

**PRODUCT NAME:** 3D FILAMENT PLA Plus ProSpeed 1,75mm

**PRODUCT DESCRIPTION:** PLA Plus ProSpeed filament – blend of thermoplastic polymers based on polylactic acid in the form of a thread, designed for 3D printing using the FFF/FDM method. Filament coiled on spools, vacuum-packed with desiccant in a PET/PE bag, and then in a box.

**STORAGE** Store in dry area. Store in a closed container.

## PRODUCT PARAMETERS

Parameter	Value
Filament diameter [mm]	1,75
Diameter tolerance [mm]	+/- 0,05
Oval tolerance [mm]	+/- 0,02
Net weight [g]	500
Weight with packaging [g]	900
Spool weight [g]	245
Small spool dimensions [mm] ( ø / height / hole ø )	200/55/52
Box dimensions [mm]	218/209/62

## RECOMMENDED PRINTING PARAMETERS

Parameter	Value
Print temperature [°C]	190-230
Bed temperature [°C]	50-70

## PHYSICAL PARAMETERS OF THE MATERIAL

Parameter	Value	Unit	Test method
Density	1,22	g/cm <sup>3</sup>	-
Tensile modulus XY axis	2863	MPa	ASTM D638
Tensile modulus YX axis	2444	MPa	ASTM D638
Tensile modulus ZX axis	2475	MPa	ASTM D638

**ROSA PLAST Sp. z o.o.**

ul. Hipolitowska 102, 05-074 Hipolitów

tel.: +48 22 783 62 62, [www.rosa3d.pl](http://www.rosa3d.pl)

Tensile strength XY axis	39	MPa	ASTM D638
Tensile strength YX axis	31	MPa	ASTM D638
Tensile strength ZX axis	24	MPa	ASTM D638
Izod impact strength (notched) XY axis	160	J/m	ASTM D256 (amorphous)
Izod impact strength (notched) YX axis	21	J/m	ASTM D256 (amorphous)
Izod impact strength (notched) ZX axis	109	J/m	ASTM D256 (amorphous)
Izod impact strength (notched) XY axis	233	J/m	ASTM D256 (crystalline)
Izod impact strength (notched) YX axis	200	J/m	ASTM D256 (crystalline)
Izod impact strength (notched) ZX axis	64	J/m	ASTM D256 (crystalline)
HDT	75-85	°C	ASTM E2092
Food Contact Approval	YES	-	-

All tested samples were printed at 100% infill and annealed at 110°C for 20 minutes.

The values above have been measured using standard test specimens made of non-colored material at room temperature. The figures should be considered as indicative values only. Actual properties of PLA Plus ProSpeed parts can be affected by the printing parameters, design of the model, ambient conditions, application of the printout etc. It is essential that users test our products to determine whether they are suitable for their intended use. ROSA PLAST Sp. z o.o. accepts no liability for any health detriment or material losses or any other losses related to the use of the material.



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