

PLA Nature

MATERIAL PROPERTIES

Specific Gravity	1.24 g/cm ³	D 792
MFR (210°C, 2.16kg)	6 g/10min	D 1238

Mechanical Properties

Tensile Strength at Break	53 MPa	D 882
Tensile Yield Strength	60 MPa	D 882
Tensile Modulus	3.5 Gpa	D 882
Tensile Elongation	6,00%	D 882
Notched Izod Impact	16 J/m	D 256
Flexural Strength	83 MPa	D790
Flexural Modulus	3.8 MPa	D790

Thermal Properties

Heat Distortion Temperature	55°C	E 2092
Glass Transition Temperature	55-60°C	D3418

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

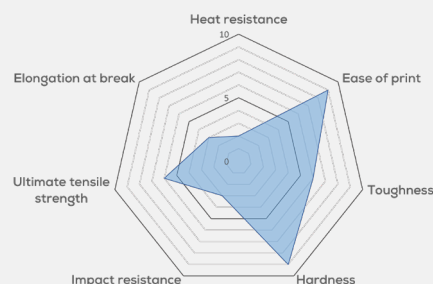
The PLA Nature series was designed with the intention of creating new textures in 3D printing materials through the use of bio-fillers. Filaments from the PLA Nature series are characterized by ease of printing, unique textures and colors and low shrinkage. A significant presence of visible bio-filler in PLA Nature filaments is a unique feature compared to the traditional PLA material.

FEAUTURES

- bio-filler
- unique texture
- ease of printing
- made of biodegradable raw materials

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