

# Technical data sheet- PLA 3D filament

Printing features	Parameters
<b>Extrusion temperature</b>	Between 195 and 210°C
<b>Bed temperature</b>	Between 20 and 40°C
<b>Bed type</b>	Glass, micro-perforated metal
<b>Bed surface treatment</b>	Unimportant
<b>Chamber temperature</b>	Room temperature
<b>Ventilation</b>	100%
<b>Printing speed</b>	Around 50 – 60 mm/s (max)
<b>Retraction speed</b>	40 mm/s
<b>Retraction distance</b>	1.2 mm
<b>Printing difficulty level</b>	Very easy to print

Based on use on Zortrax M200 Plus and Z-Suite 2.8.3.0. Printing may vary between printers and printheads

## Recommendations:

- To avoid warping, an adhesive should be added for a printing on a smooth "mirror" type plate
- It is not recommended to print above 60 mm/s because this will damage the fine patterns

## **THESE VALUES ARE INDICATIVE AND MAY VARY**

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<b>Typical Material &amp; Application Properties <sup>(1)</sup></b>		
<b>Physical Properties</b>		<b>ASTM Method</b>
Specific Gravity	1.24	D792
Melt Index, g/10 min (210°C/2.16kg)	5-7	D1238
Clarity	Transparent	
<b>Mechanical Properties</b>		
Tensile Strength @ Break, psi (MPa)	7,700 (53)	D882
Tensile Yield Strength, psi (MPa)	8,700 (60)	D882
Tensile Modulus, kpsi (GPa)	500 (3.5)	D882
Tensile Elongation, %	6.0	D882
Notched Izod Impact, ft-lb/in (J/m)	0.24 (12.81)	D256
Shrinkage is similar to PET <sup>(2)</sup>		