

TECHNICAL DATA SHEET

PLA Magic SILK

MATERIAL PROPERTIES

Specific Gravity	1.22 g/cm ³	D 792
MFR (210°C, 2.16kg)	6 g/10min	D 1238
Mechanical Properties		
Tensile Strength at Break	45 MPa	ISO 527
Tensile Strength at Yield	59 MPa	ISO 527
Tensile Modulus	2700 MPa	ISO 527
Elongation at Break	10,00%	ISO 527
Elongation at Yield	5,00%	ISO 527
Notched Izod Impact Strength	6 J/m	D 256
Flexural Strength	72 MPa	D790
Thermal Properties		
Heat Distortion Temperature	50°C	ISO 75
Glass Transition Temperature	57°C	DSC

GUIDELINE FOR PRINT SETTINGS*

Nozzle temperature	210-240°C	
Bed temperature	40-60°C	
Active cooling fan	YES (up to 100%)	
Layer height**	0.05 - 0.30 mm	
Shell thickness**	0.40 - 2.70 mm	
Print speed**	40-110 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.

Disclaimer

The product- and technical data provided in this datasheet is correct to the best of Spectrum Group Sp. z o.o. knowledge and are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary according to printing conditions, model complexity, environmental conditions, etc. The user assumes all responsibility for the use of all information provided and shall verify quality and other properties or any consequence from the use of all such information. Typical values are indicative only and are not to be construed as being binding specifications. Spectrum Group Sp. z o.o. shall not be made liable for any damage, injury or loss induced from the use of Spectrum Group Sp. z o.o. materials in any particular application.

DESCRIPTION

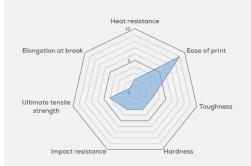
Spectrum Magic SILK PLA is an innovative 3D filament that, thanks to co-extrusion technology, combines two colors in one strand, creating stunning color transitions. The color-changing effect, depending on the viewing angle and lighting, gives prints depth and a unique, dynamic appearance.

FEAUTURES

- · Co-extrusion technology: two colors in one strand
- Dynamic color transitions depending on the viewing angle
- · Color-changing effect
- · Smooth, silky print surface
- High aesthetics and unique character of models

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



 $^{^{**}}$ depending on the geometrical complexity