



## PLA filament

Printing Parameters		
Item	Results	Unit
Nozzle Temp	190-220	°C
Ideal Temp	195°C	°C
Heated Bed Temp	40°C~50°C	°C
Print speed	30~50	mm/s
Materials Parameters		
Density	1.24	g/cm <sup>3</sup> , D1505
Melt Flow Index	6	g /10 min, 190°C/5kg
Heat Distortion Temp	56	°C
Tensile Strength	75	MPa
Tensile Elongation	13	%
Flexural Strength	66	MPa
Flexural Modulus	2855	MPa
Impact Strength	4.8	KJ/m <sup>2</sup>
Diameter Accuracy	1.75mm: 1.70~1.78mm; 3.0mm: 2.90~3.0mm	