

snapmaker | TPU 95A HF

Technical Data Sheet



www.snapmaker.com

1	Filament Introduction	3
2	Specifications	3
3	Recommended Printing Settings	3
4	Properties	7
5	Specimen Test	8
6	Disclaimer	9

1 Filament Introduction

Snapmaker TPU 95A HF is a flexible filament specifically developed for high-speed printing, delivering faster print speeds compared to standard TPU 95A. It features high flowability, excellent interlayer adhesion, outstanding impact resistance, and good flexibility.

2 Specifications

Subjects	Data
Diameter	1.75 ± 0.03 mm
Net Filament Weight	1 kg
Length	346 m/kg
Spool Material	Cardboard Spool
Spool Size	Diameter: 200 mm; Height: 66 mm

3 Recommended Printing Settings

Subjects	Data
Drying Settings Before Printing	65°C , 6 h
Printing and Storage Humidity	< 20% RH (Sealed, with Desiccant)
Nozzle Size	0.4/0.6/0.8 mm
Nozzle Temperature	200–250°C
Bed Type	Smooth PEI Plate / Textured PEI Plate
Bed Surface Preparation	Glue Stick / Liquid Glue
Bed Temperature	25–50°C
Cooling Fan	ON
Printing Speed	Up to 200 mm/s
Retraction Length	1–2 mm
Retraction Speed	30 mm/s

Printing Tips

1. Drying & Storage

- **Pre-Drying:** TPU is extremely hygroscopic and must be dried before use. Dry the filament at 65°C for 6 hours.
- **Storage:** When not in use, keep the filament away from direct sunlight in a sealed container with desiccant.
- **Recommended Solution:** We highly recommend using SnapDryer, which serves as an all-in-one solution to perfectly dry and store your filament. Watch our [video guide](#) to get started with SnapDryer.

2. Printing

- **Nozzle Selection:** Printing with a 0.2 mm nozzle is not recommended.
- **Loading & Unloading:** TPU is a flexible filament that demands precise control during loading and unloading. Improper handling may lead to issues such as loading problems or nozzle clogs. To minimize the risk of print failures, the filament must be loaded and unloaded manually. Do not use the automatic filament feeder. We strongly recommend watching our [video guide](#) before your first print.
- **Drying While Printing:** For optimal print quality, we recommend using SnapDryer while printing.
- **Printing Speed:** Snapmaker TPU 95A HF is optimized for high-speed printing, supporting print speeds of up to 200 mm/s under optimized conditions. For optimal print quality and consistency across most models, we recommend a print speed of 50–110 mm/s. This range delivers faster printing than standard TPU 95A while maintaining excellent print quality and a high print success rate.

- **Removal:** TPU tends to over-stick to the build plate, which may damage the print during removal. We recommend spraying alcohol at the interface between the model and the bed during removal.

- **Optimizing First-Layer Adhesion:** If first-layer adhesion fails, please check the bed levelling and clean the build plate. If the issue persists, apply a glue stick or liquid glue to improve adhesion.

- **Fixing Bubbles & Stringing:** If you notice bubbles or heavy stringing, dry your filament thoroughly first. If stringing continues, try reducing the distance between models, increasing the retraction length or speed, and decreasing the travel speed.

- **Fixing Model Collapse:** If the model collapses during printing, first ensure the cooling fan speed is set to 100%. Additionally, you can rotate the model so the affected area faces the cooling fan and position it closer to the fan. This enhances localized cooling and improves print quality.

4 Properties

Physical Properties

Subjects	Testing Methods	Data
Density	ISO 1183	1.216 g/cm ³ at 23°C
Melt Index	210°C , 2.16 kg	28.5 g/10 min
Melting Temperature	DSC, 10 °C/min	177.29°C
Glass Transition Temperature	DSC, 10 °C/min	-18.56°C
Decomposition Temperature	TGA, 20 °C/min	315.11°C
Crystallization Temperature	DSC, 10 °C/min	90.52°C
Vicar Softening Temperature	ISO 306, GB/T 1633	N/A
Heat Deflection Temperature	ISO 75, 1.8 MPa	N/A
Heat Deflection Temperature	ISO 75, 0.45 MPa	N/A
Saturated Water Absorption Rate	25°C, 55% RH	0.69%

Mechanical Properties

Subjects	Testing Methods	Data
Shore Hardness	ISO 7619-1, GB/T 531.1	95A
Young's Modulus (X-Y)	ISO 527, GB/T 1040	N/A
Young's Modulus (Z)	ISO 527, GB/T 1040	N/A
Tensile Strength (X-Y)	ISO 527, GB/T 1040	N/A
Tensile Strength (Z)	ISO 527, GB/T 1040	18.64 ± 0.64 MPa
Breaking Elongation Rate (X-Y)	ISO 527, GB/T 1040	N/A
Breaking Elongation Rate (Z)	ISO 527, GB/T 1040	459.25 ± 18.09%
Bending Modulus (X-Y)	ISO 178, GB/T 9341	64.19 ± 3.17 MPa
Bending Modulus (Z)	ISO 178, GB/T 9341	N/A
Bending Strength (X-Y)	ISO 178, GB/T 9341	3.20 ± 0.07 MPa
Bending Strength (Z)	ISO 178, GB/T 9341	N/A
Impact Strength (X-Y)	ISO 179, GB/T 1043	N/A
Impact Strength (Z)	ISO 179, GB/T 1043	N/A

Other Physical and Chemical Properties

Subjects	Data
Odor	Odorless
Composition	Thermoplastic Polyurethane
Skin Hazards	Non-Hazardous
Chemical Stability	Stable under normal storage and handling conditions
Solubility	Insoluble in Water
Resistance to Acid	Non-Resistant
Resistance to Alkali	Non-Resistant
Resistance to Organic Solvent	Not resistant to some organic solvents
Resistance to Oil and Grease	Fair
Flammability	Flammable
Combustion Products	Water, Carbon Oxides, Nitrogen Oxides
Odor of Combustion Products	Pungent Odor

5 Specimen Test

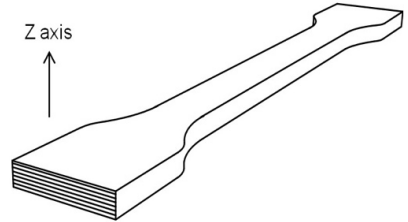
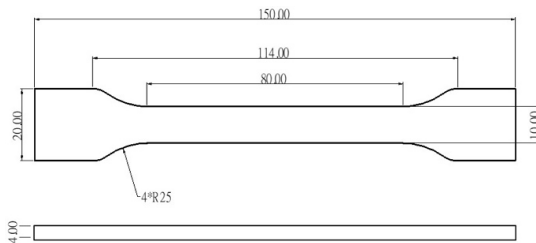
Specimen Printing Conditions

Subjects	Data
Nozzle Temperature	240°C
Bed Temperature	35°C
Printing Speed	50 mm/s
Infill Density	100%



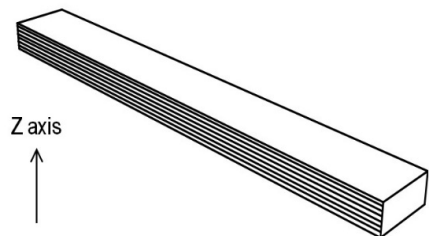
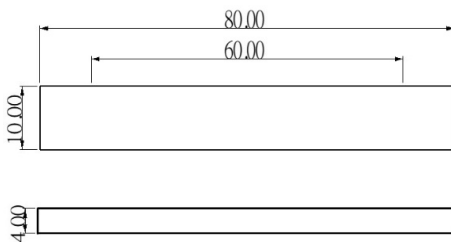
Based on 0.4 mm nozzle. Printing conditions may vary with different nozzle diameters.

Tensile Testing Specimen

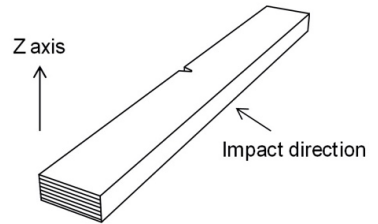
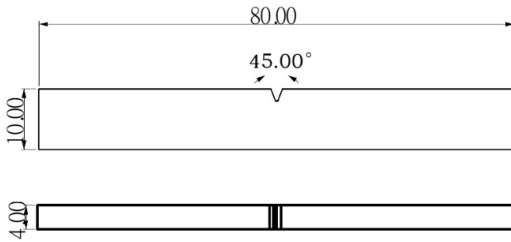


ISO 527, GB/T 1040

Flexural Testing Specimen



Impact Testing Specimen



ISO 179, GB/T 1043

6 Disclaimer

The performance and printing parameters of the aforementioned filaments are obtained by Snapmaker through testing filament samples with sample 3D printers. All data provided is for reference and comparison purposes only, and does not constitute design specifications or any warranty of quality. Actual 3D printing quality and final part performance are subject to various factors including, but not limited to, printer equipment, model design, environmental conditions, and printing parameters. Users shall independently evaluate the compliance and safety of printed models and finished parts, including legal compliance, application safety, and structural reliability. Snapmaker shall not be held liable for any direct or indirect losses arising from the use of the aforementioned filaments, including equipment damage, print failure, personal injury, and property damage.

$$\int_0^{\text{Wonderful}} \text{make}(x)dx = \text{snapmaker}$$