

## TECHNICAL DATE SHEET

ALFAPLUS

BASE MATERIAL: Polylactic acid

### PROPERTIES

PROPERTIES	VALUE	ABS	PLA	PET-G	
PHYSICAL & MECHANICAL	Density	1,24 g/cm <sup>3</sup>	ISO 1183		
	CHARPY (test 80x10x4 mm)	25 kJ/m <sup>2</sup>	ISO 179-1eU		
	Elongation at break:	- Untreated	4,10%	ISO 527	
		- Annealed	2,35%	ISO 527	
	Tensile strength at break:	- Untreated	43 Mpa	ISO 527	
		- Annealed	51 Mpa	ISO 527	
		Flexure Modulus:	3070 Mpa	ISO 527	
		- Annealed	4100 Mpa	ISO 527	
THERMAL	Heat Deflection Temperature	- Untreated	58 °C	ISO 75	
		- Annealed	110 °C	ISO 75	

### SUGGESTED PRINTER SETTING

	VALUE	UNIT
Extruder Temperature	190 - 210	°C
Print Speed	40 - 120	mm/s
Bed Material	0 - 50	°C
Annealing Temperature	100 °C for 2-4 hr	with any support material (suggested in sand)

### PRODUCT DETAILS & CERTIFICATION

Diameter	1,75 mm 2,85 mm	Tolerance ± 0,05mm Tolerance ± 0,10mm
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