

## TECHNICAL DATA SHEET

Use	is a material for the FDM (FFF) 3D printing additive technology		
Material	Polylactid acid + 20% blend colors, pearls and rocks adittives		
Diameter	1,75 mm		
Tolerance	± 0,1 mm		
Weight	0,5 kg netto ± 5 % / 0,7 kg brutto ± 5 %		
Packing	Spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil.		
Colours	See <a href="http://www.filament-pm.com">www.filament-pm.com</a>		
Solvents	1,2 Dichloroethane, Toluene, Tetrahydrofuran		
Printing Properties			
Temperature HE	200 - 220 °C		
Temperature HB	60 °C		
Surface bed	Kapton, Ultem, PET foil, commons for FDM printing		
Cooling print object	Yes		
Nozzle	All diameters / for glitter using nozzle min 0,5 mm and more		
Printer space	Open / Close		
Material Properties			
Thermal	Vicat softening temperature	ISO 306	55 °C
	Heat deflection temperature	ISO 75	55 °C
Mechanical	Impact strength	ISO 179	16 kJ/m²
	Flexural modulus	ISO 178	3500 MPa
Physical	Density	ISO 1183/B	1,24 g/cm³
	Melt Flow Index	ISO 1133	7 g/10 min
Optical	Light fastness	DIN 53387	7