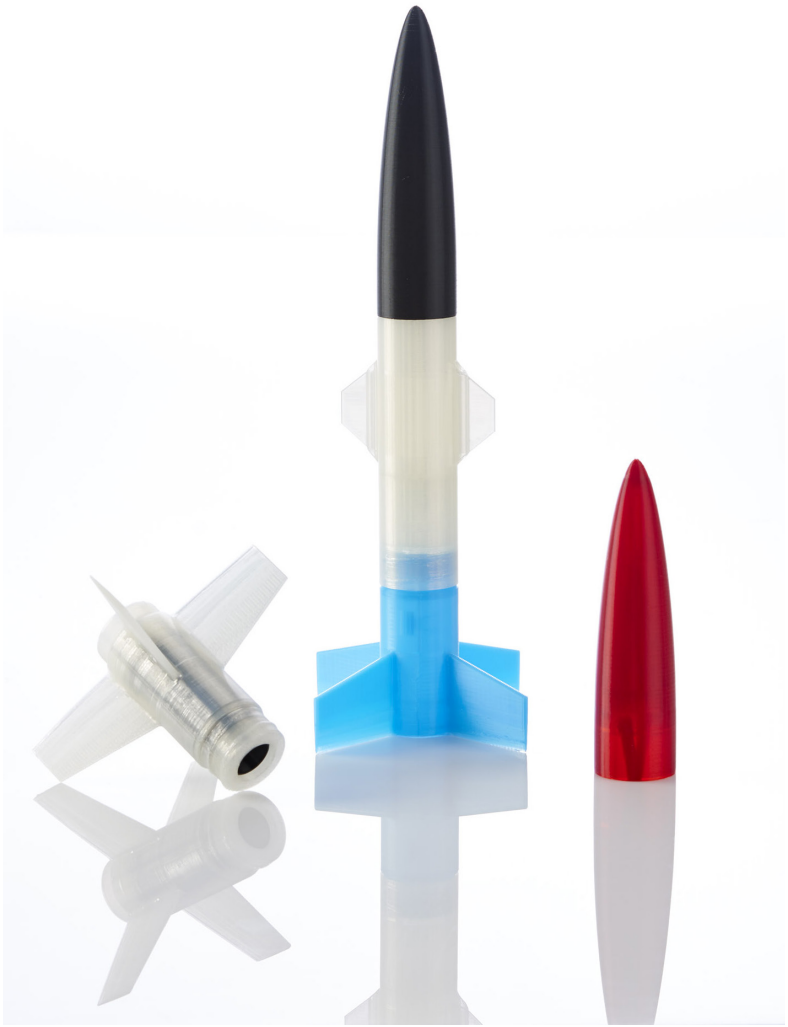
PLA

ECONOMY THERMOPLASTIC FOR STRATASYS F123 SERIES PRINTERS

PLA is a renewable plastic material offered as a low-cost material option for fast-draft part iterations. Available on the office-friendly Stratasys F123™ Series 3D printers, PLA offers a higher stiffness than ABS and its low melting point and HDT mean less heat and power required to print parts.

PLA works well at high speeds, specifically fast-draft mode on the Stratasys F123 Series, for quick concept verification and design development. PLA offers good tensile strength and is available in a wide range of colors. Ideal applications for PLA include early concept modeling and fast prototyping.



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THE **3D PRINTING SOLUTIONS** COMPANY™

PLA

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At the core: Advanced FDM™ Technology From The Industry Leader

The Stratasys F123 3D Printer Series is based on Stratasys® proven FDM technology. FDM (fused deposition modeling) is the industry's leading additive manufacturing technology and can produce professional-quality models, prototypes and parts in a wide range of production-grade thermoplastics.

Ideal for building components with complex geometries in nearly any shape and size, parts created with Stratasys F123 3D Printers are strong, durable and dimensionally stable with the best accuracy and repeatability.

MECHANICAL PROPERTIES[1]	TEST METHOD	ENGLISH		METRIC	
		XZ AXIS	ZX AXIS	XZ AXIS	ZX AXIS
Tensile Strength, Yield (Type 1, 0.125", 0.2"/min)	ASTM D638	6,580 psi	3,790 psi	45 mPa	26 mPa
Tensile Strength, Ultimate (Type 1, 0.125", 0.2"/min)	ASTM D638	6,990 psi	3,830 psi	48 mPa	26 mPa
Tensile Modulus (Type 1, 0.125", 0.2"/min)	ASTM D638	440,730 psi	368,200 psi	3,039 mPa	2,539 mPa
Elongation at Break (Type 1, 0.125", 0.2"/min)	ASTM D638	2.5%	1.0%	2.5%	1.0%
Elongation at Yield (Type 1, 0.125", 0.2"/min)	ASTM D638	1.5%	1.0%	1.5%	1.0%
Flexural Strength (Method 1, 0.05"/min)	ASTM D790	12,190 psi	6,570 psi	84 mPa	45 mPa
Flexural Modulus (Method 1, 0.05"/min)	ASTM D790	425,010 psi	358,290 psi	2,930 mPa	2,470 mPa
Flexural Strain at Break	ASTM D790	4.1%	1.9%	4.1%	1.9%
IZOD impact - notched (Method A, 23°C)	ASTM D256	0.5 ft-lb/in	N/A	27 J/m	N/A
IZOD impact - unnotched (Method A, 23°C)	ASTM D256	3.6 ft-lb/in	N/A	192 J/m	N/A

THERMAL PROPERTIES	TEST METHOD	ENGLISH	METRIC
Heat Deflection (HDT) @ 66 psi	ASTM D648	127°F	53°C
Heat Deflection (HDT) @ 264 psi	ASTM D648	124°F	51°C
Vicat Softening Temperature (Rate B/50)	ASTM D1525	129°F	54°C
Glass Transition Temperature (Tg)	DMA (SSYS)	145°F	63°C
Coefficient of Thermal Expansion (flow)	ASTM E831	$56x10^{-06}$ µin/(in·°F)	$101x10^{-06}$ µm/(m·°C)
Coefficient of Thermal Expansion (xflow)	ASTM E831	$57x10^{-06}$ µin/(in·°F)	$102x10^{-06}$ µm/(m·°C)

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ELECTRICAL PROPERTIES	TEST METHOD	VALUE	
		XY	ZX
Volume Resistivity	ASTM D257	2.9E+15 ohm-cm	3.24E+15 ohm-cm
Dielectric Constant	ASTM D150-98	1.51	2.33
Dissipation Factor	ASTM D150-98	0.003	0.005
Dielectric Strength	ASTM D149-09, Method A	154 V/mil	293 V/mil

OTHER	TEST METHOD	VALUE
Specific Gravity	ASTM D792	1.264 g/cc

SYSTEM AVAILABILITY	LAYER THICKNESS CAPABILITY	SUPPORT STRUCTURE	AVAILABLE COLORS
F123 Series	0.010 in. (0.254 mm)	Breakaway	Black White Light Gray Medium Gray Red Blue Natural Trans Red Trans Blue Trans Yellow Trans Green Trans

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