XY), 115 % (ZX)
Tear Strength:	66 kN/m (XY), 37 kN/m (XZ), 79 kN/m (ZX)

## Printing Guidelines

Nozzle Temperature	230–255 °C
Bed Temperature	40–60 °C
Nozzle Diameter	≥ 0.4 mm
Bed Modification	Glass
Print Speed	30–60 mm/sec

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