TECHNICAL DATA SHEET
PLA BASIC

1. DESCRIPTION

PLA is a bio-based material and is one of the most commonly used polymer for 3D printing. It is ideal for a wide range of applications, including prototyping, architecture, modelling and DIY projects. The raw material is approved according to REACH, RoHS and FDA standards. Due to its low melting temperature, PLA Basic is very easy to print and enables the production of impressive end products with a glossy surface. High-speed printing up to 350 mm/s is possible with the material.

2. FEATURES

- Excellent price-performance ratio
- Wide range of colours
- Easy to process
- Very high print quality
- Made from renewable raw materials
- Biodegradable (EN 13432)

3. PROPERTIES

TEST	METHOD	UNIT	VALUE
Tensile modulus (E-Modulus)	ASTM D882	MPa	500 (3,5)
Tensile strength	ASTM D882	MPa	53
Stress at break	ASTM D882	MPa	60
Nominal elongation at break	ASTM D882	%	6
Notched impact strength	ASTM D256	kj/m²	0,3
HDT	ASTM E2092	°C	55*
Melting temperature	ISO 3146-C	°C	180-200
MFR	ASTM D1238	g/10min	6
Shrinking	ASTM D955	%	0,4
Density	ASTM D792	g/cm³	1,24

*Temperature resistance tested at a minimum wall thickness of 4 mm.

PRINT SETTINGS	
Nozzle	200-230°C
Heatbed	20-60°C
Adhesive	not required
Speed	20-200mm/s
Cooling	30-100%
Enclosed Space	no
Hardened Nozzle	no
Max. Volumetric Speed	21 mm³/s

Recommended settings for printers with a 0.4mm Nozzle. Max. 50% layerheight. Optimal print settings may vary between different printers and also depend on environmental factors.

4. CERTIFICATIONS & ADDITIONAL INFORMATION

FDA compliant · RoHS compliant · REACH compliant · FREE of Silicone · DEGRADABLE ISO 14885 · RECYCABLE · TOY SAFE compliant

Certifications depend on colors in final product. More info in the additional information sheet.

5. STORAGE AND SHELF LIFE

Store in a dry room at room temperature (18-27°C / 65-80°F). Keep out of direct heat and sunlight.
When stored correctly, this material has a shelf life of 2 years.
Additional info in our regulatory, additional information and chemical resistance data sheets.