

TECHNICAL DATA SHEET

Use	is a material for the FDM (FFF) 3D printing additive technology		
Material	Polylactid acid by NatureWork, Biodegradabilic material, Non petroleum product		
Diameter	1,75 mm / 2,85 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 %		
	5,0 kg netto ± 5 % / 5,8 kg brutto ± 5 %		
Packing	Spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil.		
Colour	See www.filament-pm.com		
Solvents	1,2 Dichloroetan, Toluen, 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		
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	64.5 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