

Technical data sheet

RePLA+

Use	It is a material for the FDM (FFF) 3D printing additive technology.
Material	Poly lactid acid by NatureWork, Biodegradable material
Diameter	1,75 mm
Tolerance	± 0,05 mm
Weight	1,0 kg netto ± 5 % / 1,3 kg brutto ± 5 %
Packing	Spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil.
Colour	See www.filament-pm.com
Solvents	1,2 Dichloroetan, Toluene, Tetrahydrofuran

Printing Properties

Temperature HE	220 – 250 °C
Temperature HB	60 – 80 °C
Surface bed	Kapton, Ultem, PET foil, commons for FDM printing
Cooling print object	Yes
Nozzle	All diameters
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	64,5 kJ/m ²
	Flexural modulus	ISO 178	3 500 MPa
	Hardness	Shore D	78,3
Physical	Density	ISO 1183/B	1,24 g/cm ³
	Melt Flow Index	ISO 1133	6 g/10 min



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