

TECH PLA 609HD

Material	PLA polylactide
Color	Black, Natural, Orange, Red, White, Green, Yellow, Brown, Silver, Blue
Properties	Eco-friendly, high heat and impact grade
Diameter	1.75mm / 2.85mm
Diameter tolerance	+/- 0.03mm
Tolerance roundness	98%
Printing temperature	190–230 °C
Heatbed temperature	60–80 °C
Net weight	0.5kg / 1 kg / 3kg / 9kg
Gross weight	0.85kg / 1.4kg / 3.95kg / 10.4kg
Spool dimensions	200x52x43mm / 200x52x80mm / 200x52x100mm / 355x35x165mm
Packaging	Vacuum packaging, carton box, moisture absorber



Properties of the PLA 609HD material

PHYSICAL PROPERTIES	UNIT	ASTM METHOD
SPECIFIC GRAVITY, G/CC	1.22	D792
MFR, G/10 MIN	9-15	D1238
PEAK MELT TEMPERATURE, °C	165-180	D3418
GLASS TRANSITION TEMPERATURE, °C	55-60	D3418
MECHANICAL PROPERTY		
TENSILE STRENGTH, PSI (MPA)	5,802 (40)	D638
TENSILE MODULUS, KPSI (MPA)	416 (2,865)	D638
FLEXURAL STRENGTH, PSI (MPA)	10,588 (73)	D790
FLEXURAL MODULUS, KPSI (MPA)	350 (2,414)	D790
NOTCHED IZOD IMPACT, FT-LB/IN (J/M) AMORPHOUS	2.99 (160)	D256
NOTCHED IZOD IMPACT, FT-LB/IN (J/M) CRYSTALLINE	4.37 (233)	D256
HEAT DISTORTION TEMPERATURE, °C 66 PSI (0.45 PA)	75-85	E2092