

HiFill® PLA 1816 3DP

 Techmer Polymer Modifiers - *Polylactic Acid*
General Information
Product Description

PLAM114869

General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Features	<ul style="list-style-type: none"> Biodegradable
Appearance	<ul style="list-style-type: none"> Natural Color
Forms	<ul style="list-style-type: none"> Pellets
Processing Method	<ul style="list-style-type: none"> 3D Printing, Fused Filament Fabrication (FFF)

Properties ¹

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	820000	psi	ASTM D638
Tensile Strength (Yield)	8100	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	770000	psi	ASTM D790
Flexural Strength	13500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	0.50	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	160	°F
Drying Time	4.0 to 5.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	320 to 350	°F
Middle Temperature	340 to 360	°F
Front Temperature	340 to 360	°F
Nozzle Temperature	320 to 380	°F
Processing (Melt) Temp	320 to 380	°F

Notes
¹ Typical properties: these are not to be construed as specifications.
