

## Ender-PLA Filament Technical Data Sheet

Version 1.0

### 1. Product introduction

Ender-PLA filaments are 3D printing filaments based on PLA. Good printing performance

### 2. Physical Performance Parameters

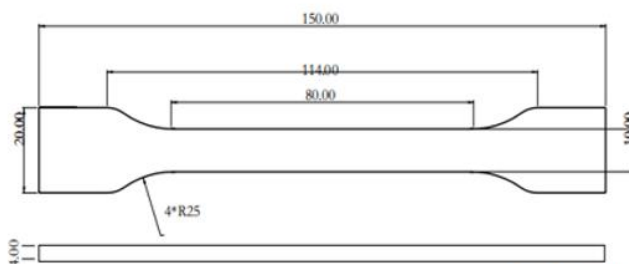
Items	Testing Criteria	Parameters
Density	ASTM D792 (ISO 1183, GB/T 1033)	1.25 ±0.1 (g/cm <sup>3</sup> at 21.5°C)
Glass transition temperature	DSC, 10 °C/min	60.5 (°C)
Vicat Softening temperature	ASTM D1525 (ISO 306 GB/T 1633)	62.5 ±0.4(°C)
Melt index	190°C, 2.16 kg	6-12 (g/10 min)

### 3. Mechanical Performance Parameters

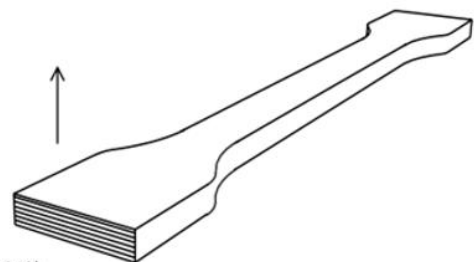
Items	Testing Criteria	Parameters
Tensile strength (X-Y)	ISO 527, GB/T 1040	34 (MPa)
Tensile strength (Z)	ISO 527, GB/T 1040	7.13(MPa)
Elongation at break (X-Y)	ISO 527, GB/T 1040	8(%)
Elongation at break (Z)	ISO 527, GB/T 1040	3.6(%)
Bending strength (X-Y)	ISO 178, GB/T 9341	77 (MPa)
Charpy impact strength (X-Y)	ISO 179, GB/T 1043	7(J/m <sup>2</sup> )
Charpy impact strength (Z)	ISO 179, GB/T 1043	5(kJ/m <sup>2</sup> )

Printing parameters and styles of printing conditions:

Print Conditions	Parameters
Nozzle Temperature	200°C
Hot Bed Temperature	50°C
Printing Speed	60mm/s
Infill	100%



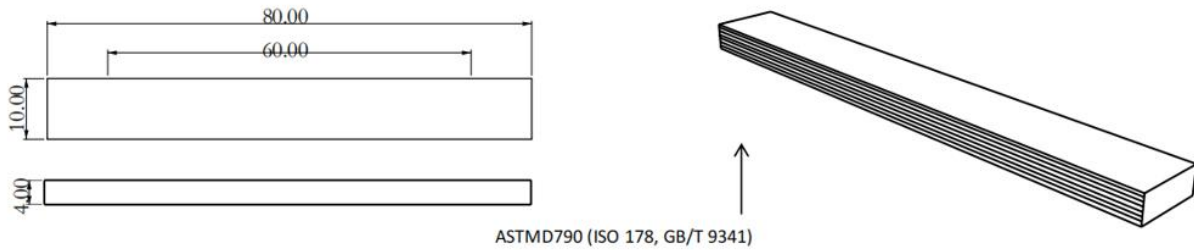
ASTM D638 (ISO 527, GB/T 1040)



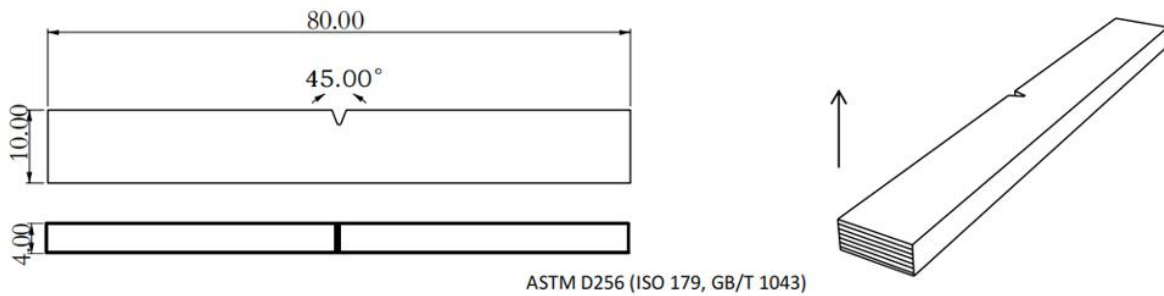
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**\*2\***



**\*3\***

### 4. Recommended printing conditions

Print Temperature	Hotbed Temperature	Ambient Temperature	Print Speed	Pumping Distance
190-230°C	Non-heating/60°C	0-50°C	40-100mm/s	3-8mm

### 5. Compatible Models

Ender-PLA widely used in FDM 3D printers on the market.

### 6. Storage Condition

Please place this product in a dry and ventilated environment, not in an environment of high temperature, sunny or humid conditions. If it is not used up within a short time after opening, it is recommended to use it with a dry box when using it again.

### 7. Disclaimer

The values given in this data sheet are for reference and comparison only. Actual values may vary with printing conditions, and the end-use performance of printed models depends on model design, environmental conditions, printing conditions, etc.