

## TECHNICAL DATA SHEET

|                             |   |            |                        |
|-----------------------------|---|------------|------------------------|
| <b>Use</b>                  | is a material for the FDM (FFF) 3D printing additive technology                   |            |                        |
| <b>Material</b>             | polylactid acid ,biodegradabilic material, non petroleum product, bamboo additive |            |                        |
| <b>Diameter</b>             | 1,75 mm   |            |                        |
| <b>Tolerance</b>            | ± 0,1 mm  |            |                        |
| <b>Weight</b>               | 0,5 kg netto ± 5 % / 0,7 kg brutto ± 5 %  |            |                        |
| <b>Packing</b>              | Spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil.                |            |                        |
| <b>Colours</b>              | See <a href="http://www.filament-pm.com">www.filament-pm.com</a>                  |            |                        |
| <b>Solvents</b>             | 1,2 Dichloroetan, Toluene, Tetrahydrofuran  |            |                        |
| <b>Printing Properties</b>  |   |            |                        |
| <b>Temperature HE</b>       | 200 - 215 °C  |            |                        |
| <b>Temperature HB</b>       | 20 - 60°C   |            |                        |
| <b>Surface bed</b>          | Kapton, Ultem, PET foil, commons for FDM printing                                 |            |                        |
| <b>Cooling print object</b> | Yes   |            |                        |
| <b>Nozzle</b>               | 0,4 mm or bigger  |            |                        |
| <b>Printer space</b>        | Open / Close  |            |                        |
| <b>Material Properties</b>  |   |            |                        |
| <b>Thermal</b>              | Vicat softening temperature   | ISO 306    | 55 °C                  |
|                             | Heat deflection temperature   | ISO 75     | 55 °C                  |
| <b>Mechanical</b>           | Impact strength   | ISO 179    | 10,2 kJ/m <sup>2</sup> |
|                             | Flexural modulus  | ISO 178    | 53,1 MPa               |
| <b>Physical</b>             | Density   | ISO 1183/B | 1,19 g/cm <sup>3</sup> |
|                             | Melt Flow Index   | ISO 1133   | 5,0 g/10 min           |