

# **TECHNICAL DATA SHEET**

# **Huracan PLA**

#### **MATERIAL PROPERTIES**

Specific Gravity	1.22 g/cm <sup>3</sup>	D 792
MFR	15 g/10 min	D 1238
Mechanical Properties*		ASTM Method
Tensile Strength	42 MPa	D 638
Tensile Modulus	2950 MPa	D 638
Flexural Strength	75 MPa	D 790
Flexural Modulus	2500 MPa	D 790
Notched Izod Impact [crystaline]	240 J/m	D 256
Thermal properties		
Heat Distortion Temperature*	80°C	E 2092
Glass Transition Temperature	55-60°C	D 3418

<sup>\*</sup> annealed

# **GUIDELINE FOR PRINT SETTINGS\***

Nozzle temperature	190 - 230°C	
Bed temperature	0 - 45°C	
Active cooling fan	YES (up to 100%)	
Layer height**	0.05 - 0.30 mm	
Shell thickness**	0.40 - 2.70 mm	
Print speed**	40 - 350 mm/s	
Closed chamber	not necessary	
Dry box	not necessary	
Ruby or hardened nozzle	not necessary	

<sup>\*</sup> settings are based on a 0,4 mm nozzle.

## Disclaimer

The product- and technical data provided in this datasheet is correct to the best of Spectrum Group Sp. z o.o. knowledge and are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary according to printing conditions, model complexity, environmental conditions, etc. The user assumes all responsibility for the use of all information provided and shall verify quality and other properties or any consequence from the use of all such information. Typical values are indicative only and are not to be construed as being binding specifications. Spectrum Group Sp. z o.o. shall not be made liable for any damage, injury or loss induced from the use of Spectum Group Sp. z o.o. materials in any particular application.

### DESCRIPTION

Huracan PLA is an innovative filament designed for high speed 3D printing (up to 350mm/s), which combines incredible printing speed with unique mechanical and thermal (post-annealed) properties. This material is characterized by exceptional efficiency and quality, making it ideal for a wide range of applications.

### **FEAUTURES**

- High flow rate enabling fast printing (up to 350 mm/s)
- · Easy to print
- Better mechanical and thermal strength after annealing
- · High strength comparable to ABS
- · Increased temperature resistance after annealing

#### STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4-77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.



# SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at support@spectrumfilaments.com



<sup>\*\*</sup> depending on the geometrical complexity