



MPN	Description
55506	3D Filament, Flexible, PRIMALLOY™ 1.75mm 500g Reel – Black



**Features:**

- Pliable rubber material with outstanding heat, oil and abrasion resistance as well as superior mechanical strength.
- Developed using proprietary materials from Mitsubishi Chemical
- High performance polyester based thermoplastic elastomer (TPE).
- Custom spool designed for strength, uniform performance and trouble-free feeding
- Filaments packaged in vacuum-sealed bag, with desiccant to prevent introduction of dust and moisture.
- 1-Year Limited Warranty

**Usage:**

- For best performance, use a Polyimide Tape (Kapton™ Tape) with a heated build platform (40° - 50° C)
- To prevent layer drooping, apply forced air cooling on object as it builds.
- To prevent feed jams, utilize slow print speeds ( $\leq 30$  mm/s) and turn off retraction. Avoid excessive pressure in the pinch feeder.
- Not recommended for printers with significant distance between the pinch feeder and hot end (eg. >15mm)

**Storage and Handling:**

- Keep material in sealed bag until ready for use.
- Store unused material in cool, dark place.

## Technical Specifications

Diameter Tolerance	1.75 ± 0.05 mm
Process Temperature	230 to 240° C
Net Weight	2.20 lbs (1.00 kg)
Gross Weight	3.00 lbs (1.36 kg)
Spool Diameter	20.00 cm (7.87 In)
Spool Depth	7.20 cm (2.83 In)
Hub Diameter	10.20 cm (4.02 In)
Hub Hole Diameter	5.10 cm (2.01 In)
Heated platform required?	Recommended
Recommended Storage Temperature	-20 to 60° C