



3D Printing Filament

TECHNICAL DATA SHEET HQ-PLA

Commercial name: Fiber Force HQ-PLA
Raw material: PLA – Polylactid Acid
Designation: 3D printing applications
Manufacturer: Fiber Force Italy srl – Vicolo Dotti 4 – 31100 Treviso - Italy

Material specifications

Property	Value	Test Method - ASTM
Density	1,24 g/cm ³	D1505
Melting point	145 – 160°C	D3418
Tensile Modulus	MD 480 kpsi TD 560 kpsi	D882 D882
Tensile Strength	MD 16 kpsi TD 21 kpsi	D882 D882
Degradation Temperature	250°C	/

Filament specifications

Property	Value and Tolerances
Diameter 1.75mm	1.75 ± 0.05 mm
Diameter 2.85mm	2.85 ± 0.05 mm
Roundness deviation	max 3%
Suggested print temperature (guideline)	215°C
Suggested print speed	40 – 85 mm/s
Suggested bed temperature	30-50°C (not necessary)