

**PRODUCT NAME:** 3D FILAMENT R-PLA 1,75mm

**PRODUCT DESCRIPTION:** R-PLA filament - poly(lactic acid) in the form of a thread, designed for 3D printing using the FFF/FDM method. Filament coiled on spools, vacuum-packed with desiccant in a PA/PE bag, and then in a box.

**STORAGE:** Store in dry area. Store in a closed container.

## PRODUCT PARAMETERS

Parameter	Value
Filament diameter [mm]	1,75
Diameter tolerance [mm]	+/- 0,05
Oval tolerance [mm]	+/- 0,02

Net weight [g]	1000	3000
Weight with packaging [g]	1400	4000
Spool weight [g]	205	710
Spool dimensions [mm] ( $\varnothing$ / height / hole $\varnothing$ )	200/70/52	300/100/52
Box dimensions [mm]	220/210/75	325/310/110

## RECOMMENDED PRINTING PARAMETERS

Parameter	Value
Print temperature [°C]	200-230
Bed temperature [°C]	40-60
Cooling [%]	50-100
<b>Closed chamber</b>	Not necessary
Drying conditions: [°C/h]	50/4

## PHYSICAL PARAMETERS OF THE MATERIAL

Parameter	Value	Unit	Test method
Density	1,24	g/cm <sup>3</sup>	-
Tensile strength at break	55	MPa	ASTM D882
Elongation at break	8	%	ASTM D882
HDT A	55	°C	ASTM E2092
Food Contact Approval	No	-	-

The values above have been measured using standard test specimens made of non-colored material at room temperature. The figures should be considered as indicative values only. Actual properties of R-PLA parts can be affected by the printing parameters, design of the model, ambient conditions, application of the printout etc. It is essential that users test our products to determine whether they are suitable for their intended use. ROSA PLAST Sp. z o.o. accepts no liability for any health detriment or material losses or any other losses related to the use of the material.

