

## TPE-SEBS 1300 85A Filament

### Recommended Print Settings

TPE SEBS 85A is a soft material great for prototyping where rubber-like or elastomeric properties and durability are required. TPE SEBS properties are similar to rubber and other thermoplastic elastomers, including being soft to the touch while maintaining a strong and flexible durability.



#### PRINT TEMPERATURE

The optimal printing range is 240° – 250°C



#### BED TEMPERATURE

A bed temperature of 70°C will provide the best adhesion during printing.



#### PRINTING SPEED

- Base printing speed of 25 mm/s
- Infill speed of 25-30 mm/s
- Wall speed of 25-30 mm/s
- Initial Layer speed of 10 mm/s
- Initial Layer Speed: 10 mm/s



#### COOLING

- For best results do not use a cooling fan while printing with TPE-SEBS.



#### BED ADHESION

- Use a brim when printing on clean glass. When using a PEI sheet, use a skirt on a clean plate. There is no need for any additional adhesion methods.



#### OTHER TIPS

- For best results, print TPE-SEBS 85A on a direct-drive printer. If attempting to print on a Bowden-style printer, using a PTFE or fluoropolymer-lined Bowden tube will increase success.
- If the material starts to short feed or bind up in the extruder, turn down the feeder wheel tension. It is recommended to start with as little tension as possible.

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### APPLICATIONS

- Automotive, aerospace, general manufacturing
- Complex geometries
- Parts that need to dampen vibrations
- Products that need to retain flexible properties under weather or heat exposure

Examples include:

- Seals
- Gaskets
- No skid / no mark feet
- No slip mats for auto interiors
- Soft touch grip for power tools

### ADVANTAGES

- Easier to print than TPU filaments
  - Shore 85A elastomer
  - High flexibility, bend and stretch
  - (can stretch over 500%)
  - Low moisture absorption
  - Less visible layer lines
  - Does not require drying to process
- Works on all open platform direct-drive 3D printers (including desktop with PTFE Bowden tubes)

### DIAMETERS

- 2.85mm



Questions? Visit [JabilAdditive@jabil.com](mailto:JabilAdditive@jabil.com), [jabil.com/filaments](http://jabil.com/filaments)

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TPE-SEBS 1300 85Ae

