

# Technical Data Sheet: PLA Basic

## Material:

**PLA Basic** is a bio-based filament produced in Austria. It offers consistent quality, clean winding, and certified standards. The material is easy to process, supports high-speed printing up to 350 mm/s, and delivers a glossy surface with fine details. PLA Basic provides excellent value for money while ensuring reliable, high-quality printing results.

## Physical properties:

Description	Typical value	Unit	Test method
Density	1,24	g/cm <sup>3</sup>	ASTM D792
Tensile modulus	500 (3,5)	MPa	ASTM D882
Tensile strength	53	MPa	ASTM D882
Yield stress	60	MPa	ASTM D882
Elongation at yield	6	%	ASTM D882
Impact strength	0,3	kJ/m <sup>2</sup>	ASTM D256
HDT	55	°C	ASTM E2092
Melting temperature	180-200	°C	ISO 3146-C
MFR	6	g/10min	ASTM D1238
Shrinking	0,4	%	ASTM D955

## Print settings:

Description	Typical value
Printing Temperature	200-230 °C
Heated Bed	20-60 °C
Speed	20-200 mm/s
Max. volumetric speed	21 mm <sup>3</sup> /s
Cooling	30-100 %
Adhesive	not required
Enclosure	not required
Hardened nozzle	not required

## Additional info:

All spools are sealed and packed with silica gel to avoid humidity.

Store in a dry place at room temperature (18–27 °C). Avoid exposure to heat or direct sunlight.