TECHNICAL DATA SHEET

Rev 2.0 · Issue date 10-27-2026 · Supersedes Rev 1.0 (03-11-2020)

COEXFlex™ TPE 60D 3D Printer Filament

Thermoplastic copolyester elastomer (TPC-ET) · Product code CX19 · 1.75 mm and 2.85 mm

Base resin: Thermoplastic copolyester elastomer (TPC-ET)

Typical values for the base resin. Printed parts vary with print settings, orientation and moisture content.

Physical properties

Property	Standard	Unit	Typical value
Density	ISO 1183	g/cm³	1.25
Melt volume-flow rate (MVR), 190 °C / 2.16 kg	ISO 1133	cm³/10 min	5.20
Molding shrinkage, across flow	ISO 294-4	%	0.70
Molding shrinkage, flow	ISO 294-4	%	0.30
Shore hardness, Shore D	ISO 7619		61
Shore hardness, Shore D, 15 sec	ISO 7619		55
Burning rate, 1.00 mm	ISO 3795	mm/min (in/min)	< 80 (< 3.1)
FMVSS flammability	FMVSS 302		B

Mechanical properties

Property	Standard	Unit	Typical value
Tensile modulus	ISO 527-2	MPa (psi)	190 (27,600)
Tensile stress at break	ISO 527-2	MPa (psi)	32.0 (4,640)
Tensile stress at 10% strain	ISO 527-2	MPa (psi)	11.0 (1,600)
Tensile strain at break	ISO 527-2	%	290
Flexural modulus	ISO 178	MPa (psi)	170 (24,700)
Tear strength, across flow	ISO 34-1	kN/m (lbf/in)	180 (1,000)
Tear strength, flow	ISO 34-1	kN/m (lbf/in)	170 (970)

Thermal properties

Property	Standard	Unit	Typical value
Brittleness temperature	ISO 974	°C (°F)	−65.0 (−85.0)
Melting temperature, 10 °C/min	ISO 11357-3	°C (°F)	165 (329)

Filament specifications

Diameter	Nominal	Minimum	Maximum	Tolerance
1.75 mm	1.75 mm (0.0689 in)	1.72 mm (0.0677 in)	1.78 mm (0.0701 in)	±0.03 mm (±0.0012 i
2.85 mm	2.85 mm (0.1122 in)	2.79 mm (0.1098 in)	2.91 mm (0.1146 in)	±0.06 mm (±0.0024 i

Recommended print settings

Nozzle temperature	220–240°C
Bed temperature	25–85°C
Enclosure	No enclosure is needed
Part cooling fan	0–40%
Extruder	Preferably use a direct drive extruder
Drying	Dry an opened spool at 50°C for 4–6 hours
Storage	Keep filament dry: store it sealed, and dry it again only after the spool has been exposed to air
Bed adhesion	Use a glue stick or hairspray as a release agent, or WELD3D. COEXFlex bonds very strongly to glass and smooth PEI, so a release agent protects both the print and the plate
Stringing	Print multiple parts one at a time (sequentially) to minimize stringing. Use maximum travel speed to minimize stringing

Advantages

Resilient, Flexible, Heat Resistant, Chemical Resistant, Strong, Durable Combines the flexibility of rubber with the strength and processability of thermoplastics

www.coex3d.com · COEX LLC, 1228 Elizabeth St, Green Bay, WI 54302, USA · (920) 757-1055
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