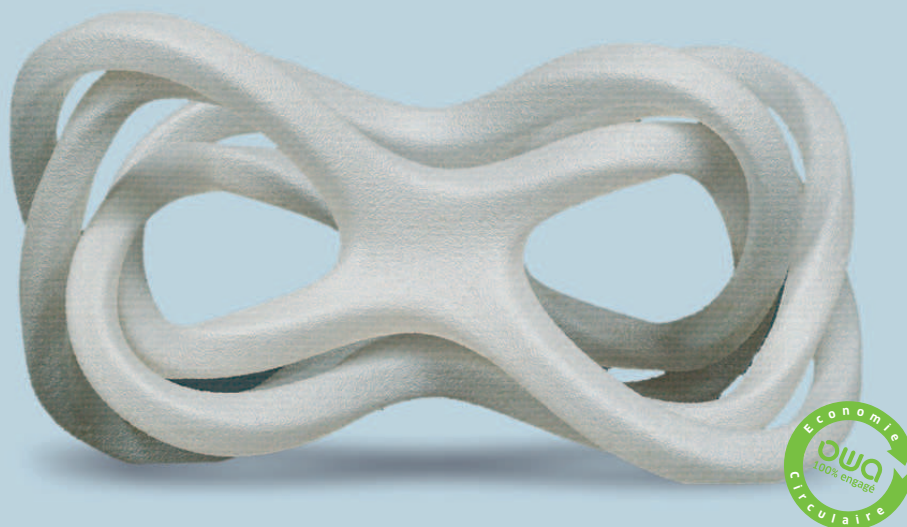




PLA-R



PLA-R is a recycled filament for prototypes, design printings. PLA-R Natural is biodegradable eligible.

| **EASY TO PRINT** | **SHINY APPEARANCE**
| **≥ 97 % RECYCLED MATERIAL** | **NO ODOR**

FILAMENT PROPERTIES

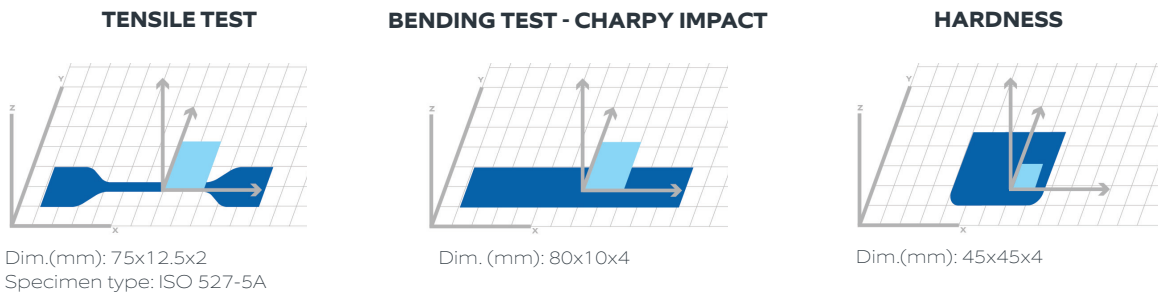
DESCRIPTION	TEST METHODS	UNITS	VALUES
Diameter	INS-6712	mm	1.75 ± 0.1 2.85 ± 0.1
Density	ISO 1183	g/cm3	1.24
Humidity rate	INS-6711	%	< 1
MFI (@210°C – 2,16 kg)	ISO 1133	g/10min	9 - 12
Glass temperature tg	ISO 11357 DSC (10°C/min – 20 à 220°C)	°C	61



PRINT PARAMETERS AND SPECIMENS DIMENSIONS

PRINT AXIS	XY
PRINT SPEED	50 mm/s
INFILL	100% - rectilinear
INFILL ANGLE	45°/-45°
EXTRUSION TEMPERATURE	200°C
PLATFORM TEMPERATURE	60°C

RESULTS



PRINTED SPECIMENS PROPERTIES

	PROPERTIES	TEST METHODS	UNITS	VALUES
TENSILE	Tensile modulus	ISO 527	MPa	2,963
	Tensile strength	ISO 527	MPa	57.9
	Elongation @tensile strength	ISO 527	%	2.2
	Tensile stress @break	ISO 527	MPa	47.3
	Tensile elongation @break	ISO 527	%	4.0
BENDING	Flexural modulus	ISO 178	MPa	2,675
	Flexural stress @3.5%	ISO 178	MPa	88.8
	Flexural strength	ISO 178	MPa	91.6
	Deformation @flexural strength	ISO 178	%	4.3
CHARPY IMPACT	Charpy impact strength (notched type A)	ISO 179	kJ/m2	3.22
HARDNESS	Hardness	ISO 868	Shore D	79.1

CERTIFICATION

% RECYCLED	≥ 97 % Recycled
% RECYCLED (FOR PLA-R NATURAL ONLY)	100 % Recycled
BIODEGRADABILITY (FOR PLA-R NATURAL ONLY)	NF EN 13432 & NF EN14995 (for a thickness of 1mm)

The results presented are the averaged values of the PLA-R 1.75mm range.
For each test, 5 specimens per reference, previously placed at least 24 hours in climatic chamber (23°C - hygrométrie : 50%) have been tested.

