



PLA+ Property Table

Product Description: The raw material of PLA+ is obtained by blending and modifying PLA raw material with additives, mainly used in the field of 3D printing.

Material Diameter: 1.75mm、2.85mm、3.0mm

PLA+ Characteristics:

High rigidity and good fluidity;

Excellent heat resistance and short printing cycle;

Excellent hydrolysis resistance and product stability;

Ultra high toughness.

Property	Unit	Testing Standards	Typical Value
Density	g/cm ³	ASTM D-792	1.2-1.3
Melting Index (190°C,2160g)	g/10min	ASTM D-1238	4-8
Melting Point	°C	DSC	185-190
Vicat softening point A/120	°C	ASTM D-648	55
Tensile Strength	MPa	ASTM D-638	85
Break Elongation %	Break	ASTM D-638	4.0
Bending Strength	MPa	ASTM D-790	85
Impact Strength	kJ/M ²	ASTM D-256	55
Water Absorption Rate	%	ASTM D-570	<0.6
Printing Temperature	°C	DSC	200-220

* The above data are typical values and should not be interpreted as technical indicators for determining quality.

Storage: The temperature should not exceed 50°C during transportation and storage. This storage warehouse should be dry and well ventilated. Pay attention to moisture prevention

Drying: It is recommended to pre dry in the R3D Dryer D1 or other drying machines for 4-6 hours before printing at a drying temperature of 45 ° C.

Before printing, it is recommended to dry in advance for easy printing. Filament should be kept sealed before using, and unused filament should be promptly sealed after use.

Suitable Equipment: PLA+ is usually used on high-speed 3D printers, and the key of good printing performance is appropriate printing temperature.

Cleaning Steps: PLA+ is incompatible with certain petroleum base printing materials. If the machine has printed traditional petroleum base resin, it needs to be cleaned before using. To clean the extruder, please follow cleaning steps below:

1. Heat the extruder to 230-260 ° C;
2. Clean the extruder with dedicated cleaning filament, extruding and threading at the same time;

Printing Temperature: Hot bed temperature is around 40-60° C, and extruder temperature is around 200-220° C.