



SUGGESTED PRINT SETS (I)			
Suggested print sets	unit	value	test method
extruder temp	C°	215-240°	internal
plate temp	C°	90-30°	internal
min. nozzle diameter	mm.	0,3	internal
fan	%	0-70	internal
print speed	mm/l°	30-80	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.21	ISO 1183
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	15.8	ISO 527
Flexural	MPa	3000	ISO 178
Charpy impact (23°C)	kJ/m <sup>2</sup>	23	ISO 179
Charpy impact (-30°C)	kJ/m <sup>2</sup>	9	ISO 179
Thermal			
H.D.T.	°C	65	ISO 75-2

### Disclaimer

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**ADDITIONAL INFORMATIONS**

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

PLA Lèvigo is a special PLA developed for 3D printing and to obtain best results we recommend pre drying the filaments at 50° 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 190°, 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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