

## TPE-SEBS 1300 95A Filament

### Recommended Print Settings

TPE-SEBS 95A is a soft material great for prototyping where rubber-like or elastomeric properties and durability are required. TPE-SEBS 1300 95A is slightly firmer than TPE-SEBS 1300 85A for application requirements that call for flexibility but also need more rigidity to achieve the optimal finished part performance.



#### PRINT TEMPERATURE

The optimal printing range is 230° – 270°C



#### BED TEMPERATURE

A bed temperature of 50°C to 70°C will provide the best adhesion during printing.



#### PRINTING SPEED

- Base printing speed of 25 mm/s
- Infill speed of 15-25 mm/s
- Wall speed of 15-25 mm/s
- Initial layer speed of 15-25 mm/s



#### COOLING

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



#### BED ADHESION

Use a brim while printing on clean glass or a PEI sheet. No glue or extra adhesion method is necessary.



#### OTHER TIPS

- 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.
- Using a PTFE or fluoropolymer-lined tubing will help with printing. Using this type of tube will allow the print temperature to be lower.

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### APPLICATIONS

- Automotive, aerospace, general manufacturing
- Parts that require toughness and resilience as well as some flexibility and fatigue resistance along with elastomeric properties that can bend, flex and stretch
- Complex geometries

Examples include:

- Automotive interior trim components
- Packaging closures
- Covers and housings
- Grips
- No slip feet for electronic and mechanical components
- Gap seals

### ADVANTAGES

- High print success rates
- Very low warpage and curl
- No need for heated print bed or drying requirements
- Shore 95A elastomer
- High flexibility, bend and stretch
- Non-hygroscopic, does not absorb moisture
- Durable with repetitive motions
- Less visible layer lines, less warp

### DIAMETERS

- 1.75mm and 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 95A

