

Product Name:

Anycubic PLA

Anycubic PLA is an eco-friendly filament that offers vibrant color options. It provides prints with smooth surfaces and high success rates. The filament is neatly wrapped, free of bubbles, and features a consistent diameter to minimize clogging.

Physical Properties

Property	Testing Method	Unit	Typical Value
Density/ (g/cm ³)	ISO 1183,at 23°C	g/cm ³	1.24
Melt Index/ (g/10min)	ISO 1133	g/10min	5.7±0.67
Moisture Content	ISO 787-2	%	0.26

Mechanical Properties

Property	Testing Method	Unit	Typical Value
Tensile Strength / MPa (X-Y)	ISO 527	MPa	48±5
Tensile Strength / MPa (Z)			28±2.4
Young's Modulus / MPa (X-Y)	ISO 527	MPa	2534±85
Young's Modulus / MPa (Z)			/
Elongation at Break / % (X-Y)	ISO 527	%	8±1
Elongation at Break / % (Z)			/
Bending Strength / MPa (X-Y)	ISO 178	MPa	90±3
Bending Strength / MPa (Z)			/
Bending Modulus / MPa (X-Y)	ISO 178	MPa	3360±100
Bending Modulus / MPa (Z)			/
Izod Impact Strength (kJ/m ²) (X-Y)	ISO 179	kJ/m ²	22±1
Izod Impact Strength (kJ/m ²) (Z)			/

*All data are based on printed test samples. '(X-Y)' and '(Z)' indicate different testing orientations (refer to the direction schematic).

Thermal Performance

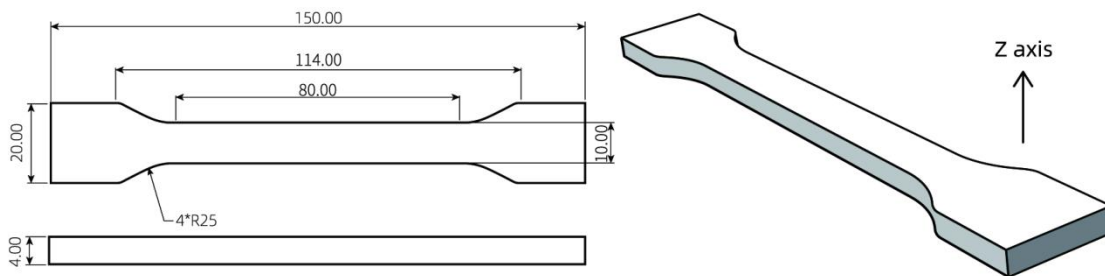
Property	Testing Method	Unit	Typical Value
Glass Transition Temperature	ISO 11357-1, 10°C/min	°C	61.2
Melting Temperature	ISO 11357-1, 10°C/min	°C	166
Crystallization Temperature	ISO 11357-1, 10°C/min	°C	114
Vicat Softening Temperature (VST)	ISO 306, 10N	°C	55
Heat Deflection Temperature (HDT)	ISO 75-2, 1.8 MPa	°C	/
Heat Deflection Temperature (HDT)	ISO 75-2, 0.45MPa	°C	54

Recommended Printing Parameters

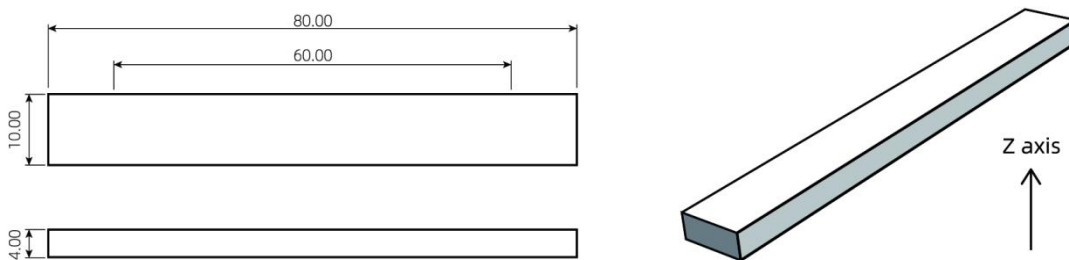
*Based on a 0.4mm nozzle, printing conditions may vary with different nozzle diameters

Parameter	Recommended Value
Nozzle Temperature	190-230
Bed Temperature	55-65
Dry Environment	45-50°C , 6-8h
Printing Speed	50-200
Extrusion Multiplier	0.98
Max Volumetric Flow Rate	12
Fan Speed	100%
Cooling Time	8
Minimum printing Speed	20
Raft Separation Distance	0.8
Retraction Speed	40

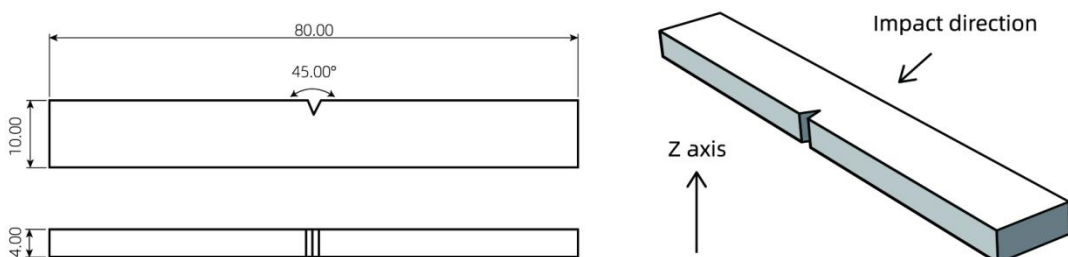
TENSILE TESTING SPECIMEN



IMPACT TESTING SPECIMEN



IMPACT TESTING SPECIMEN



Disclaimer:

The values shown in this chart are for comparison purposes only and are not appropriate for design specifications or quality assurance. Variations may arise due to printing conditions. The end-use performance of printed parts depends on materials, design, environmental conditions, and printing conditions. Please note that product specifications are subject to change without notice.

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