

PLA-Silk Mystic

Technical Data Sheet

A filament of three colors, rich horizontal color collocation makes the print model full of mystery, each print can be observed at different angles to the rich color combination performance, rotating the model more three-color interweaving gradient brought about by the wonderful dynamic sense of the appearance of rich silk luster texture, the surface is smooth and does not show the layer of texture; support compared to other materials, easier to peel off from the surface of the model. The product is based on PLA material modification, with the characteristics of PLA easy to print.

Material Status	Mass Production
Characteristics	• Mysterious three-color appearance • Smooth surface. • Easy to print as PLA. • High toughness.
Applications	• Toys • Decoration
Form	• Filament
Processing method	• 3D Print, FDM Print

	testing method	Typical value	
Physical Properties			
Density	GB/T 1033	1.23	g/cm³
Melt Flow Index	GB/T 3682	4.8	190°C/2.16kg
Mechanical Properties			
Tensile Strength	GB/T 1040	52	MPa
Elongation at Break	GB/T 1040	14.4	%
Flexural Strength	GB/T 9341	65	MPa
Flexural Modulus	GB/T 9341	1447	MPa
IZOD Impact Strength	GB/T 1843	5.86	kJ/m²
Thermal Properties			
Heat distortion Temperature	GB/T 1634	54.7	°C
Continuous Service Temperature	IEC 60216	N/A	
Maximum (short term) Use Temperature		N/A	
Electrical Properties			
Insulation Resistance	DIN IEC 60167	N/A	
Surface Resistance	DIN IEC 60093	N/A	

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Recommended printing parameters

Extruder Temperature	190- 230°C
Build Platform Temperature	45-60°C
Fan Speed	100%
Printing Speed	40 - 100mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2. Printing conditions may vary with different nozzle diameters

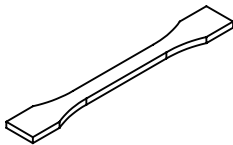
Drying Recommendations

N/A

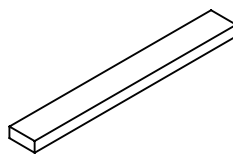
Precautions:

Reducing overhang angle structure in the model or the speed in printing to keep the cooling.

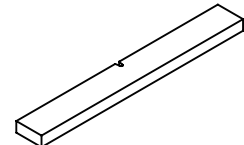
Mechanical Properties



Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1043

The physical properties, mechanical properties, thermal properties, and electrical properties of the line are obtained based on the injection molding spline test.

Print test condition :

Extruder Temperature	190-230°C
Build Platform Temperature	45°C
Outline/Perimeter Shells	4
Top/Bottom Layers	4
Infill Percentage	20%
Fan speed	100%
Printing speed	40mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2.

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