

Technical Data Sheet

Ice9™ Flex

Thermally conductive, electrically non-insulating plastic
Product code: TC-TPE1-145-000

Product type: filament or pellets
Properties based on 3D printed samples



GENERAL PROPERTIES	VALUE			
Base Material	Thermoplastic elastomer (TPE)			
Color	Dark gray			
Density	1550 kg/m ³			
THERMAL PROPERTIES	METRIC	ENGLISH		ASTM
Thermal conductivity, in-plane	8 W/m-K	54	BTU·in/hr·ft ² ·°F	E1461
Thermal conductivity, through-plane	2.5 W/m-K	17	BTU·in/hr·ft ² ·°F	E1461
Coefficient of thermal expansion	80 ppm/°C	44	ppm/°F	E831
Heat deflection temperature, 0.45 MPa	65 °C	149	°F	D648
Max. continuous temperature	110 °C	230	°F	*
MECHANICAL PROPERTIES	METRIC	ENGLISH		ASTM
Shore Hardness	100 A			D2240
Flexural modulus	95 MPa	15	ksi	D638
Flexural strength, Break	50 MPa	8	ksi	D638
Elongation at break	35 %	35	%	D638
Impact strength, Izod notched	No break	No break		D256
ELECTRICAL PROPERTIES	METRIC	ENGLISH		ASTM
Volume resistivity	<10 ⁵ Ω-cm			D257
FDM PRINTING GUIDELINES	METRIC	ENGLISH		
Extruder temperature	225-250 °C	437-482	°F	
Bed temperature	40-90 °C	104-194	°F	

* Max. continuous temperature is the highest temperature recommended for operation of more than 1 hour and is based internal testing and not any recognized standard.

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Recommended FDM Print Settings

Ice9™ Flex

Thermally conductive, electrically non-insulating plastic
Product code: TCP 01-1140-2210

Product type: FDM filament



TCPOLY

GENERAL PROPERTIES

Base material	Thermoplastic elastomer (TPE)
Color	Dark gray
Filament diameter	1.75 or 2.85 +/- 0.05 mm

TEMPERATURE SETTINGS

	VALUE	UNITS
Extruder temperature	225-250	°C
Bed temperature	40-90	°C
Cooling fan	Off	

SLICING SETTINGS

	VALUE	UNITS
Print speed	< 30	mm/s
Layer height	0.2-0.6	mm
Retraction distance	4-8	mm
Infill for best thermal performance	100	%

ADDITIONAL GUIDELINES

Nozzle diameter	0.5-1.0 mm
Extruder type (1.75 mm)	Direct only
Extruder type (2.85 mm)	Direct or Bowden
Print bed preparation	Painter's tape
Storage instructions	Sealed bag
Drying instructions	2 hr @ 70°C

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