



PLA

Property Data

Property	Test Method	Value	Comment
Melt Flow Index/ g/10 mins	ASTM D1238	5 – 15	Dependent on color. Tested at <400 ppm moisture
Density/ gcm ⁻³	ASTM D792	1.22	Resin Manufacturer data
Glass transition temperature/ °C	ASTM D3418	55	Resin Manufacturer data
Heat Deflection Temperature/ °C *	ASTM D648 at 66 psi	54	
Tensile Strength at Yield/ psi *	ASTM D638, Type IV	9320	
Tensile Elongation/ % *	ASTM D638, Type IV	5	
Flexural Modulus/ kpsi *	ASTM D790	1150	
Flexural Peak Stress / kpsi *	ASTM D790	25.1	
Notched Izod Impact/ Jm ⁻¹ *	ASTM D256	27	

* 3D printed test specimens using Ultimaker 2+; 100 % infill; y-axis orientation; tested in an independent lab

Recommended Printer Conditions

Nozzle temperature*	205 °C
Heated bed temperature	Ambient - 55 °C
Speed**	90-150 mm/s
Infill	As needed, up to 100 %
Bed material	Adheres to a variety of standard bed materials, including: Glass, painter's tape, BuildTak, PEI, Kapton tape, glue sticks etc.

*Nozzle temperature recommendations based on achieving better print definition. The recommendations given above leave about ±15°C depending on specific printers and other print settings.

**Higher print speeds might require higher nozzle temperatures

These processing conditions are general guidelines only. Each printer will likely have a unique set of printing parameters.