



Filament Data Sheet

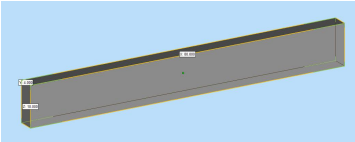
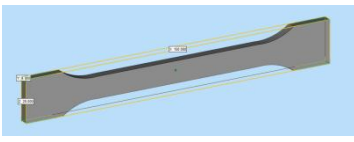
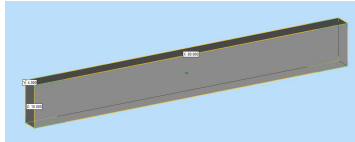
PLA-E

Revision Date:25/12/2025

Application: FDM

Version: 01

RECOMMENDED PRINTING CONDITIONS	
Nozzle Temperature	220-250°C
Bed Temperature	20-60°C
Closure Chamber	Recommended open printing
Drying Setting	55°C for 6H

FLEXURAL TESTING SPECIMEN	TENSILE TESTING SPECIMEN	IMPACT TESTING SPECIMEN
ISO 178/T 9341	ISO 527,GB/T 1040	ISO 180,GB/T1043
		

PHYSICAL PROPERTIES				
Performance	Condition	Standards	Unit	Values
Density	25°C	ISO 1183	g/cm ³	1.510
Melt Flow Rate	220°C/2.16kg	ISO 1133	g/10min	18.23

MECHANICAL PROPERTIES				
Performance	Condition	Standards	Unit	Values
TensileStrength (X-Y)	10*4mm sample	ISO 527-2	MPa	32.08
TensileStrength (Z)	10*4mm sample	ISO 527-2	MPa	14.82
Elongation at break (X-Y)	10*4mm sample	ISO 527-2	%	17.35
Elongation at break (Z)	10*4mm sample	ISO 527-2	%	3.75
Bending modulus(X-Y)	10*4mm sample	ISO178	MPa	1999.76
Bending modulus(Z)	10*4mm sample	ISO178	MPa	585.79
Bending strength (X-Y)	10*4mm sample	ISO178	MPa	48.89
Bending strength (Z)	10*4mm sample	ISO178	MPa	20.08
Notched impact strength (X-Y)	10*4mm sample notched	ISO180	KJ/m ²	11.47
Notched impact strength (Z)	10*4mm sample notched	ISO180	KJ/m ²	2.11
Non-notched impact strength (X-Y)	10*4mm sample non notched	ISO180	KJ/m ²	132.92
Non-notched impact strength (Z)	10*4mm sample non notched	ISO180	KJ/m ²	6.23

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