

FIL-A-GEHR PLA®

Filaments for professional 3D printing

Technical Data

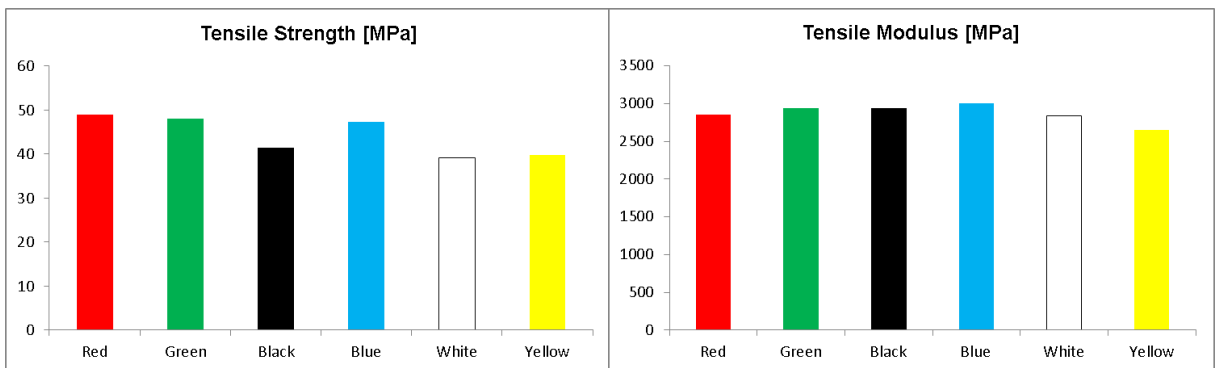
Melt Volume Rate 190 °C/2,16 kg	2,35 cm ³ / 10 min
Tensile Stress at Yield ISO 527	70,4 MPa
Tensile Modulus ISO 527	3380 MPa
Density ISO 21183	1240 kg / m ³
Melting Point ISO 294	152 °C



Printing Recommendations

Optimal Nozzle Temperature	223 °C
Bed Temperature	65 °C

Tensile Test ISO 527, Interlayer Adhesion



Tensile Stress at Yield FIL-A-GEHR PLA® per Color

Tensile Modulus FIL-A-GEHR PLA® per Color

To determine the FIL-A-GEHR PLA® data, ISO 527 tensile test specimen were printed vertically with the following parameters: Infill 20%, T_{Print} 223 °C, T_{Bed} 65 °C, Layer Thickness 0,2 mm, Outlines 3, Nozzle Diameter 0,5 mm, Wall thickness 1,5 mm, Infill rectilinear, Printing Speed 50 mm/s, Multiplier 100, Slicer Simplify3D