

THE FILAMENT PLA HS

MATERIAL PROPERTIES

General Properties

Density	1.24 g/cm ³	D 792
MFR (210°C, 2.16kg)	23 g/10min	D 1238

Mechanical properties

Charpy notched impact strength, 23°C	5 kJ/m ²	D 882
Tensile Modulus	3450 MPa	D 882
Tensile Strength	51 MPa	D 882
Elongation at Break	<5%	D 882

Thermal properties

Heat deflection temperature (0.45MPa)	60°C	E 2092
		D3418

GUIDELINE FOR PRINT SETTINGS*

Nozzle temperature	190-220°C
Nozzle temperature (High Speed)	225-250°C
Bed temperature	40-55°C
Closed chamber for printing	not necessary
Dry box recommended	No
Ruby or hardened nozzle recommended	No
Adhesive	not necessary (if you need increased adhesion or prevent warping: glue stick, Dimafix, 3DLac, Magigoo)
Cooling	Up to 100%
Surface finish	shiny / matte
Features	efficient and high speed 3D printing up to 600mm/s

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

** depending on the geometrical complexity

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

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.