

Technical datasheet DRAFT

PLA-HT

color**Fabb**

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If you're looking for outstanding temperature resistance of 134°C HDT, with easy-to-print properties of PLA, we introduce to you our PLA-HT 3D print filament.

No more annealing, reach the desired temperature resistance right after printing, no need for additional heat processing step.

TYPICAL MATERIAL PROPERTIES – 3D Printed

Physical properties	Unit	Value	Method
Tensile modulus	MPa	3766.37	ISO 527
Yield strength	MPa	55.13	ISO 527
Yield strain	%	2.07	ISO 527
Tensile strength	MPa	55.13	ISO 527
Tensile strain at tensile strength	%	2.07	ISO 527
Tensile stress at break	MPa	50.73	ISO 527
Tensile strain at break	%	3.07	ISO 527
Charpy unnotched impact strength	kJ/m ²	13.48	ISO 179-1/1 eU
Charpy notched impact strength	kJ/m ²	2.81	ISO 179-1/1 eU
HDT	°C	134*	ISO 75

*only injection molded data available

FILAMENT SPECIFICATION

Nominal diameter:	Diameter tolerance	Ovality
1,75 mm	± 0.1mm	≥ 95%
2,85 mm	± 0.1mm	≥ 95%

Netto filament weight 750g

GUIDELINE FOR PRINT SETTINGS

Nozzle temperature	200 - 220°C
Bed temperature	50°C
Bed surface / modification	-
Bed adhesion slicer settings	3D Lac
Cooling	50-100%
Print speed	40-100 mm/s
Layerheight	0.2 mm (for 0.4mm nozzle)

Disclaimer

The product- and technical information provided in this datasheet is correct to the best of our knowledge. The information given is provided as a guidance for good use, handling and processing and is not to be considered as a quality specification. The information only relates to the specific product and the material properties.