



# Filament Data Sheet

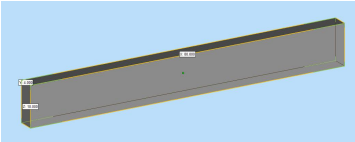
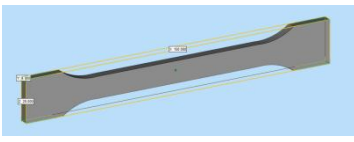
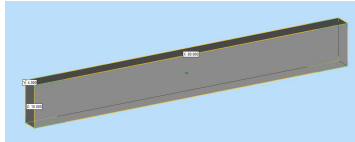
## PLA-SILK

Revision Date:22/01/2026

Application: FDM

Version: 01

RECOMMENDED PRINTING CONDITIONS	
Nozzle Temperature	220-260°C
Bed Temperature	20-60°C
Closure Chamber	Recommended open printing
Drying Setting	55°C for 6H

FLEXURAL TESTING SPECIMEN	TENSILE TESTING SPECIMEN	IMPACT TESTING SPECIMEN
ISO 178/T 9341	ISO 527,GB/T 1040	ISO 180,GB/T1043
		

PHYSICAL PROPERTIES				
Performance	Condition	Standards	Unit	Values
Density	25°C	ISO 1183	g/cm <sup>3</sup>	1.375
Melt Flow Rate	220°C/2.16kg	ISO 1133	g/10min	12.84

<b>MECHANICAL PROPERTIES</b>				
<b>Performance</b>	<b>Condition</b>	<b>Standards</b>	<b>Unit</b>	<b>Values</b>
<b>TensileStrength (X-Y)</b>	10*4mm sample	ISO 527-2	MPa	48.52
<b>TensileStrength (Z)</b>	10*4mm sample	ISO 527-2	MPa	12.67
<b>Elongation at break (X-Y)</b>	10*4mm sample	ISO 527-2	%	8.54
<b>Elongation at break (Z)</b>	10*4mm sample	ISO 527-2	%	1.93
<b>Bending modulus(X-Y)</b>	10*4mm sample	ISO178	MPa	2379.77
<b>Bending modulus(Z)</b>	10*4mm sample	ISO178	MPa	1670.94
<b>Bending strength (X-Y)</b>	10*4mm sample	ISO178	MPa	75.01
<b>Bending strength (Z)</b>	10*4mm sample	ISO178	MPa	20.20
<b>Notched impact strength (X-Y)</b>	10*4mm sample notched	ISO180	KJ/m <sup>2</sup>	6.07
<b>Notched impact strength (Z)</b>	10*4mm sample notched	ISO180	KJ/m <sup>2</sup>	2.05
<b>Non-notched impact strength (X-Y)</b>	10*4mm sample non notched	ISO180	KJ/m <sup>2</sup>	17.43
<b>Non-notched impact strength (Z)</b>	10*4mm sample non notched	ISO180	KJ/m <sup>2</sup>	4.58

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