

## MATERIAL PROPERTIES

Density	1.23 g/cm <sup>3</sup>	D 792
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## Mechanical Properties

Tensile Modulus (Young)	2 600 MPa	D 638
Tensile Strength	32 MPa	D 638
Flexural Modulus	2 450 Mpa	D 790
Flexural Strength	56 MPa	D 790
Tensile strain at Break	12 %	D 638
Notched Izod Impact Strength 23C ( crystalline )	165 [J/m]	D 256
Notched Izod Impact Strength 23C ( amorphous )	97 [J/m]	D 256

## Thermal Properties

Heat Distortion Temperature (66 psi 0,45 MPa)	80-85°C	E 2092
Glass Transition Temperature	55-60°C	D 3418

## Print Settings\*

Nozzle temperature	200-230°C
Bed temperature	20-65°C
Active cooling fan	80- 100%
Print speed**	70-220 mm/s
Closed chamber	not
Dry box	not /optional
Ruby or hardened nozzle	not

### Features of filament

Basic material with very good printing parameters. The low shrinkage characteristic of PLA makes printing very simple and does not require advanced equipment, and the prints are precise and dimensionally stable. A great material for those starting their adventure with FDM technology. The highest quality raw materials and dyes were used for production, thanks to which the material meets the highest quality standards. An additional advantage is the fact that the filament is fully biodegradable, as well as odorless and approved for contact with food.

### STORAGE

Ensuring proper storage conditions is a guarantee that the shelf life of the filament will be 2 years. The product should be stored in a dry room at room temperature (18-250 C), protected from moisture and exposure to sunlight and heat.

### DISCLAIMER

The above data are for illustrative purposes only. Print parameters may change depending on conditions such as print geometry, surroundings, etc. These values are indicative and should not be construed as binding specifications. 3D Logic sp. z o.o. does not bear any responsibility for material losses, damage to health related to the use of the material.