

PLA + · Technical Data Sheet

General Features

Chemical Name Polylactic acid	Benefits • Ideal ABS substitute for many tasks • Very low shrinkage	Main Applications Concept modeling, educational projects, design objects, ideal for high resolution or fast printing.
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Filament Characteristics

Diameter	Ø 1.75mm	Ø 2.85mm
Meters per spool	251.462m	94.811m
Weight per meter	2.98g	7.91g
Tolerance	±0.02mm	±0.03mm

Material Properties

		Typical value	ASTM Method
Tensile stress at yield, psi	MPa	7,440 (51)	D 638
Tensile strength, psi	MPa	7,290 (50)	D 638
Tensile elongation	%	3,31	D 638
Izod impact strength Notched , ft-lb/in	J/m	2,21 (118)	D 256
Clarity	-	Opaque	--
Heat distortion	°C	80-90	E 2092
Density	g/cm ³	1.04	D792
Melt Flow Index (220C, 10kg)	g/min	38 /10	D1238
Mold Shrinkage %	%	0.5 - 0.8	D955
Water Absorption %	%	-	D570

Recommended printer settings

Print temperature	200±5°C
Print bed temperature	50±5°C
Cooling fans	On except first layer
Closed environment	Not Required
Adhesive	Required

Available Colours

Colour	Pantone Code	Colour	Pantone Code	Colour	Pantone Code
Black	6C	Green	17-6153 TCX	Light Blue	2225C
Blue	2935 C	Red	485 C	Light Gray	428 C
Bronze	17F1028 TPX	Silver	427 CP	Light Green	802 C
Copper	876 C	Skin	489 C	Light Yellow	Yellow U
Gray	8402 C	White	11F4001	Neon Green	802 C
Natural	--	Yellow	1235 C	Neon Orange	172 C
Orange	1505 C	Pink	919 C	Neon Yellow	809 C

Disclaimer:

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