

Wood

Technical Data Sheet

This is a PLA based 3D printing material with cool appearance like wood. It has the characteristics of easy to print and smooth surface as PLA. It utilizes active foaming technology to achieve like-wood appearance with low-density PLA of 0.7g/cm³.

Material Status	Mass Production
Characteristics	<ul style="list-style-type: none"> Cool appearance like wood. Easy to paint. Low-density PLA of 0.7g/cm³. Easy to print as PLA.
Applications	<ul style="list-style-type: none"> Aeromodelling Crafts.
Form	<ul style="list-style-type: none"> Filament
Processing method	<ul style="list-style-type: none"> 3D Print, FDM Print

	testing method	Typical value	
Physical Properties			
Density	GB/T 1033	0.7	g/cm ³
Melt Flow Index	GB/T 3682	17	(190°C/2.16kg)
Mechanical Properties			
Tensile Strength	GB/T 1040	N/A	MPa
Elongation at Break	GB/T 1040	N/A	%
Flexural Strength	GB/T 9341	N/A	MPa
Flexural Modulus	GB/T 9341	N/A	MPa
IZOD Impact Strength	GB/T 1843	N/A	kJ/m ²
Thermal Properties			
Heat distortion Temperature	GB/T 1634	45	°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	210 - 230°C
Build Platform Temperature	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

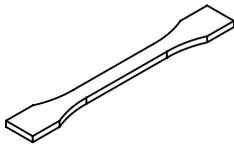
Drying Recommendations

N/A

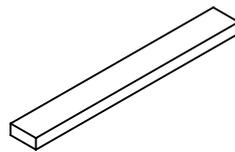
Precautions:

- 1.It utilize active foaming technology to achieve like-wood appearance,which is hard to avoid stringing problem. Try to down the extruder temperature.
- 2.Suggest to close
- 3.Keep the printing speed 20mm/s-30mm/s.

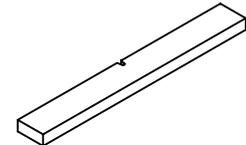
Mechanical Properties



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	210-230°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.

Notice

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