

## PLA Cristal

## MATERIAL PROPERTIES

Density	1.24 g/cm <sup>3</sup>	D 792
MFR (210°C, 2.16kg)	8 g/10min	ISO 1133-A

## Mechanical Properties

Charpy notched impact strength, 23°C	5 kJ/m2	ISO 527 (1)
Tensile Modulus	3500 MPa	ISO 527 (1)
Tensile Strength	50 Mpa	ISO 527 (1)
Elongation at Break	5,00%	ISO 527 (1)

## Thermal Properties

Heat deflection temperature (0.45MPa)	60°C	ISO 75-1
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## GUIDELINE FOR PRINT SETTINGS\*

Nozzle temperature	185-215°C
Bed temperature	0-45°C
Active cooling fan	YES (up to 100%)
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	40-150 mm/s
Closed chamber	not necessary
Dry box	not necessary
Ruby or hardened nozzle	not necessary

\* settings are based on a 0,4 mm nozzle.

\*\* depending on the geometrical complexity

## Disclaimer

The product- and technical data provided in this datasheet is correct to the best of Spectrum Group Sp. z o.o. knowledge and are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary according to printing conditions, model complexity, environmental conditions, etc. The user assumes all responsibility for the use of all information provided and shall verify quality and other properties or any consequence from the use of all such information. Typical values are indicative only and are not to be construed as being binding specifications. Spectrum Group Sp. z o.o. shall not be made liable for any damage, injury or loss induced from the use of Spectrum Group Sp. z o.o. materials in any particular application.

## DESCRIPTION

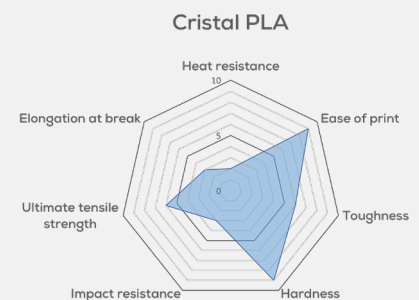
Cristal PLA is an innovative series of filaments designed especially for 3D printing enthusiasts who seek transparent and semi-transparent effects in their projects. Made from highly crystalline PLA, these filaments provide exceptional clarity and aesthetic appeal, which is not achievable with traditional non-transparent PLA filaments. This characteristic makes 3D prints using Cristal PLA visually appealing and suitable for various applications.

## FEAUTURES

- transparent, crystalline prints
- increased flow rate
- easy printing
- made of biodegradable raw materials
- heat deflection temperature - 60°C

## STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.



## SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at [support@spectrumfilaments.com](mailto:support@spectrumfilaments.com)