

## TECHNICAL DATE SHEET

ALFAPLUS

BASE MATERIAL: Polylactic acid

### PROPERTIES

| PROPERTIES            | VALUE                       | ABS                    | PLA         | PET-G   |  |
|-----------------------|-----------------------------|------------------------|-------------|---------|--|
| PHYSICAL & MECHANICAL | Density                     | 1,24 g/cm <sup>3</sup> | ISO 1183    |         |  |
|                       | CHARPY (test 80x10x4 mm)    | 25 kJ/m <sup>2</sup>   | ISO 179-1eU |         |  |
|                       | Elongation at break:        | - Untreated            | 4,10%       | ISO 527 |  |
|                       |                             | - Annealed             | 2,35%       | ISO 527 |  |
|                       | Tensile strength at break:  | - Untreated            | 43 Mpa      | ISO 527 |  |
|                       |                             | - Annealed             | 51 Mpa      | ISO 527 |  |
|                       |                             | Flexure Modulus:       | 3070 Mpa    | ISO 527 |  |
|                       | - Annealed                  | 4100 Mpa               | ISO 527     |         |  |
| THERMAL               | Heat Deflection Temperature | - Untreated            | 58 °C       | ISO 75  |  |
|                       |                             | - Annealed             | 110 °C      | ISO 75  |  |

### SUGGESTED PRINTER SETTING

|                       | VALUE             | UNIT  |
|-----------------------|-------------------|---|
| Extruder Temperature  | 190 - 210         | °C  |
| Print Speed           | 40 - 120          | mm/s  |
| Bed Material          | 0 - 50            | °C  |
| Annealing Temperature | 100 °C for 2-4 hr | with any support material (suggested in sand) |

### PRODUCT DETAILS & CERTIFICATION

|          |                    |  |
|----------|--------------------|--|
| Diameter | 1,75 mm<br>2,85 mm | Tolerance ± 0,05mm<br>Tolerance ± 0,10mm |
|----------|--------------------|--|

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