



# Datasheet

## RS PRO – METALLIC PLA

Stock numbers:

183-0233 / 183-0236 / 183-0238 / 183-0239

EN

**METALLIC PLA** is a highly aesthetical PLA based filament with sparkling flakes inside. Slightly modified, the filament retains the typical features of PLA, but is tougher and less brittle. The sparkling flakes helps concealing layer lines. Polylactic acid is one of the most popular materials for 3D printing. Because of the translucency of PLA combined with the flakes, the colour saturation can be increased by increasing wall thickness. No need for special nozzle as the material is not abrasive.

### Features:

- Easy to print
- Beautiful metallic effect
- Layers are not visible
- Low warping
- Limited smell & not abrasive

### Colours:

RS PRO - METALLIC PLA is available from stock in dark grey colour

### Packaging:

RS PRO – METALLIC PLA is available in 500 grams and 1 kg packaging.



Filament specs.		
Size	Ø tolerance	Roundness
1,75mm	± 0,05mm	≥ 95%
2,85mm	± 0,10mm	≥ 95%
Physical properties		
Description	Testmethod	Typical value
Specific gravity	ISO 1183	1,24g/cc
MFR 210°C/2,16 kg	ISO 1133	9,56 gr/10 min
Tensile strength at yield	ISO 527	70 Mpa
Strain at yield	ISO 527	5 %
E-Modulus	ISO 527	3120 Mpa
Impact strength - Charpy method 23°C	ISO 179	3,4 kJ/m <sup>2</sup>
Thermal properties		
Description	Testmethod	Typical value
Printing temp.	-	215±10°C
Melting temp.	ISO 11357	115±35°C
Vicat softening temp.	ISO 306	60°C

### Additional information:

Due to its low tendency to warp METALLIC PLA can also be printed without a heated bed. If you have a heated bed the recommended temperature is ± 35-60°C.

**It is recommended to purge the nozzle after printing, to prevent build-up of flakes for the next print.**

METALLIC PLA can be used on all common desktop 3D printers. (FDM or FFF technology)

Storage: Cool and dry (15-25°C) and away from UV light. This enhances the shelf life significantly.

- Bed adhesion: Glass Plate or Tape or Hairspray
- Print speed: Medium
- Fan speed: Medium/ high
- Retraction: +-5mm
- Layer Height: >0,1mm