

PLA-Matte Rainbow

Technical Data

Sheet

PLA-Matte Rainbow is base on the popular PLA-Matte filament, combine different colors according to different themes to match. The colorful and gorgeous rainbow filament maintain outstanding matte texture at same time. This filament is very suitable for creative design, the surface of the model is delicate and smooth, the printing effect is also good.

Basic Information

Characteristics	<ul style="list-style-type: none"> Colorful rainbow appearance Low density Fast printing 	<ul style="list-style-type: none"> Matte surface effect Easy to peel off support Lines are not easy to break
Applications	<ul style="list-style-type: none"> Prototyping Cosplay 	<ul style="list-style-type: none"> Decoration Other mechanical parts
Forming Method	<ul style="list-style-type: none"> Filament 	
Processing Method	<ul style="list-style-type: none"> 3D Printing 	

Physical Properties	Testing Method	Data
Density	GB/T 1033	1.329 g/cm ³
Melt Flow Index	GB/T 3682	5.8 (190°C/2.19kg)

Thermal Properties	Testing Method	Data
Heat Distortion Temperature	GB/T 1634	50.2 °C (0.45Mpa)
Glass Transition Temperature		N/A
Continuous Service Temperature	IEC 60216	N/A
Maximum (short term) Use Temperature		N/A

Electrical Properties	Testing Method	Data
Insulation Resistance	DIN IEC 60167	N/A
Surface Resistance	DIN IEC 60093	N/A

Mechanical Properties	Testing Method	Data
Tensile Strength (X-Y)	GB/T 1040	39.81Mpa
Tensile Strength (Z)	GB/T 1040	16.23 MPa
Elongation at Break (X-Y)	GB/T 1040	5.75 %
Elongation at Break (Z)	GB/T 1040	1.80 %
Flexural Strength (X-Y)	GB/T 9341	65 MPa
Flexural Strength (Z)	GB/T 9341	26.6 Mpa
Flexural Modulus (X-Y)	GB/T 9341	2914.68 MPa
Flexural Modulus (Z)	GB/T 9341	2223.34 Mpa
IZOD Impact Strength (X-Y)	GB/T 1843	3.67 KJ/m ²
IZOD Impact Strength (Z)	GB/T 1843	2.41 KJ/m ²

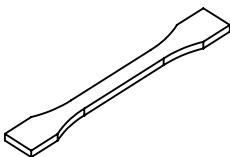
Chemical Properties	Data
Acid and Alkali Resistance	NO
Grease Resistance	N/A
UV Resistance	NO
Water Repellency	N/A

Recommended Printing Parameters	Data
Drying Preparation	60°C > 8H
Nozzle Size	0.4
Nozzle Temperature	210-230°C
Build Platform Type	PEI
Build Platform Temperature	65°C
Fan Speed	100%
Printing Speed	< 300mm/s

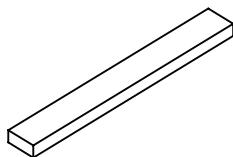
Printing Tips

When slicing, it is best to turn on the Z seam alignment and starting point alignment functions, turn off the Z-axis lift and exit, avoid passing through the shell when idling, optimize the slicing printing path, and appropriately reduce the printing speed to achieve the best printing effect.

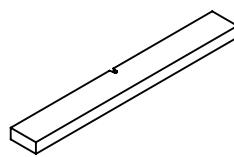
Test Conditions of Mechanical Properties



Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1843

The performance of the filament is evaluated based on standard samples printed by eSUN, while the actual printing performance is influenced by various factors such as printer type, printing parameters, and print environment.

Printing Test Conditions:

Extruder Temperature	220°C
Build Platform Temperature	65°C
Outer Layer Number	2
Top/Bottom Layer Number	3
Infill Density	100%
Fan Speed	100%

*Based on Bambu P1S 0.4 mm nozzle and Orcaslicer 2.1.0 Beta.

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