

**Technical Data Sheet**
**PLA+**
**Base Material: Polylactic Acid**
**Product Details**

Diameter ( $\phi$ )	Tolerance	Ovality
1.75 mm	$\pm 0.03$ mm	$\geq 97$ %

**Properties of the most relevant Raw Material**

Description	Test Method	Avg. Value	
Density	ASTM 1505	1.24	Gr/Cm3
Flow Index	ASTM 1238	6	Gr/10 min

Physical	Test Method	Ingeo Resin
Specific Gravity, g/cc	ASTM D792	1.24
MFR, g/10 min (1)	ASTM D1238	6
Relative Viscosity (2)	ASTM D5225	04.0
Clarity	-	Transparent
Peak Melt Temperature, °C	ASTM D3418	145 - 160
Glass Transition Temperature, °C	ASTM D3418	55 - 60

Mechanical	Test Method	Value
Tensile Yield Strength, psi (MPa)	ASTM D882	8700 (60)
Tensile Strength at Break, psi (MPa)	ASTM D882	7700 (53)
Tensile Modulus, psi (MPa)	ASTM D882	524,000 (3.6)
Tensile Elongation, %	ASTM D882	6
Notched Izod Impact, ft-lb/in (J/m)	ASTM D256	0.3 (16)
Flexural Strength, psi (MPa)	ASTM D790	12,000 (83)
Flexural Modulus, psi (MPa)	ASTM D790	555,000 (3.8)
Heat Distortion Temperature, °C 66 psi (0.45 MPa)	ASTM E2092	55

(1) 210 °C/2.16 kg

(3) RV measured at 1.0 g/dL in chloroform at 30 °C

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