

TECHNICAL DATE SHEET

ALFAPRO

BASE MATERIAL: Polylactic acid

PROPERTIES

PROPERTIES	VALUE	ABS	PLA	PET-G
PHYSICAL & MECHANICAL	Density	1,24 g/cm ³	ISO 1183	
	CHARPY (test 80x10x4 mm)	14 kJ/m ²	ISO 179-1eU	
	Elongation at break: - Untreated	2,90%	ISO 527	
	- Annealed	ND	ISO 527	
	Tensile strength at break:			
	- Untreated	30 Mpa	ISO 527	
	- Annealed	ND	ISO 527	
	Flexure Modulus: - Untreated	2750 Mpa	ISO 527	
- Annealed	ND	ISO 527		
THERMAL	Heat Deflection Temperature			
	- Untreated	58 °C	ISO 75	
	- Annealed	116 °C	ISO 75	

SUGGESTED PRINTER SETTING

	VALUE	UNIT
Extruder Temperature	200 - 220	°C
Print Speed	40 - 120	mm/s
Bed Material	0 - 50	°C
Annealing Temperature	100 °C for 2-4 hr	suggested in sand and/or with support

PRODUCT DETAILS & CERTIFICATION

Diameter	1,75 mm 2,85 mm	Tolerance ± 0,05mm Tolerance ± 0,10mm

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