

Normal PLA Filament

Physical Properties

Property	Testing Method	Typical Value	Unit
Density	ISO 1183	1.26	g/cm ³
Glass transition temperature	DSC, 10C°/min	about 65	C°
Softening temperature of filament (for 1.75mm)	Custom method	about 58	C°
Melt index (g/10min)	210C°, 2.16kg	7-11	g/10min
Moisture content ¹	Thermogravimetric	≤0.1%	%
Odor	/	Almost odorless	/
Solubility	/	Insoluble in water; soluble in chloroform, toluene, and tetrahydrofuran(THF)	/

Note:

1. For newly opened filaments; filaments may absorb higher levels of moisture during use.

Mechanical Properties

Items	Testing Method	Typical Value	Unit
Tensile strength	ISO 527(5mm/min)	55-65	MPa
Elongation at break	ISO 527(6mm/min)	3-5	%
Bending modulus	ISO 178:2001	2100-2300	MPa
Bending strength	ISO 178:2002	65-76	MPa
Impact strength	ISO 180	13-17	KJ/m ²

