

# PLA Crystal

## MATERIAL PROPERTIES

Density	1.24 g/cm <sup>3</sup>	
MFR (210°C, 2.16kg)	8 g/10min	ISO 1133-A

## Mechanical properties

Charpy notched impact strength, 23°C	5 kJ/m <sup>2</sup>	ISO 527 (1)
Tensile Modulus	3500 MPa	ISO 527 (1)
Tensile Strength	50 Mpa	ISO 527 (1)
Elongation at Break	5,00%	ISO 527 (1)

## Thermal properties

Heat deflection temperature (0.45MPa)	60°C	ISO 75-1
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## GUIDELINE FOR PRINT SETTINGS\*

Nozzle temperature	185 - 215°C
Bed temperature	0 - 45°C
Active cooling fan	YES (up to 100%)
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	40 - 200 mm/s
Closed chamber	not necessary
Dry box	not necessary
Ruby or hardened nozzle	not necessary

\* settings are based on a 0,4 mm nozzle.  
\*\* depending on the geometrical complexity

## DESCRIPTION

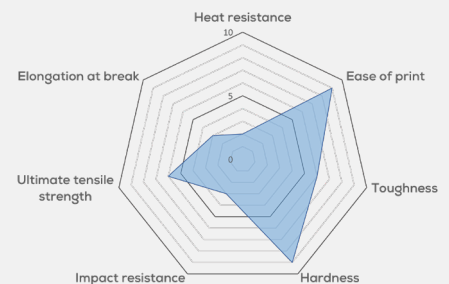
PLA Crystal is an innovative filament series tailored for 3D printing enthusiasts seeking transparent and semi-transparent effects. Crafted from highly crystalline PLA, these filaments offer exceptional clarity and aesthetics, setting them apart from traditional non-transparent PLA. With nearly 30% improved flow rates, they enable smoother and more precise 3D printing.

## FEAUTURES

- transparent, crystalline prints
- increased flow rate
- easy printing
- made of biodegradable raw materials

## STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.



## SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at [support@spectrumfilaments.com](mailto:support@spectrumfilaments.com)