

## TECHNICAL DATE SHEET

PLA

BASE MATERIAL: Polylactic acid

### PROPERTIES

| PROPERTIES                       | VALUE                        | METOD AND CONDICTION |       |
|----------------------------------|------------------------------|----------------------|-------|
| <b>PHYSICAL &amp; MECHANICAL</b> | Density                      | 1,24 g/cm3           | D792  |
|                                  | Hardness/ Flexure Modulus    | 3,8 Gpa              | D790  |
|                                  | Tensile strength             | 53 Mpa               | D882  |
|                                  | Tensile Modulus              | 3,6 Mpa              | D882  |
|                                  | Tensile Elongation           | 6%                   | D882  |
| <b>THERMAL</b>                   | Melting point                | 135°C                | D1003 |
|                                  | Heat Deflection Temperature  | 55°C                 | E2092 |
|                                  | Viscat Softening Temperature | 55-60°C              | D3418 |
|                                  | <b>Flammability:</b>         |                      |       |
|                                  | Burging Rate                 | ND                   |       |
| Flame Rating                     | ND                           |                      |       |

### SUGGESTED PRINTER SETTING

|                      | VALUE     | UNIT   |
|----------------------|-----------|--------|
| Extruder Temperature | 170 – 210 | °C     |
| Print Speed          | 40 – 120  | mm/sec |
| Bed Material         | 0 – 50    | °C     |

### PRODUCT DETAILS & CERTIFICATION

|                 |                    |  |
|-----------------|--------------------|--|
| Diameter        | 1,75 mm<br>2,85 mm | Tollerance ± 0,05mm<br>Tollerance ± 0,10mm |
| REACH compliant |                    | ND   |
| FDA compliant   |                    | ND   |
| ROHS certified  |                    | ND   |

The information supplied in relation to our products recommendations or otherwise, is collected from source considered to be dependable or internally developed. Ciceri de Mondel Srl assumes no liability and makes no warranties of any kind about the accuracy of this datas. The user assumes all responsibility for the use of all information provided and shall.

Filoalfa by Ciceri de Model Srl  
Via Galvani 13, 20080  
Ozzero (MI)