

NinjaFlex[®] Printing Guidelines

Extruder Temperature: 225°C – 235°C

Platform Temperature: Room temperature – 40°C

Glue and/ or blue painters tape is suggested if not using a heated bed.

Print Speed:

Top and bottom layers: 10-20 mm/ sec (600-1200 mm/ min)

Infill speeds: 15-35 mm/ sec (900-2100 mm/ min)

Layer 2+ use cooling fan if available.

NinjaFlex[®] Tips and Tricks

Safety:

We recommend printing in a well-ventilated area for use with all of our materials. TPE's are capable of releasing small amounts of fumes at high temperatures.

Finishing parts:

Best results are achieved using a dremel or a hot knife for smoothing rough surfaces. It is also tolerant to cutting and light drilling as required for an application.

Connecting printed parts:

Welding is the best option. Plastic welders, soldering irons, wood burners or heat guns are ideal. NinjaFlex will also bond to other plastics using the same method.

Injection molding:

NinjaFlex is available in pellet form and is useable for injection molding in addition to pellet extrusion.

Bridging:

NinjaFlex is not ideal for bridging, though it can handle some small areas in unsupported applications.

Water resistance:

Occasional contact with water will have no adverse effect on NinjaFlex, but long-term exposure will degrade the material to the point in which its elastic properties will be reduced.

UV Resistance:

NinjaFlex is not recommended for long-term continuous outdoor use as it has no UV stabilizer. However, it does boast higher UV performance over ABS & PLA . Short term usage is suitable, with an estimated 4-6 months before seeing any degradation.