

THE FILAMENT HT-PLA

MATERIAL PROPERTIES

Physical		
Specific Gravity	1.2 g/cm3	ISO 1183
Mechanical Properties		
Tensile Strength	44 MPa	ISO 527
Tensile strength at break	27,5 MPa	ISO 527
Elongation at break	12 %	ISO 527
Tensile modulus	2620 MPa	ISO 527
Flexural Modulus	3350 MPa	ISO 178
Charpy impact strength notched, 23°C	2,1 kJ/m2	ISO 179
Thermal Properties		
Heat Deflection Temperature	108°C	DSC
VICAT	140°C	DSC

GUIDELINE FOR PRINT SETTINGS*

Nozzle temperature	195-220°C
Nozzle temperature (High Speed)	
Bed temperature	40-50°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	40-80%
Surface finish	shiny
Features	VICAT - 140°, biodegradable, odour-free printing

* 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**

Disclaimer
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