



Technical Data Sheet

Product name: PLA Silk

Version: 1.0

Date: 07.2024

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	1.29 g/cm ³	ISO 1183,GB/T 1033
Meltindex (MFR)	13.8 g/10min (190 °C/2.16kg)	ISO 1133,GB/T 3682
Melting temperature	176 °C	DSC,10°C/min
Vicatsoftening temperature	60.8 °C	ISO306,GB/T1633
Heat deflection temperature	55.3 °C	ISO 75 0.45MPa
Tensile strength at Yield	43 MPa	ISO 527, GB/T 1040
Elongation at Break	6.2%	ISO 527, GB/T 1040



Flexural Modulus	2700 MPa	ISO 527, GB/T 9341
Flexural strength	83 MPa	ISO 178, GB/T 9341
Impact strength	4.2 kJ/m ²	ISO 179, GB/T 1043
Layer Adhesion (Impact Strength - Z)	2.6 kJ/m ²	ISO 179, GB/T 1043
Moisture absorption	0.5%	ISO 62 23°C , 50% RH

GUIDELINE FOR PRINT SETTINGS

Description	Typical value
Printing temperature	220-240°C
Build Plate Compatibility	BuildTak®,Glass,BlueTape,PEI
Bed Temperature	55-65°C (Glue Recommended)
Cooling fan	60-100%
Drying Settings	47-50°C , 4-6 h
Printing speed	<300 mm/s
AMS Compatibility	YES
Raftseparationdistance	0.5-1.5mm
Retractionspeed	40-60mm/s
Hotend Compatibility	0.4-0.8mm nozzle.
Environmenttemperature	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.

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