



3D Printing Filament

TECHNICAL DATA SHEET PLA PRO-HT

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

Material specifications

Property	Value	Test Method - ASTM
Density	1,25 g/cm ³	D792
Melting point	165 – 180°C	D3418
Tensile Modulus	2,5 MPa	D638
Tensile Strength	42 MPa	D638
Glass Transition Temperature	55-60°C	D3418
Izod Impact Strength	40 J/m	D256
Heat Distortion Temperature	>100°C (after post-annealing)	D648

Filament specifications

Property	Value and Tolerances
Diameter 1.75mm	1.75 ± 0.03 mm
Diameter 2.85mm	2.85 ± 0.05 mm
Roundness deviation	max 2%
Suggested print temperature (guideline)	190-220°C
Suggested print speed	40 – 85 mm/s
Suggested bed temperature	30-50°C (not necessary)

Post-annealing Guideline: 20 minutes at 110°C