

SAKATA 3D PLA WOOD is a biodegradable filament made of PLA and natural wood fibres, suitable for all consumer-grade 3D FDM/FFF printers. Its biobased carbon content is > 75 %. It gives to 3D printed parts a realistic wooden look and feel. 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	450 / 1,000

MECHANICAL PROPERTIES	Standard	Unit	Value
Tensile modulus <sup>(1)</sup>	ISO 527	MPa	2,900
Tensile strength <sup>(1)</sup>	ISO 527	MPa	47
Elongation at break <sup>(1)</sup>	ISO 527	%	6.5
Flexural modulus <sup>(1)</sup>	ISO 178	MPa	2,950
Flexural strain at break <sup>(1)</sup>	ISO 178	MPa	NB
Flexural strain at 3.5% strain <sup>(1)</sup>	ISO 178	MPa	64
Charpy unnotched impact strength <sup>(1)</sup>	ISO 179-1/1 eA	KJ/m <sup>2</sup>	21
Charpy notched impact strength <sup>(1)</sup>	ISO 179-1/1 eA	KJ/m <sup>2</sup>	4.4

NB: No break.

<sup>(1)</sup> Injection moulding bars.

PRINT SETTINGS (*)	Unit	Value
Nozzle temp.	°C	190 - 210
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	< 90
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 WOOD filament is not certified for food contact either medical applications.

### Safety Considerations

Good general ventilation of the workplace is recommended.

### Disclaimer

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