TECHNICAL DATA SHEET - WOOD

IDENTIFICATION OF THE MATERIAL	
Trade name	WOOD
Chemical name	Polylactic acid compound
Chemical family	Compound of polylactic acid
Use	3D printing
Brand	3dcolors

GUIDELINE FOR PRINT SETTINGS - Settings are based on a ≥0.4 mm nozzle	
Nozzle temperature	200 ± 10 °C
Bed temperature	0 - 60 °C
Bed modifications	Tape, glue or other adhesives
Active cooling fan	Yes, up to 100%
Layer height	0.08 - 0.2 mm
Layer thickness	0.4 - 0.8 mm
Print speed	40 - 60 mm/s

THERMAL PROPERTIES		Test Method
Melting temperature	145 ± 5 °C	-
Printing temperature	200 ± 10 °C	/
Vicat softening temp.	45 °C	ISO 306

FILAMENT SPECIFICATIONS AND TOLERANCE	
Diameter 1.75	1.75 ± 0.05 mm
Roundness	95%
Net weight on reel	500 g ± 2%

Think it, make it!

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PHISICAL PROPERTIES	Typical value	Test Method
Specific gravity	1,2 g/cc	ASTM D1505
MFI	5 gr/10min	-
Tensile strength	70 MPa (MD) - 100 MPa (TD)	ASTM D882
Elongation at break	170% (MD) - 110% (TD)	ASTM D882
Tensile modulus	1900 MPa (MD) - 2300 MPa (TD)	ISO 527
Impact strength *Charpy notched 23°C	7,0 kJ/m^2	ISO 179

WOOD FEATURES:

- Feels and smells like WOOD
- Easy to print at low temperature
- Very low warping
- Biodegradable
- Preferably printed with ≥ 0,5 mm nozzle

LIST OF COLOURS:

Coconut
RAL N/D

Ebony
RAL N/D

Forest
RAL N/D

Ivory
RAL N/D

Bamboo
RAL N/D

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