TECHNICAL DATA SHEET FOR PRODUCT:

PLA FILAMENT

Use	is a material for the FDM (FFF) 3D printing additive technology		
Material	polylactid acid by NatureWork, biodegradabilic material, non petroleum product		
Diameters	1,75 or 2,90 mm		
Tolerance	± 0,05 mm		
Weight	0,5 kg netto ± 5% / 0,7 kg brutto ± 5%		
	1,0 kg netto ± 5% / 1,3 kg brutto ± 5%		
	2,0 kg netto ± 5% / 2,4 kg brutto ± 5%		
Packing	spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil		
Colours	views on web https://www.filament-pm.com/pla		
Solvents	1,2 Dichloroethane, Toluene, Tetrahydrofuran,		
Printing Properties:			
Temperature HE	200 – 220 °C		
Temperature HB	20-60 °C		
Surface bed	kapton, ultem, PET foil, commons for FDM printing		
Cooling print object	YES		
Nozzle	All diameters / for glitter using nozzle min 0,5 mm and more		
Printer space	Open / Close		
Material Properties:			
Thermal	vicat softening temperature	ISO 306	**55 °C**
	heat deflection temperature	ISO 75	**55 °C**
Mechanical	impact strength	ISO 179	**16 kJ/m^2**
	flexural modulus	ISO 178	**3500 MPa**
Physical	Density	ISO 1183/B	**1,24 g/cm^3**
	Melt Flow Index	ISO 1133	**6 g/10 min**

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