

## BASIC INFORMATION

**PRODUCT NAME:** FILAMENT 3D PLA Starter 1.75mm

**PRODUCT DESCRIPTION:** PLA Starter Filament is a poly(lactic acid) filament for FFF/FDM 3D printing. The supplied filament is wound on a spool or cardboard core (no spool), vacuum sealed in a moisture absorbing bag and packaged in a cardboard box. The product is designed for use with 3D printers using FDM technology. It should be used in a well-ventilated room to avoid exposure to fume emissions during printing. It is important to avoid direct contact with hot printer components, which can lead to burns. Filament should be stored in a dry place, in a closed container and away from children. It is recommended to use the felt material within the recommended printing temperature range for optimum results. Dispose of waste filament in accordance with local regulations. The product has been designed with safety in mind and meets all relevant standards for consumer use.

**STORAGE:** Store in dry area. Store in a closed container.

## PRODUCT PARAMETERS

| PARAMETER               | VALUE   |
|-------------------------|---------|
| Filament diameter [mm]  | 1.75    |
| Diameter tolerance [mm] | +/-0,05 |
| Oval tolerance [mm]     | +/-0,02 |

## RECOMMENDED PRINTING PARAMETERS

| PARAMETER                    | VALUE   |
|------------------------------|---------|
| 3D printing temperature [C]  | 190-225 |
| Heated bed [C]               | 40-60   |
| Cooling fan [%]              | 70-100  |
| Closed chamber               | no      |
| Recommended nozzle           | brass   |
| Recommended nozzle size [mm] | 0,4     |
| Drying conditions [C/h]      | 50/4    |

## PHYSICAL PARAMETERS OF THE MATERIAL

| PARAMETER                        | VALUE | UNIT  | TEST METHOD |
|----------------------------------|-------|-------|-------------|
| <b>Density</b>                   | 1,24  | g/cm3 | -           |
| <b>Tensile modulus</b>           | 3495  | MPa   | ASTM D882   |
| <b>Tensile strength at break</b> | 53    | MPa   | ASTM D882   |
| <b>Tensile elongation</b>        | 6     | %     | ASTM D882   |
| <b>HDT</b>                       | 55    | stC   | ASTM E2092  |

The values above have been measured using standard test specimens made of non-colored material at room temperature. The figures should be considered as indicative values only. Actual properties of PLA Starter parts can be affected by the printing parameters, design of the model, ambient conditions, application of the printout etc. It is essential that users test our products to determine whether they are suitable for their intended use. ROSA PLAST Sp. z o.o. accepts no liability for any health detriment or material losses or any other losses related to the use of the material. Additional documents, certificates and detailed technical information can be provided on special request.

