

PLA GLITTER is a highly aesthetical PLA based filament with sparkling flakes inside. Slightly modified, the filament retains the typical features of PLA, but is tougher and less brittle. Polylactic acid is one of the most popular materials for 3D printing. Because of the translucency of PLA combined with the flakes, the colour saturation can be increased by increasing wall thickness.

Material features:

- Beautiful sparkling effect
- Layers are not visible
- Tougher and less brittle compared to regular PLA
- Easy to print
- Low warping
- Limited smell
- Not abrasive

1. Identification of the material

Trade name:	HotOrange3D
Chemical name:	Polylactic acid
Use:	3D printing
Origin:	HotOrange3D – Netherlands

Disclaimer: The technical data contained on this data sheet is furnished without charge or obligation and accepted at the recipient's sole risk. This data should not be used to establish specifications limits or used alone as the basis of design. The data provided is not intended to substitute any testing that may be required to determine fitness for any specific use.

2. Printer settings

Printer:	Desktop FFF printer
Heated bed:	± 35 - 60 °C

3. Material properties

Specific gravity:	1,24	g/cc	ISO 1183
MFR 210°C/2,16 kg:	9,56/10 min	gr	ISO 1133
Tensile Strength at Yield (MPa):	70	MPa	ISO 527
Strain at yield:	5	%	ISO 527
Strain at break:	20	%	ISO 527
E-Modulus:	3120	MPa	ISO 527
Impact strength - Charpy method 23°C:	3,4	kJ/m2	ISO 179
Moisture absorption:	1968	ppm	ISO 62
Printing temp.:	215±10	°C	DF
Melting temp.:	115±35	°C	ISO 11357
Vicat softening temp.:	60	°C	ISO 306
Glass transition temp.:	57	°C	ISO 11357

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