

# PLA-Silk

## Technical Data Sheet

The model has a silky luster and texture, with a smooth surface that does not show layering patterns. Compared with other materials, the support is easier to peel off from the model surface, and the contact surface is smooth and flat. This product is modified based on PLA material and features the easy printability of PLA.

### Basic Information

Characteristics	• Shiny and luster texture	• High toughness
	• Smooth surface	
	• Easy to print as PLA	
Applications	• Toys	
	• Decoration	
Forming Method	• Filament	
Processing Method	• 3D Print, FDM Print	

### Physical Properties

#### Testing Method

#### Data

Density	GB/T 1033	1.21 g/cm <sup>3</sup>
Melt Flow Index	GB/T 3682	4.8 (190°C/2.16kg)

### Thermal Properties

#### Testing Method

#### Data

Heat Distortion Temperature	GB/T 1634	50 °C (0.45Mpa)
Glass Transition Temperature		N/A
Continuous Service Temperature	IEC 60216	N/A
Maximum (short term) Use Temperature		N/A

### Electrical Properties

#### Testing Method

#### Data

Insulation Resistance	DIN IEC 60167	N/A
Surface Resistance	DIN IEC 60093	N/A

Mechanical Properties	Testing Method	Data
Tensile Strength (X-Y)	GB/T 1040	32.53 Mpa
Tensile Strength (Z)	GB/T 1040	17.36 MPa
Elongation at Break (X-Y)	GB/T 1040	11.65 %
Elongation at Break (Z)	GB/T 1040	1.84 %
Flexural Strength (X-Y)	GB/T 9341	44.4 MPa
Flexural Strength (Z)	GB/T 9341	23.1 Mpa
Flexural Modulus (X-Y)	GB/T 9341	1917.35 MPa
Flexural Modulus (Z)	GB/T 9341	1858.86 Mpa
IZOD Impact Strength (X-Y)	GB/T 1843	2.93 KJ/m <sup>2</sup>
IZOD Impact Strength (Z)	GB/T 1843	2.19KJ/m <sup>2</sup>

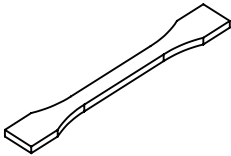
Chemical Properties	Data
Acid and Alkali Resistance	NO
Grease Resistance	N/A
UV Resistance	NO
Water Repellency	N/A

Recommended Printing Parameters	Data
Drying Preparation	50°C > 8H
Nozzle Size	0.2,0.4,0.6,0.8mm
Nozzle Temperature	190-230°C
Build Platform Type	PEI
Build Platform Temperature	45-60°C
Fan Speed	100%
Printing Speed	< 200mm/s

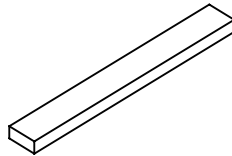
## Printing Tips

When slicing, it is best to turn on the Z seam alignment and starting point alignment functions, turn off the Z-axis lift and exit, avoid passing through the shell when idling, optimize the slicing printing path, and appropriately reduce the printing speed to achieve the best printing effect.

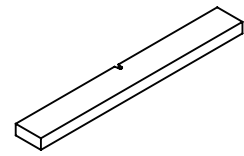
## Test Conditions of Mechanical Properties



Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1843

The performance of the filament is evaluated based on standard samples printed by eSUN, while the actual printing performance is influenced by various factors such as printer type, printing parameters, and print environment.

## Printing Test Conditions:

Extruder Temperature	220°C
Build Platform Temperature	60°C
Outer Layer Number	2
Top/Bottom Layer Number	3
Infill Density	100%
Fan Speed	100%

\*Based on Bambu P1S 0.4 mm nozzle and Orcaslicer 2.1.0 Beta.

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