TECHNICAL DATA SHEET

High Gloss PLA

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Product specifications

High Gloss PLA is an aesthetical PLA type of 3D printer filament that 3D prints parts without visible layers and an extremely high surface gloss and high level of light dispersion and reflection.

Important key features

High level of light dispersion and reflection
Very smooth and silky surface finish
Compatible with AquaSolve PVA for complex dual extrusion 3D printing

Suitable applications

Aesthetics, design, and art
Complex educational projects and models
Household articles

Recommended pretreatment

Drying	Not necessary	**Print with**	
	30 - 60 °C	Enclosure	No
	6 h	Dry box	No

Recommended print settings regular speed

Print speed	25 - 110 mm/s
Nozzle temperature	210 - 240 °C
Bed temperature	40 - 60 °C
Fan speed	80 - 100 %

Material properties	**Typical value**	**Unit of Measure**	**Test method**	**Test condition**
Density				
Specific gravity	1,22	g/cm3	ASTM D792	
Melt flow rate	6	g/10min	ASTM D1238	210°C/2,16kg
Mechanical properties				
Impact strenght	6	J/m	ASTM D256	Izod notched 23°C
Tensile strenght at yield	59	MPa	ISO 527	
Tensile strenght at break	45	MPa	ISO 527	
Tensile modulus	2700	MPa	ISO 527	
Elongation at yield	5	%	ISO 527	
Elongation at break	10	%	ISO 527	
Flexural strenght	72	MPa	ASTM D790	
Flexural modulus				
Rockwell hardness				
Thermal properties				
Melting temperature				
Heat deflection temperature	50	°C	ISO 75	HDT A
Vicat softening temperature				
Glass transition temperature	57	°C	DSC	

Product export information

HS code	**Description**	**Origin**
39169090	Monofilament for 3D printing	European Union

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