

## TECHNICAL DATE SHEET

ALFAPRO

BASE MATERIAL: Polylactic acid

### PROPERTIES

PROPERTIES	VALUE	METOD AND CONDICTION	
PHYSICAL & MECHANICAL	Density	1,24 g/cm <sup>3</sup>	ISO 1183
	CHARPY (test 80x10x4 mm)	14 kJ/m <sup>2</sup>	ISO 179-1eU
	Elongation at break: - Untreated	2,90%	ISO 527
	- Annealed	ND	ISO 527
	Tensile strength at break:		
	- Untreated	30 Mpa	ISO 527
	- Annealed	ND	ISO 527
	Flexure Modulus: - Untreated	2750 Mpa	ISO 527
	- Annealed	ND	ISO 527
	THERMAL	Heat Deflection Temperature	
- Untreated		58 °C	ISO 75
- Annealed		116 °C	ISO 75

### SUGGESTED PRINTER SETTING

	VALUE	UNIT
Extruder Temperature	200 - 220	°C
Print Speed	40 - 120	mm/s
Bed Material	0 - 50	°C
Annealing Temperature	100 °C for 2-4 hr	suggested in sand and/or with support

### PRODUCT DETAILS & CERTIFICATION

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