

# ePLA-Silk Candy

Technical Data Sheet

ePLA Silk Candy has a silk-like glossy texture, with the ever-changing candy colors, giving the model a lively and beautiful appearance, presenting a dynamic beauty. Furthermore, the model's surface is smooth and free of layer lines. This filament is based on PLA material modification, as easy to print as PLA.

|                   |   |  |
|-------------------|---|--|
| Material Status   | Mass Production   |  |
| Characteristics   | <ul style="list-style-type: none"> <li>• Silk-like glossy texture</li> <li>• Colorful appearance</li> </ul> | <ul style="list-style-type: none"> <li>• Smooth surface</li> <li>• Easy to peel off support</li> </ul> |
| Applications      | <ul style="list-style-type: none"> <li>• Cultural Creativity</li> </ul>                                     | <ul style="list-style-type: none"> <li>• Animation Industry</li> </ul>                                 |
| Form              | <ul style="list-style-type: none"> <li>• Filament</li> </ul>  |  |
| Processing method | <ul style="list-style-type: none"> <li>• 3D Print, FDM Print</li> </ul>                                     |  |

|                                      | testing method | Typical value |                   |
|--------------------------------------|----------------|---------------|-------------------|
| <b>Physical Properties</b>           |                |               |                   |
| Density                              | GB/T 1033      | 1.24          | g/cm <sup>3</sup> |
| <b>Mechanical Properties</b>         |                |               |                   |
| Tensile Strength                     | GB/T 1040      | 19.33         | MPa               |
| Elongation at Break                  | GB/T 1040      | 3.03          | %                 |
| Flexural Strength                    | GB/T 9341      | 85.18         | MPa               |
| Flexural Modulus                     | GB/T 9341      | 2770.8        | MPa               |
| IZOD Impact Strength                 | GB/T 1843      | 3.45          | kJ/m <sup>2</sup> |
| <b>Thermal Properties</b>            |                |               |                   |
| Heat distortion Temperature          | GB/T 1634      | 52.15         | °C                |
| Continuous Service Temperature       | IEC 60216      | N/A           |                   |
| Maximum (short term) Use Temperature |                | N/A           |                   |
| <b>Electrical Properties</b>         |                |               |                   |
| Insulation Resistance                | DIN IEC 60167  | N/A           |                   |
| Surface Resistance                   | DIN IEC 60093  | N/A           |                   |

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### Recommended printing parameters

|                            |               |
|----------------------------|---------------|
| Extruder Temperature       | 200- 220°C    |
| Build Platform Temperature | 45-60°C       |
| Fan Speed                  | 100%          |
| Printing Speed             | 40 - 300 mm/s |

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2. Printing conditions may vary with different nozzle diameters

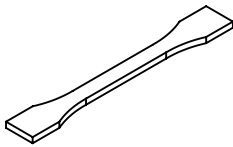
### Drying Recommendations

N/A

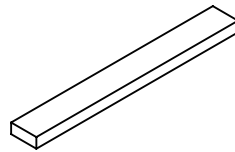
### Precautions:

Reducing overhang angle structure in the model or the speed in printing to keep the cooling.

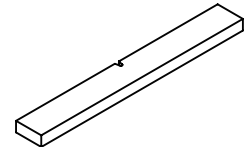
### Mechanical Properties



Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1043

The physical properties, mechanical properties, thermal properties, and electrical properties of the line are obtained based on the injection molding spline test.

### Print test condition:

|                            |         |
|----------------------------|---------|
| Extruder Temperature       | 220°C   |
| Build Platform Temperature | 55°C    |
| Outline/Perimeter Shells   | 4       |
| Top/Bottom Layers          | 4       |
| Infill Percentage          | 100%    |
| Fan speed                  | 100%    |
| Printing speed             | 130mm/s |

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2.

### Notice

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