

## THE FILAMENT PLA HS

### MATERIAL PROPERTIES

#### General Properties

Density	1.24 g/cm <sup>3</sup>	D 792
MFR (210°C, 2.16kg)	23 g/10min	D 1238

#### Mechanical properties

Charpy notched impact strength, 23°C	5 kJ/m <sup>2</sup>	D 882
Tensile Modulus	3450 MPa	D 882
Tensile Strength	51 MPa	D 882
Elongation at Break	<5%	D 882

#### Thermal properties

Heat deflection temperature (0.45MPa)	60°C	E 2092
		D3418

### GUIDELINE FOR PRINT SETTINGS\*

Nozzle temperature	190-220°C
Nozzle temperature (High Speed)	225-250°C
Bed temperature	40-55°C
Closed chamber for printing	not necessary
Dry box recommended	No
Ruby or hardened nozzle recommended	No
Adhesive	not necessary (if you need increased adhesion or prevent warping: glue stick, Dimafix, 3DLac, Magigoo)
Cooling	Up to 100%
Surface finish	shiny / matte
Features	efficient and high speed 3D printing up to 600mm/s

\* settings are based on a 0,4 mm nozzle.

\*\* depending on the geometrical complexity

### 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)

#### Disclaimer

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