

PLA Tough

Tough PLA filament has been specially formulated to provide impact resistance akin to ABS whilst retaining the printability of PLA.

PLA Tough has superior Charpy Impact (Kj/m²) - a high strain-rate test as per ISO 179 - versus other strong PLA / PLA+ / PLA filaments on the market.

PLA Tough exhibits excellent results in layer adhesion and the benefits of strength and durability makes it highly-suited manufacturing aids or even end-use parts where impact resistance is needed beyond a regular PLA.

Material features:

- High impact and stiffness
- Prints like regular PLA (easy to print)
- No warpage & no shrinkage
- Printable with various print temperatures
- Suitable for applications which needs to be strong
- Industrial touch and feel



Filament specs.

Size	Ø tolerance	Roundness
1,75mm	± 0.05mm	≥ 95%
2,85mm	± 0.10mm	≥ 95%

Material properties

Description	Testmethod	Typical value
Specific gravity	ISO 1183	1.21 g/cc
MFR 210°C/2,16 kg	ISO 1133	8.75 gr/10 min
Tensile strength at yield	ISO 527	46 MPa
Tensile strength at break	ISO 527	19 MPa
Elongation strain at yield	ISO 527	2%
Elongation strain at break	ISO 527	27%
Tensile (E) modulus	ISO 527	2750 MPa
Impact strength - charpy method 23°C	ISO 179	29.8 kJ/m ²
Vicat softening temperature B	ISO 306	57°C
Printing temp.	Internal Method	210±10°C

Additional info:

Recommended temperature for heated bed is ≥60°C. Adhesion is possible on different surfaces. TOUGH PLA can be used on all common desktop FDM or FFF technology 3D printers.

Storage: Cool and dry (15-25°C) and away from UV light. This enhances the shelf life significantly.

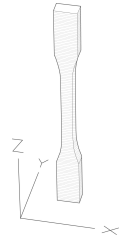
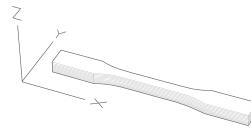
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Mechanical Specifications

During additional research, a print profile has been made which was optimized for achieving the best performance on printed parts. Table 1 shows the typical values of an injection moulded specimen compared to a 3D-printed specimen in both the X-Y axis (3D-printed horizontally) and the Z-axis (3D-printed vertically).

Table 1: Data of both injection moulded and 3D-printed specimens.*

	Injection Moulded	3D-Printed X-Y	3D-Printed Z
Young’s Modulus [MPa] ISO 527	2750	2450	2200
Stress at Yield [MPa] ISO 527	46	41	33
Stress at Break [MPa] ISO 527	19	32	33
Strain at Yield [%] ISO 527	2	2	2
Strain at Break [%] ISO 527	27	20	2,6
Charpy Impact (Kj/m2) ISO 179	29,8	22,9	2,2
Flexural Strength ISO 178	72	76	60
Flexural Modulus ISO 178	2750	2700	2250



PLA Tough has excellent impact properties at a broad range of temperatures.

Print Conditions

All specimens have been printed using a 0.4mm nozzle and the layer height was set to 0.2mm. The room in which the 3D-printer was located had an environmental temperature of ± 25°C.

*Test Conditions

The tensile tests have been carried out according to ISO-527 using modified 1BA specimens (3D-printing) and 1A specimens (injection moulding). The room in which the Universal Testing Machine was located had an environmental temperature of ± 20°C.

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