



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	185-210	internal
plate temp	C°	cold to 90	internal
min. nozzle diameter	mm.	0,3	internal
fan	%	0-20	internal
print speed	mm/l°	60-70	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.3	ASTM D792
Mechanical at 23°C / 50% rh			
IZOD impact strength notched (23°C)	J/m	50	ASTM D256
Tensile elongation yield	MPa	38	ASTM D638
Tensile elongation break	%	>10	ASTM D638
Thermal			
Heat deflection temp.	°C	90	ASTM D648

Disclaimer

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ADDITIONAL INFORMATIONS

In general filaments made with SHOGUN PLA can be processed on conventional 3D printer using FDM / FFF technology.

SHOGUN PLA is a special polylactide blend developed for 3D printing and to obtain best results we recommend pre drying the filaments at 60° for 2 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 170°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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