

HiTerra® White Oak PLA 2467 3DP

Techmer Polymer Modifiers - *Polylactic Acid*

Product Description

HiTerra® White Oak PLA 2467 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	• Natural Fiber
Features	• Renewable Resource Content
Uses	• Additive Manufacturing (3D Printing)
Appearance	• Brown
Processing Method	• 3D Printing

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.00		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	600000	psi	ASTM D638
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	650000	psi	ASTM D790
Flexural Strength	12500	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	aluminum bed with cement glue, glass epoxy laminate board		
Recommended Print Bed Temperature	104 to 140	°F	

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	1.0 to 5.0	hr
Cylinder Zone 1 Temp.	320 to 350	°F
Cylinder Zone 2 Temp.	340 to 360	°F
Cylinder Zone 3 Temp.	340 to 360	°F
Cylinder Zone 4 Temp.	340 to 380	°F
Melt Temperature	330 to 380	°F
Die Temperature	340 to 380	°F

Extrusion Notes

If drying for longer than 5 hours, recommend reducing the drying temperature to 110°F in a desiccant dryer to avoid degradation of the material.

