ANYCUBIC
3D PRINTER FILAMENT

Version: 3.0

Product Name:

Anycubic PLA+

Anycubic PLA+ is an eco-friendly filament known for its high toughness, impressive impact resistance, and excellent elongation at break. It offers outstanding resistance to wear and deformation when printing moving components. The PLA+ filament ensures high printing success rates due to its uniform diameter and minimal risk of nozzle clogging.

Physical Properties

Property	Testing Method	Unit	Typical Value
Density/（g/cm³）	ISO 1183,at 23°C	g/cm³	1.21
Melt Index/ (g/10min)	ISO 1133	g/10min	6.2±0.32
Moisture Content	ISO 787-2	%	0.23

Mechanical Properties

Property	Testing Method	Unit	Typical Value
Tensile Strength / MPa (X-Y)	ISO 527	MPa	45±5
Tensile Strength / MPa (Z)			23.8±0.4
Young's Modulus / MPa (X-Y)	ISO 527	MPa	2790±250
Young's Modulus / MPa (Z)			/
Elongation at Break / % (X-Y)	ISO 527	%	12±1
Elongation at Break / % (Z)			/
Bending Strength / MPa (X-Y)	ISO 178	MPa	82±8
Bending Strength / MPa (Z)			/
Bending Modulus / MPa (X-Y)	ISO 178	MPa	3980±360
Bending Modulus / MPa (Z)			/
Izod Impact Strength (kJ/m²) (X-Y)	ISO 179	kJ/m²	28±1
Izod Impact Strength (kJ/m²) (Z)			/

*All data are based on printed test samples. '(X-Y)' and '(Z)' indicate different testing orientations (refer to the direction schematic).

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Thermal Performance

Property	Testing Method	Unit	Typical Value
Glass Transition Temperature	ISO 11357-1, 10℃/min	℃	54.2
Melting Temperature	ISO 11357-1, 10℃/min	℃	162
Crystallization Temperature	ISO 11357-1, 10℃/min	℃	108
Vicat Softening Temperature (VST)	ISO 306, 10N	℃	52
Heat Deflection Temperature (HDT)	ISO 75-2, 1.8 MPa	℃	/
Heat Deflection Temperature (HDT)	ISO 75-2, 0.45MPa	℃	50

Recommended Printing Parameters

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

Parameter	Recommended Value
Nozzle Temperature	190-230
Bed Temperature	55-65
Dry Environment	45-50℃，6-8h
Printing Speed	50-200
Extrusion Multiplier	0.96
Max Volumetric Flow Rate	12
Fan Speed	100%
Cooling Time	8
Minimum printing Speed	20
Raft Separation Distance	0.8
Retraction Speed	30

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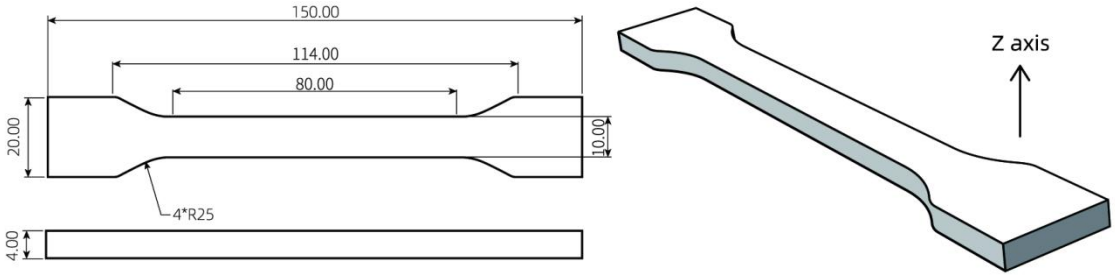
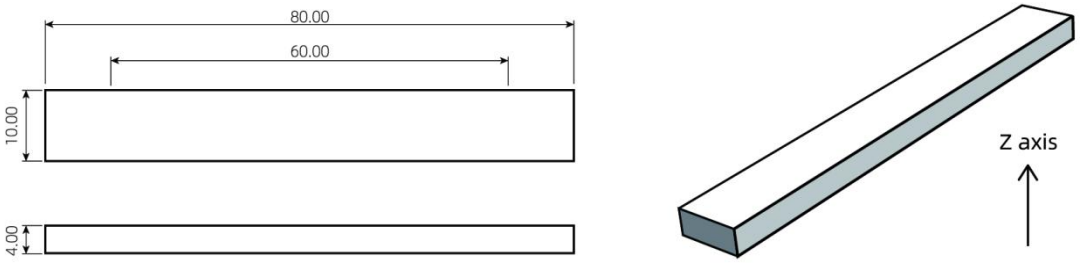
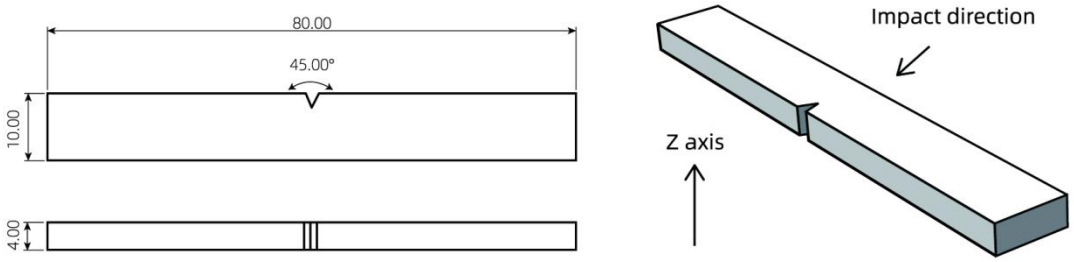
TENSILE TESTING SPECIMEN



IMPACT TESTING SPECIMEN



IMPACT TESTING SPECIMEN



Disclaimer：

The values shown in this chart are for comparison purposes only and are not appropriate for design specifications or quality assurance. Variations may arise due to printing conditions. The end-use performance of printed parts depends on materials, design, environmental conditions, and printing conditions. Please note that product specifications are subject to change without notice.

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