

Product name:

ANYCUBIC PLA

BASIC PHYSICAL PROPERTY

Property	Testing Method	Unit	Typical Value
Density	ISO 1183,at 23°C	g/cm ³	1.241±0.06
Melt Index	ISO 1133	g/10min	4.86±0.35
Moisture Content	ISO 787-2	%	0.25±0.03

MECHANICAL PROPERTY

Property	Testing Method	Unit	Typical Value
Tensile Strength (X-Y)	ISO 527	MPa	51.2±0.6
Tensile Strength (Z)			24.2±0.7
Young's Modulus (X-Y)	ISO 527	MPa	2834±79
Young's Modulus (Z)			2426±156
Elongation at Break (X-Y)	ISO 527	%	4.2±1.1
Elongation at Break (Z)			1.1±0.15
Bending Strength (X-Y)	ISO 178	MPa	79.2±1.1
Bending Strength (Z)			N/A
Bending Modulus (X-Y)	ISO 178	MPa	3020±12
Bending Modulus (Z)			N/A
Izod Impact Strength (X-Y)	ISO 179	kJ/m ²	21.48±0.89
Izod Impact Strength (Z)			10.3±0.6

All data are printed sample test results, "(X-Y)" and "(Z)" represents different directions(reference diagram)

THERMAL PROPERTY

Property	Testing Method	Unit	Typical Value
Glass Transition Temperature	ISO 11357-1, 10°C/min	°C	59.2
Melting Temperature	ISO 11357-1, 10°C/min	°C	169.5
Crystallization Temperature	ISO 11357-1, 10°C/min	°C	114.3
Vicat Softening Temperature (VST)	ISO 306, 10N	°C	62.1
Heat Deflection Temperature (HDT)	ISO 75-2, 0.45MPa	°C	55.1
Heat Deflection Temperature (HDT)	ISO 75-2, 1.8MPa	°C	52.7

RECOMMENDED PRINT PARAMETER

*Based on 0.4mm nozzle, printing condition may vary with different nozzle diameters

Parameter	Recommended Value
Nozzle Temperature	190~230°C
Bed Temperature	55~65°C
Dry Environment	50~60°C, 6~8h
Printing Speed	50~200mm/s
Extrusion Multiplier	0.98
Max Volumetric Flow Rate	12mm ² /s
Fan Speed	60-100%
Cooling Time	9s
Min printing Speed	20mm/s
Raft Separation Distance	1mm
Retraction Speed	80mm/s

Attention:

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.