

# PLA Stone Age

## MATERIAL PROPERTIES

Specific Gravity	1.24 g/cm <sup>3</sup>	D 792
MFR (210°C, 2.16kg)	6 g/10min	D 1238

## Mechanical Properties

Tensile Strength at Break	53 MPa	D 882
Tensile Strength at Yield	60 MPa	D 882
Tensile Modulus	3.5 Gpa	D 882
Tensile Elongation	6,00%	D 882
Notched Izod Impact	16 J/m	D 256
Flexural Strength	83 MPa	D790
Flexural Modulus	3.8 MPa	D790

## Thermal Properties

Heat Distortion Temperature	55°C	E 2092
Glass Transition Temperature	55-60°C	D3418

## GUIDELINE FOR PRINT SETTINGS\*

Nozzle temperature	185-225°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**	40-80 mm/s
Closed chamber	not necessary
Dry box	not necessary
Ruby or hardened nozzle	not necessary
Recommended nozzle	≥ 0.4 mm

\* settings are based on a 0,4 mm nozzle.

\*\* depending on the geometrical complexity

## 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 Spectrum Group Sp. z o.o. materials in any particular application.

## DESCRIPTION

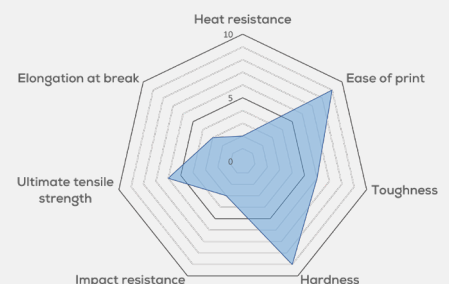
Spectrum PLA Stone Age filament is a series of PLA-based material with admixtures to obtain an imitation of "stony" structure of printed items. The Stone type filament, manufactured in two shades: Stone Age Light and Stone Age Dark, demonstrates excellent masking of layers, while printed items feel rough resembling real stone.

## FEAUTURES

- beautiful, aesthetic imitation of stone
- rough surface
- high durability
- shrinkage-free printing
- layer masking
- not abrasive

## 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](mailto:support@spectrumfilaments.com)