

PLA Stone Age

MATERIAL PROPERTIES

Specific Gravity	1.24 g/cm ³	D 792
MFR (210°C, 2.16kg)	6 g/10min	D 1238

Mechanical Properties

Tensile Strength at Break	53 MPa	D 882
Tensile Strength at Yield	60 MPa	D 882
Tensile Modulus	3.5 GPa	D 882
Tensile Elongation	6,00%	D 882
Notched Izod Impact	16 J/m	D 256
Flexural Strength	83 MPa	D790
Flexural Modulus	3.8 MPa	D790

Thermal Properties

Heat Distortion Temperature	55°C	E 2092
Glass Transition Temperature	55-60°C	D3418

GUIDELINE FOR PRINT SETTINGS*

Nozzle temperature	185-225°C
Bed temperature	0-45°C
Active cooling fan	YES (up to 100%)
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	40-80 mm/s
Closed chamber	not necessary
Dry box	not necessary
Ruby or hardened nozzle	not necessary
Recommended nozzle	≥ 0.4 mm

* settings are based on a 0,4 mm nozzle.

** depending on the geometrical complexity

DESCRIPTION

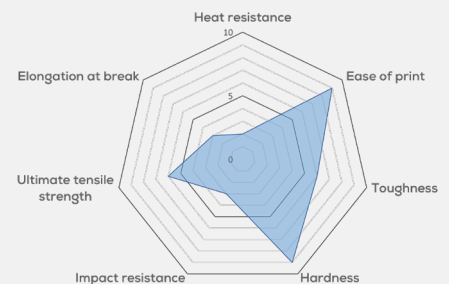
Spectrum PLA Stone Age filament is a series of PLA-based material with admixtures to obtain an imitation of "stony" structure of printed items. The Stone type filament, manufactured in two shades: Stone Age Light and Stone Age Dark, demonstrates excellent masking of layers, while printed items feel rough resembling real stone.

FEAUTES

- beautiful, aesthetic imitation of stone
- rough surface
- high durability
- shrinkage-free printing
- layer masking
- not abrasive

STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.



SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at support@spectrumfilaments.com