

TECHNICAL DATE SHEET

BASE MATERIAL: Polylactic acid >80%

PROPERTIES

PROPERTIES	VALUE	METOD AND CONDICTION	
PHYSICAL & MECHANICAL	Density	1,24 g/cm ³	ISO 1183
	CHARPY (test 80x10x4 mm)	14 kJ/m ²	ISO 179-1eU
	Elongation at break: - Untreated	2,90%	ISO 527
	- Annealed	ND	ISO 527
	Tensile strength at break:		
	- Untreated	30 Mpa	ISO 527
	- Annealed	ND	ISO 527
Flexure Modulus:	- Untreated	2750 Mpa	ISO 527
	- Annealed	ND	ISO 527
THERMAL	Heat Deflection Temperature		
	- Untreated	58 °C	ISO 75
	- Annealed	116 °C	ISO 75

SUGGESTED PRINTER SETTING

PARAMETERS	VALUE	UNIT
Extruder Temperature	210 - 230	°C
Print Speed	40 - 120	mm/s
Bed Material	0 - 50	°C
Annealing Temperature	100 ° C for 30-60 min	suggested in sand and/or with support

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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