Technical Data Sheet

PLA GLITTER

PLA GLITTER is a highly aesthetical PLA based filament with sparkling flakes inside. Slightly modified, the filament retains the typical features of PLA, but is tougher and less brittle. Polylactic acid is one of the most popular materials for 3D printing. Because of the translucency of PLA combined with the flakes, the colour saturation can be increased by increasing wall thickness.

Material features

- Beautiful sparkling effect
- Layers are not visible
- Tougher and less brittle compared to regular PLA
- Easy to print
- Low warping
- Limited smell
- Not abrasive

Additional information

Due to its low tendency to warp PLA GLITTER can also be printed without a heated bed. If you have a heated bed the recommended temperature is ± 35-60°C. PLA GLITTER can be used on all common desktop FDM or FFF technology 3D printers. It is recommended to purge the nozzle after printing, to prevent build up of flakes for the next print. Storage: Cool and dry (15-25°C) and away from UV light. This enhances the shelf life significantly.

Filament specs		
Size	**Ø Tolerance**	**Roundness**
1,75 mm	± 0,05 mm	≥ 95%
2,85 mm	± 0,10 mm	≥ 95%

Material properties		
Description	**Testmethod**	**Typical value**
Specific gravity	ISO 1183	1,24 g/cc
MFR 210°C/2,16 kg	ISO 1133	9,56 gr/10 min
Tensile Strength at Yield (MPa)	ISO 527	70 MPa
Strain at yield	ISO 527	5%
Strain at break	ISO 527	20%
E-Modulus	ISO 527	3120 MPa
Impact strength – Charpy method 23°C	ISO 179	3,4 kJ/m2
Moisture absorption	ISO 62	1968 ppm
Printing temperature	DF	215±10°C
Melting temperature	ISO 11357	115±35°C
Vicat softening temperature	ISO 306	60°C
Glass transition temperature	ISO 11357	57°C

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