

**PLA type D transparent + color masterbatch**

- Temperature print: 195-225 °C for 2,90 mm filament / 190-210 °C for 1,75 mm filament
- Temperature pad is not necessary

Material data sheet for PLA type D:

Specific Gravity	1.24	D792
MFR, g/10 min (210°C, 2.16kg)	6	D1238
Clarity	Transparent	
<b>Mechanical Properties</b>		
Tensile Strength @ Break, psi (MPa)	7,700 (53)	D882
Tensile Yield Strength, psi (MPa)	8,700 (60)	D882
Tensile Modulus, kpsi (GPa)	500 (3.5)	D882
Tensile Elongation, %	6.0	D882
Notched Izod Impact, ft-lb/in (J/m)	0.3 (16)	D256
Shrinkage is similar to PET <sup>(2)</sup>		
Heat Distortion Temperature (°C)	55	E2092