

## TECHNICAL DATA SHEET

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