

# TECHNICAL DATA SHEET



## ReFill PLA

Date of issue: 3-11-2022

Date of update: 23-8-2024

### Product specifications

ReFill PLA is manufactured for usage with re-usable master spools. Print your own spool. This filament reduces your carbon footprint significantly as packaging waste is reduced to an absolute minimum.

### Important key features

Minimal packaging waste  
Food contact approved according to EU directives  
Very easy to 3D print

### Suitable applications

Medical  
Functional prototypes  
Drones

### Recommended pretreatment

#### Drying

Not necessary  
30 - 40 °C  
12 h

#### Print with

|           |    |
|-----------|----|
| Enclosure | No |
| Dry box   | No |

### Recommended print settings regular speed

|                    |              |
|--------------------|--------------|
| Print speed        | 25 - mm/s    |
| Nozzle temperature | 190 - 225 °C |
| Bed temperature    | 50 - 60 °C   |
| Fan speed          | 80 - 100 %   |

### Recommended print settings high speed

ReFill PLA is high speed compatible. Our recommended settings will be added once available. Please take note that the nozzle temperature and fan speed need to be raised when printing at high speed.

### Material properties

Density  
Specific gravity  
Melt flow rate

#### Typical value

1,24

#### Unit of Measure

g/cm<sup>3</sup>

#### Test method

#### Test condition

### Mechanical properties

Impact strenght  
Tensile strenght at yield  
Tensile strenght at break  
Tensile modulus  
Elongation at yield  
Elongation at break  
Flexural strenght  
Flexural modulus  
Rockwell hardness

53

3495

6

MPa

MPa

%

ASTM D882

ASTM D882

ASTM D882

### Thermal properties

Melting temperature  
Heat deflection temperature  
Vicat softening temperature  
Glass transition temperature

165

55

°C

°C

ASTM E2092

HDT A

### Product export information

#### HS code

39169090

#### Description

Monofilament for 3D printing

#### Origin

European Union

### Disclaimer

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