



## 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 <sup>3</sup>     | D1505              |
| Melting point           | 145 – 160°C                | D3418              |
| Tensile Modulus         | MD 480 kpsi<br>TD 560 kpsi | D882<br>D882       |
| Tensile Strength        | MD 16 kpsi<br>TD 21 kpsi   | D882<br>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) |