



Technical Data Sheet

Product name: HS PLA PRO

Version: 1.0

Date: 09.2024

Dimensions

Description	Typical value	Test method
1,75 mm	± 0.02 mm	± 0.02 mm
2,85 mm	± 0,10 mm	± 0,10 mm

MATERIAL PROPERTIES

Description	Typical value	Test method
Density	1.25 g/cm ³	ISO 1183,GB/T 1033
Meltindex (MFR)	6.8 g/10min (190 °C/2.16kg)	ISO 1133,GB/T 3682
Melting temperature	160°C	DSC,10°C/min
Vicatsofteningtemperature	58.9°C	ISO306,GB/T1633
Heat deflection temperature	52.6 °C	ISO 75 0.45MPa
Tensile strength at Yield	60 MPa	ISO 527, GB/T 1040
Elongation at Break	7.5%	ISO 527, GB/T 1040
Flexural Modulus	3235 MPa	ISO 527, GB/T 9341



Flexural strength	88 MPa	ISO 178, GB/T 9341
Impact strength	6.4 kJ/m ²	ISO 179, GB/T 1043
Layer Adhesion (Impact Strength - Z)	4.0 kJ/m ²	ISO 179, GB/T 1043
Moisture absorption	0.25%	ISO 62 23°C , 50% RH

GUIDELINE FOR PRINT SETTINGS

Description	Typical value
Printing temperature	205-230°C
Build Plate Compatibility	BuildTak®, Glass, BlueTape, PEI
Bed Temperature	55-65°C (Glue Recommended)
Cooling fan	50-100%
Drying Settings	47-50°C , 4-6 h
Printing speed	<500 mm/s
AMS Compatibility	YES
Raftseparationdistance	0.5-1.5mm
Retractionspeed	40-60mm/s
Hotend Compatibility	0.2-0.8mm nozzle.
Environmentaltemperature	25°C-45°C



Packaging:

All spools are sealed and packed with silica gel to avoid humidity.

Additional info:

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End- use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

Each user is responsible for determining the safety, lawfulness, technical suitability, and disposal/ recycling practices of R3D materials for the intended application. R3D makes no warranty of any kind, unless announced separately, to the fitness for any use or application. R3D shall not be made liable for any damage, injury or loss induced from the use of R3D materials in any application.

Storage: Cool and dry (15-25°C) and away from UV light. This enhances the shelf life significantly.