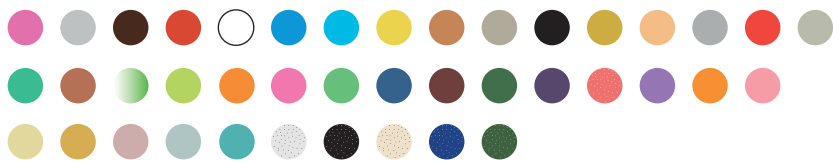


HIGH DEFINITION - Definition, surface finish and resistance.

Biodegradable filament and suitable for all 3D printers. It is very easy to print as it has no shrinkage so you can make really big pieces. With our PLA filament you can achieve a fantastic finish and vivid colors in all your pieces. Excellent adherence to bed between capable.



| PHYSICAL PROPERTIES                    | AVERAGE VALUES | UNITS         | STANDARDS  |
|--|----------------|---------------|------------|
| DENSITY                                | 1,24           | g/cm³         |            |
| FLOW RATE (210°C /2.16KG)              | 8              | g/10 min      | ISO 1133-A |
| FLOW RATE (190°C /2.16KG)              | 3              | g/10 min      | ISO 1133-A |
| STEREOCHEMICAL PURITY (CORBION METHOD) | 96             | (% L-isomero) |            |
| RESIDUAL MONOMER (CORBION METHOD)      | 0.3% (max)     |               |            |
| MOISTURE (COULOMETRIC KAR L-FISHER)    | 400 (max)      | ppm           |            |
| MELTING TEMPERATURE                    | 155°           | °C Tm (DSC)   |            |
| GLASS TRANSITION TEMPERATURE           | 55 - 60°       | °C Tg (DSC)   |            |

| MECHANICAL PROPERTIES       | AVERAGE VALUES | UNITS | STANDARDS   |
|-----------------------------|----------------|-------|-------------|
| TENSILE MODULUS             | 3500           | MPa   | ISO 527-1   |
| TENSILE STRENGTH            | 45             | MPa   | ISO 527-1   |
| STRAIN AT YIELD             | 5% (max)       |       | ISO 527-1   |
| CHARPY NOTCHED IMPACT, 23°C | ≤5             | kJ/m² | ISO 179-1eA |

| PRINTING PROPERTIES | AVERAGE VALUES | UNITS | STANDARDS |
|---------------------|----------------|-------|-----------|
| NOZZLE TEMPERATURE  | 190 - 230      | °C    |           |
| HOT BED TEMPERATURE | 50 - 70        | °C    |           |
| COOLING FAN         | ON (100)       | %     |           |

| SPOOL SIZE | DIAMETER       | ON REQUEST | COLOR   | PACKAGING                       |
|------------|----------------|------------|---------|---------------------------------|
| 300g       | 1,75mm         |            | Various | Carboard box, vacuum and silica |
| 1Kg        | 1,75 - 2,85 mm |            | Various | Carboard box, vacuum and silica |
| 3Kg        | 1,75 - 2,85 mm | Yes        | Various | Carboard box, vacuum and silica |
| 5Kg        | 1,75 - 2,85 mm | Yes        | Various | Carboard box, vacuum and silica |
| 8Kg        | 1,75 - 2,85 mm | Yes        | Various | Carboard box, vacuum and silica |

\* The indicated parameters are valid for correctly calibrated printers (PID, mechanical and fuser).  
\* Supervised and tested manufacturing process (diameter, color and winding) to guarantee the quality of our product.