



Material DataSheet PLA Fusion

TDS Nr.: 5046

Rev. 2.0 27/03/2025

Main features

Low warpage

Impact resistance

Low water absorption

High-strength and stiffness parts with low creep

Physical properties

Physical properties	Test method	Specimen	Units	Typical value
Specific gravity	ASTM D792		g/cm ³	1.24
Water absorption				

Mechanical Properties at 23°C

Tensile strength	ASTM D882		MPa	60
Tensile modulus				
Impact strength				
Impact strength notched	ASTM D256		J/m	16
Flexural modulus				
Flexural strength				
Flexural elongation F. max.				
Elongation F. max.				

Thermal properties

Heat distortion temperature

Continuous service temperature

Electrical properties

Insulation resistance

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SUGGESTED PRINT SETS (I)

Suggest print sets	Unit	Value	Test method
Extruder temp	C°	215-240	Internal
Plate temp	C°	30 - 90	Internal
Min. nozzle diameter	mm.	0,3	Internal
Fan	%	0 - 70	Internal
Print speed	mm/l°	30 - 80	Internal

ADDITIONAL INFORMATIONS

In General filaments made with PLA fusion can be processed on conventional 3D printer using FDM / FFF technology.

PLA fusion is a special PLA developed for 3D printing and to obtain best results we recommend pre drying the filaments at 50° for 2 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 190°, better stop the thermal control.

(I) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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