

SAKATA 3D PLA-M is a biodegradable PLA-based filament for matte finish applications. Suitable for all consumer-grade 3D FDM/FFF printers. Despite its rough surface, this material is considered abrasive, so a hardness steel nozzle is not required. Easy to print, reliable bed adhesion, non-glossy surface finish. Made in Spain by POLIMERSIA GLOBAL S.L.

FILAMENT SPECIFICATIONS	Unit	Value
Diameter	mm	1.75 ± 0.03
Max. roundness deviation	mm	0.03
Net weight	g	1,000

PHYSICAL PROPERTIES	Standard	Unit	Value
Specific gravity	ASTM D792	g/cm ³	1.24
MECHANICAL PROPERTIES	Standard	Unit	Value
Tensile modulus ⁽¹⁾	ASTM D882	MPa	3,600
Tensile strength at break ⁽¹⁾	ASTM D882	MPa	53
Tensile yield strength ⁽¹⁾	ASTM D882	MPa	60
Elongation at break ⁽¹⁾	ASTM D882	%	6
Flexural modulus ⁽¹⁾	ASTM D790	MPa	3,800
Flexural strength ⁽¹⁾	ASTM D790	MPa	83
Izod notched impact strength ⁽¹⁾	ASTM D256	J/m	16
THERMAL PROPERTIES	Standard	Unit	Value
HDT (0.45 MPa) ⁽¹⁾	ASTM E2092	°C	55

⁽¹⁾ Injection moulding bars.

PRINT SETTINGS (*)	Unit	Value
Nozzle temp.	°C	190 - 200
Type of nozzle	-	Brass
Bed temp.	°C	> 45
Type of bed	-	Glass or PEI
Fan speed	%	100
Layer height	mm	0.1 – 0.3
Print speed	mm/s	< 120
Dry specification	Before printing	2 – 4 hours at 60 °C (optional)
	During printing	60 °C (optional)

^(*) Settings are based on a 0.4 mm nozzle.

Certifications / Approvals

SAKATA 3D PLA-M filament is not certified for food contact either medical applications.

Safety Considerations

Good general ventilation of the workplace is recommended.

Disclaimer

The above information is provided in good faith. POLIMERSIA GLOBAL S.L. makes no warranty or representation of any kind, regarding the information given or the products described, and expressly disclaims all implied warranties, representations and conditions, including without limitation all warranties and conditions of quality, merchantability and suitability or fitness for a particular purpose.