

HiTerra® Brewed PLA 2465 3DP

Techmer Polymer Modifiers - *Poly(lactic Acid)*

Product Description

HiTerra® Brewed PLA 2465 3DP is a specially formulated, brown colored, and compounded thermoplastic material designed for general purpose additive manufacturing applications. This product has been optimized for maximum printability in additive manufacturing.

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Organic
Features	• Renewable Resource Content
Uses	• Additive Manufacturing (3D Printing)

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	5000	psi	ASTM D638
Tensile Elongation (Break)	15	%	ASTM D638
Flexural Modulus	450000	psi	ASTM D790
Flexural Strength	7000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.50	ft-lb/in	ASTM D256
Additional Information	Nominal Value	Unit	Test Method
Recommended Print Bed	Garolite sheet or heated aluminum bed		
Recommended Print Bed Temperature	175 to 190	°F	

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	1.0 to 5.0	hr
Cylinder Zone 1 Temp.	270 to 300	°F
Cylinder Zone 2 Temp.	290 to 320	°F
Cylinder Zone 3 Temp.	320 to 360	°F
Cylinder Zone 4 Temp.	320 to 360	°F
Melt Temperature	175 to 190	°F
Die Temperature	330 to 370	°F

Extrusion Notes

If drying for longer than 5 hours, recommend reducing the temperature to 100°F in a dessiccant dryer to avoid degradaton of the material.

