

# ePLA-Silk Magic

Technical Data Sheet

The model has a dreamy and gorgeous two-color appearance, different color performance can be observed at different angles, rotating the model more dynamic sense of the two-color gradient brought about by the appearance of rich silk luster texture, the surface is smooth and does not show the layer of lines; support compared to other materials, easier to peel off from the surface of the model, the surface of the contact surface is smooth and even; the product is based on the modification of the PLA material from the characteristics of PLA easy to print.

Material Status	Mass Production
Characteristics	<ul style="list-style-type: none"> <li>• Dreamy and gorgeous two-color appearance</li> <li>• Smooth surface.</li> <li>• Easy to print as PLA.</li> </ul>
Applications	<ul style="list-style-type: none"> <li>• Toys</li> <li>• Decoration</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	1.256	g/cm <sup>3</sup>
Melt Flow Index	GB/T 3682	4.8	190°C/2.16kg
<b>Mechanical Properties</b>			
Tensile Strength	GB/T 1040	52	MPa
Elongation at Break	GB/T 1040	14.4	%
Flexural Strength	GB/T 9341	65	MPa
Flexural Modulus	GB/T 9341	1447	MPa
IZOD Impact Strength	GB/T 1843	5.86	kJ/m <sup>2</sup>
<b>Thermal Properties</b>			
Heat distortion Temperature	GB/T 1634	54.7	°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	190- 230°C
Build Platform Temperature	45-60°C
Fan Speed	100%
Printing Speed	40 - 100mm/s

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

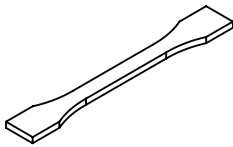
### Drying Recommendations

N/A

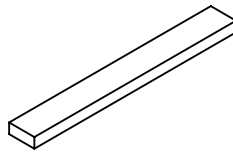
### Precautions:

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

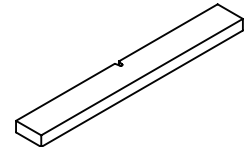
### Mechanical Properties



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	190-230°C
Build Platform Temperature	45°C
Outline/Perimeter Shells	4
Top/Bottom Layers	4
Infill Percentage	20%
Fan speed	100%
Printing speed	40mm/s

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

### Notice

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