

Technical Data Sheet 2024

PLA Filament

Hi-speed PLA+Filament

PLA+Filament

PETG Filament

Hi-speed PETG Filament

ABS Filament

TPU Filament

Printing Setting

Model No.	Print Temperature (°C)	Bottom Plate Temperature (°C)	Printing Speed(mm/s)	Bottom Plate	Cooling Fan
ABS Filament	240-270	90-110	40-100	Glass/carbon fiber + solid glue or High temperature tape	100%
PLA Filament	200-230	45-60		50-450	
PLA+ Filament					
Hi-speed PLA+ Filament		75-90	50-100		
PETG Filament	50-100				
Hi-speed PETG Filament	220-260	50-500			
TPU Filament	200-230	45-60	20-60	Glass/carbon fiber + solid glue or High temperature tape	

Technical Specification

PLA Filament&Hi-speed PLA+ Filament&PLA+Filament&PETG Filament

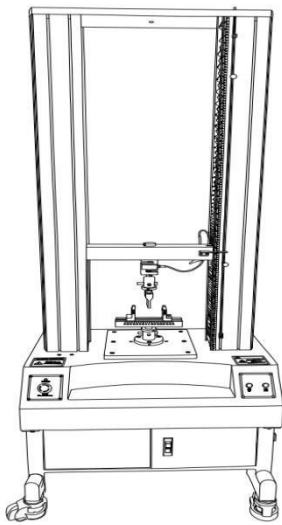
	PLA Filament	Hi-speed PLA+Filament	PLA+Filament	PETG Filament	Text Standard
Tensile strength (MPa):	72±10%	40.4±10%	62±10%	45.99±10%	ASTM D638
Elongation at break (%):	11.8±10%	19.59±10%	21.5±10%	10.71±10%	ASTM D638
Flexural strength (MPa):	90±10%	72±10%	76±10%	59±10%	ASTM D790
Flexural modulus (MPa):	1915±10%	2275±10%	1925 ±10%	1080±10%	ASTM D790
Notched Impact strength (J/m)	54±10%	183±10%	6±10% (KJ/m)	326±10%	ASTM D256
Shrinkage(%):	0.3-0.5	/	/	/	ASTM D2732
Heat deflection (HDT) at 0.455 MPa	53	54	54	64	ASTM D648
Density (g/cm³):	1.20-1.25	1.23-1.31	1.23-1.25	1.23-1.31	GB/T22235
Melt mass-flow rate (MFR) (g/10min):	3.5g/10min (190°C,2.16Kg)	10.68g/10min (190°C,2.16Kg)	5.5g/10min (190°C,2.16Kg)	9.72g/10min (230°C,2.16Kg)	ASTM D1238

ABS Filament&Hi-speed PETG Filament

	ABS Filament	TPU Filament	Hi-speed PETG Filament		Text Standard
Tensile strength (MPa):	41.59±10%	21.59±10%	59.04±10%		ASTM D638
Elongation at break (%):	15.83±10%	≥ 600%	15.97±10%		ASTM D638
Flexural strength (MPa):	53.86±10%	/	70.84±10%		ASTM D790
Flexural modulus (MPa):	2192.50±10%	/	2038.70±10%		ASTM D790
Notched Impact strength (J/m)	73.37±10%	/	19.7±10%		ASTM D256
Shrinkage(%):	/	/	/		ASTM D2732
Heat deflection (HDT) at 0.455 MPa	79	/	69		ASTM D648
Density (g/cm ³):	1.04~1.12	1.1-1.25	1.23~1.31		GB/T22235
Melt mass-flow rate (MFR) (g/10min):	25g/10min (220°C,10kg)	8.4g/10min (190°C,2.16kg)	24g/10min (230°C,2.16Kg)		ASTM D1238

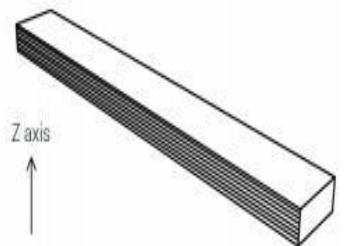
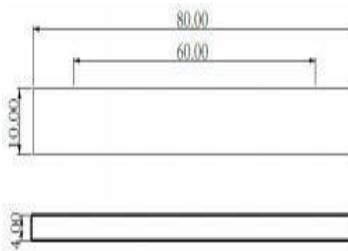
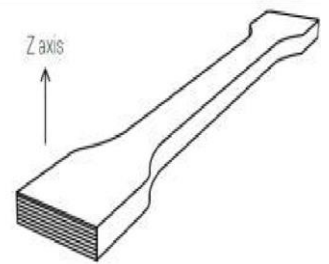
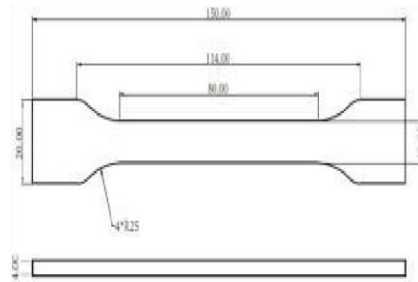
Introduction of Testing Machine

Computer-controlled Servo Tensile Testing Machine



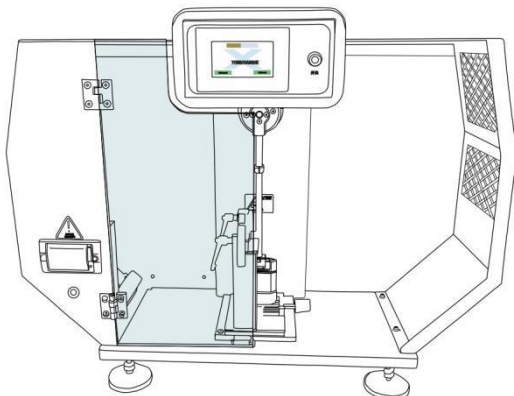
specimen ASTM D638

Tensile testing

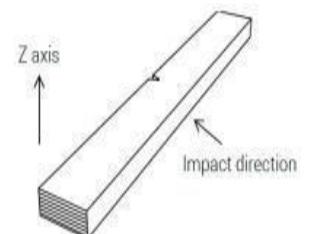
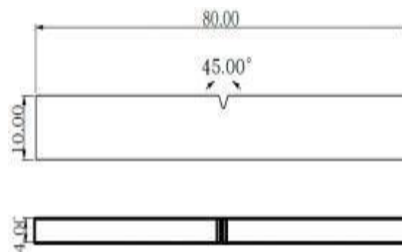


Flexural testing specimen ASTM D790

Digital IZOD Impact Tester



Impact testing specimen ASTM D256



Storage

1. The products shall be stored in a clean, cool, dry, ventilated, dark warehouse, free of chemicals, toxic and harmful substances and corrosive substances.
2. Keep away from the heat source.
3. It is strictly prohibited to stack the products in the open air, and the products are not allowed to be directly pressed.
4. Shelf life is 1 year and should be used as soon as possible after opening.

-----27th Mar, 2024 -----