TECHNICAL DATA SHEET

PLA Silk

/Acrylonitrile Butadiene Styrene/

Kings 3D Printing

RoHS COMPLIANT

- High Impact Resistance
- High Light Transmission
- Good Toughness
- Good Fluidity

Material Overview

This material is derived from a modified form of PLA and retains its user-friendly printing properties. It features a sleek surface with a soft, silky shine and no visible layer marks. Supports can be detached from the model with ease, leaving the contact area just as even and smooth as before. Additionally, it is available in a wide variety of colors.

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Kings 3D Printing

Filament Diameter	1.75mm/2.85mm/ 3.50mm
Net Weight	1KG \ Inner Box Dimension: 206*71*208mm \ G.W.: 1.35KG
Package	1KG*10PCs \ Outer Carton Dimension: 382*226*433mm \ G.W.: 14KG/CTN

Printing Tips

- Best printing temperature ranges from 190℃ to 230℃
- Best phototype can be achieved through 50℃ drying for 2-4 hours
- Print Temp: 205-215℃ 50-100mm/s;
- Print Temp: 215-235℃ 100-200mm/s
- Platform Temp.: Glue required if not heated, glue unrequired if heated 50-60℃
- Bubble: no bubble

Colors

Standardized pantone colors are available, please check in our catalogue

Data Table

Physical Properties	Standard Value	Test Method
Density	1.24-1.30g /cm^3	ASTM D792
MFR (190℃, 2.16KG)	5-7g / 10 minutes	ASTM D1238
Water absorption (saturation, 23℃)	0.3%	ASTM D570

Mechanical Properties	Standard Value	Test Method
Tensile strength	≥50 MPa	ASTM D638
Flexural strength	≥50 MPa	ASTM D638
Tensile modulus	≥3300 MPa	ASTM D638
Notch impact strength (IZOD, 23℃)	≥3KJ/m^2	ISO 180
Elongation at break	≥3.0%	ASTM D638

Accuracy	Standard Value	Test Method
Filament diameter	1.75mm/2.85mm/ 3.50mm	Q/WT 001-2014
Roundness deviation	≤0.02mm	Q/WT 001-2014

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