



Description

PLA Prime is our high-end engineering grade PLA. Due to our enhanced formulation, PLA Prime has great heat resistance, high impact resistance and has negligible shrinkage after annealing.

The ease of use combined with the capability of high-speed printing and great interlayer adhesion, makes PLA Prime a reliable material that can handle the most intricate prints.

Typical properties

	Standard	Value	Unit
Specific gravity	ISO 1133	1.27	g/cc
Melt flow rate	ISO 1133	6	cm ³ /10 min
Melting temp.	ISO 294	230	°C
Heat deflect. temp.	ISO 75	95*	°C

Typical properties (3D printed)

	Standard	XY Value	XZ Value	ZX Value	Unit
Tensile Strength	ISO 527-2	27.8	31.4	14.2	MPa
Yield Strength	ISO 527-2	26.1	29.7	14.5	MPa
Tensile Modulus	ISO 527-2	2400	2600	1900	MPa
Strain at Yield	ISO 527-2	4.3	6.5	0.9	%
Flexural Strength	ISO 178	52.3	56.4	3.0	MPa
Flexural Modus	ISO 178	2600	3000	1800	MPa
Impact Strength	ISO 179	21.5	/	/	kJ/m ²

All specimens were printed with 100% infill, 2 shells and a layer height of 0.2mm

Printing recommendations

	Standard	Value	Unit
Printing temp.	AF	230	°C
Bed temp.	AF	60	°C
Printing speed	AF	≤300	mm/s
Cooling	AF	100	%
Bed surface	/	Textured PEI	/

