

# PLA SILK

## MATERIAL PROPERTIES

Specific Gravity	1.22 g/cm <sup>3</sup>	D 792
MFR (210°C, 2.16kg)	6 g/10min	D 1238

## Mechanical Properties

Tensile Strength at Break	45 MPa	ISO 527
Tensile Strength at Yield	59 MPa	ISO 527
Tensile Modulus	2700 MPa	ISO 527
Elongation at Break	10,00%	ISO 527
Elongation at Yield	5,00%	ISO 527
Notched Izod Impact Strength	6 J/m	D 256
Flexural Strength	72 MPa	D790

## Thermal Properties

Heat Distortion Temperature	50°C	ISO 75
Glass Transition Temperature	57°C	DSC

## GUIDELINE FOR PRINT SETTINGS\*

Nozzle temperature	210-240°C
Bed temperature	40-60°C
Active cooling fan	YES (up to 100%)
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	40-110 mm/s
Closed chamber	not necessary
Dry box	not necessary
Ruby or hardened nozzle	not necessary

\* settings are based on a 0,4 mm nozzle.

\*\* depending on the geometrical complexity

## DESCRIPTION

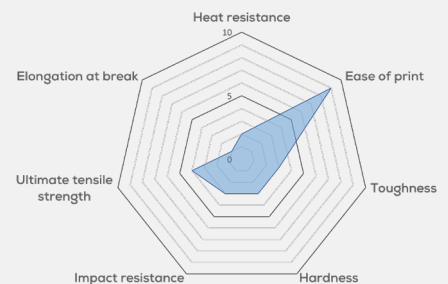
Spectrum PLA SILK filament is a PLA-based material for additive manufacturing with colour concentrates which imparts the satin texture effect to printed items. The silky surface texture of printed items largely reduces the visibility of layers on the side surface of printed items.

## FEAUTURES

- unique aesthetic properties
- reduced visibility of layers on the side surfaces of printed items
- silky shine on the entire surface of printed items
- maintenance of all the mechanical strength parameters of the standard PLA
- user friendly

## STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.



## SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at [support@spectrumfilaments.com](mailto:support@spectrumfilaments.com)