

TECHNICAL DATE SHEET

BASE MATERIAL: Polylactic acid - PRODUCED FROM RENEWABLE MATERIALS (> 80%)

PROPERTIES

PROPERTIES	VALUE	METOD AND CONDICTION
PHYSICAL & MECHANICAL	Density	1,30 g/cm ³ ISO 1183
	MFI (190 °C - 2,16 Kg)	30 g/10 min ISO 1133
	Elongation at break	>6% ISO 527
	Tensile strength at break	36 Mpa ISO 527
	Tensile Modulus - Untreated	3200 Mpa ISO 527
	- Annealed	3500 Mpa ISO 527
	Flexure Modulus - Untreated	3500 Mpa ISO 178
	- Annealed	3800 Mpa ISO 178
	IZOD (notched):	4 kJ/m ² (23°C) ISO 18071A
	3 kJ/m ² (-30°C) ISO 18071A	
THERMAL	Heat Deflection Temperature	
	- Untreated	52 °C ISO 75
	- Annealed	90 °C ISO 75

SUGGESTED PRINTER SETTING

PARAMETERS	VALUE	UNIT
Extruder Temperature	200 - 220	°C
Print Speed	40 - 120	mm/s
Bed Material	0 - 50	°C
Annealing Temperature	100 °C for 2-4 hr	any support material (suggested in s

PRODUCT DETAILS & CERTIFICATION

Diameter	1,75 mm 2,85 mm	Tolerance ± 0,05mm Tolerance ± 0,10mm
REACH compliant ROHS certified FDA compliant		compliant compliant not compliant

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