

# PLA Magic SILK

## MATERIAL PROPERTIES

Specific Gravity	1.22 g/cm <sup>3</sup>	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.

\*\* depending on the geometrical complexity

## DESCRIPTION

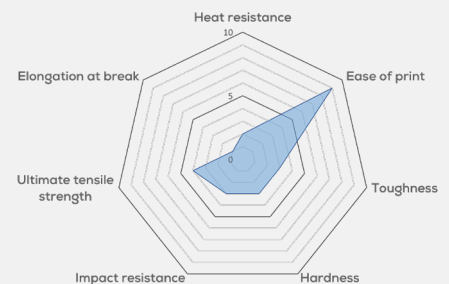
Spectrum Magic SILK PLA is an innovative 3D filament that, thanks to co-extrusion technology, combines two colors in one strand, creating stunning color transitions. The color-changing effect, depending on the viewing angle and lighting, gives prints depth and a unique, dynamic appearance.

## 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](mailto:support@spectrumfilaments.com)