

## Technical data sheet

# PLA+

Use	It is a material for the FDM (FFF) 3D printing additive technology.
Material	Poly lactid acid, Biodegradable material
Diameter	1,75 mm
Tolerance	± 0,05 mm
Weight	0,5 kg netto ± 5 % / 0,7 kg brutto ± 5 % 1,0 kg netto ± 5 % / 1,3 kg brutto ± 5 % 2,0 kg netto ± 5 % / 2,4 kg brutto ± 5 %
Packing	Spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil.
Colour	Viz <a href="http://www.filament-pm.com">www.filament-pm.com</a>
Solvents	1,2 Dichloroetan, Toluen, Tetrahydrofuran

### Printing Properties

Temperature HE	190 – 210 °C
Temperature HB	20 – 60 °C
Surface bed	Kapton, Ultem, PET foil, commons for FDM printing
Cooling print object	Yes
Nozzle	All diameters
Printer space	Open / Close

### Material Properties

Thermal	Vicat softening temperature	IISO 306	55 °C
	Heat deflection temperature	ISO 75	55 °C
Mechanical	Impact strength	ISO 179	64,5 kJ/m <sup>2</sup>
	Flexural modulus	ISO 178	3 000 MPa
	Hardness	Shore D	72,2
Physical	Density	ISO 1183/B	1,25 g/cm <sup>3</sup>
	Melt Flow Index	ISO 1133	3 g/10 min



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