



Technical Data Sheet

Product name: PLA

Version: 1.0

Date: 01.21.2024

Dimensions

Size	Ø tolerance	Roundness
1,75 mm	± 0.05 mm	± 0.05 mm
2,85 mm	± 0,10 mm	± 0,10 mm

Description	Typical value	Test method
Density	1.1783 g/cc	ISO 1183,GB/T 1033
Meltindex (MFR)	8.90 g/10 min (210 °C/2,16kg)	ISO 1133,GB/T 3682
Glasstransition temperature	61.8 °C	DSC,10 °C/min
Melting temperature	172.33 °C	DSC,10°C/min
Crystallinity	82.2630%	DSC,10°C/min
Vicatsofteningtemperature	62 °C	ISO306,GB/T1633
Heatdeflectiontemperature	51.9 °C	ISO 75 1.8MPa
Heatdeflectiontemperature	56.0 °C	ISO 75 0.45MPa
Tensile strength at Yield	41.58 MPa	ISO 527, GB/T 1040
Strain at yield	9.050%	ISO 527, GB/T 1040
Strain at break	17.427%	ISO 527, GB/T 1040
Modulus	348.017 MPa	ISO 527, GB/T 9341
Bendingmodulus	2590.963MPa	ISO 178, GB/T 9341
Bending strength	69.323MPa	ISO 178, GB/T 9341
Impact strength	5.438 kJ/ m ²	ISO 179, GB/T 1043
Layer Adhesion (Impact Strength - Z)	2.302 kJ/ m ²	ISO 179, GB/T 1043



Moisture absorption	0.11%	ISO 62 23°C, 50% RH
---------------------	-------	---------------------

MATERIAL PROPERTIES

GUIDELINE FOR PRINT SETTINGS

Description	Typical value
Printing temperature	200 – 220 °C
Build Plate Compatibility	BuildTak®, Glass, BlueTape, PEI
Bed Temperature	50-60°C (Glue Recommended)
Cooling fan	100%
Drying Settings	45-50°C (Blast Drying Oven)
Printing speed	50-400(mm/s)
AMS Compatibility	YES
Raft separation distance	0.2(mm) Settings are based on a 0.4mm nozzle.
Retraction speed	40(mm/s)
Hotend Compatibility	0.2mm, 0.3mm, 0.4mm, 0.6mm, 0.8mm 1.0mm nozzle.
Environmental temperature	25°C Room temperature

Packaging:

All spools are sealed and packed with silica gel to avoid humidity.

Additional info:

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End- use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

Each user is responsible for determining the safety, lawfulness, technical suitability, and disposal/ recycling practices of R3D materials for the intended application. R3D makes no warranty of any kind, unless announced separately, to the fitness for any use or application. R3D shall not be made liable for any damage, injury or loss induced from the use of R3D materials in any application.

Storage: Cool and dry (15-25°C) and away from UV light. This enhances the shelf life significantly.