DATA SHEET

PLA HT110 3D Filament

Based on biodegradable polymer compound derived from organic sources. It is the most common used 3D filament in FFF (FDM) printers. Odourless, biodegradable, good tensile strenght. Withstand temperatures up to 110°C (*VST) without annealing. Best PLA for hobby application and prototyping.

Material properties

Description	Method	Typical value
Density	ISO 1183	1,35 g/cm³
Melt Flow Index	ISO 1133 (190°C/2.16 kg)	4,7 g/10 min.
Softening temperature (VST) *	ISO 306	110°C
Melting temperature	ISO 3146-C	166°C
Tensile strenght	ISO 527	49 MPa
Tensile modulus	ISO 527	3300 Mpa
Tensile stress at break	ISO 527	20 MPa
Charpy notched impact, 23°C	ISO 179-1eA	≤ 5 kJ/m²

Printing properties	
Hotend temperature	210 -250°C
Heatbed temperature	40 - 60°C
Cooling print object	yes
Nozzle diameter	commonly used
Printing environment	open space or inside of box
Bed surface	commonly used (glassbed, PEI, steel etc..)
Bed adhesive	glue stick, 3Dlac
Drying material	2 -4 hours at 60°C

Type of spool		Weight of empty spool
750 gr	transparent	230gr
1 kg	transparent	250gr
1 kg	black	220gr
2,5kg	black	500gr

* VST = Vicat softening temperature.
The 3D printed object retains its shape up to a temperature of 110C.
Three or more perimeters are recommended.

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