

Technical datasheet

colorFabb Laser Marking PLA

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ColorFabb Laser Marking PLA is a high quality PLA 3D printing filament, which contains a laser-sensitive additive optimized to work within a 980-1064 nm wavelength. The material has been tested successfully with a Nd:YAG- and fiberlasers. Laser marking PLA will not work with CO2 lasers.

TYPICAL MATERIAL PROPERTIES

Physical properties	Unit	Value	Method
Density	g/cm ³	1,2 - 1,3	
Glass Transition Temperature	°C	55 - 60	DSC
Tensile Strength	MPa	45	ISO 527-1
Tensile Modulus	MPa	3400	ISO 527-1
Tensile Elongation	%	6	ISO 727-1
Impact Strength (Ch-N 23°C)	kJ/m ²	7	ISO 179-1

FILAMENT SPECIFICATION

Nominal diameter:	Diameter tolerance	Ovality
1,75 mm	± 0,05	≥ 95%
2,85 mm	± 0,10	≥ 95%

GUIDELINE FOR PRINT SETTINGS

Nozzle temperature	195 - 220°C
Bed temperature	50 - 60°C
Bed surface / modification	Tape or glue
Active cooling fan	100%
Print speed	40-80 mm/s

Disclaimer

The product- and technical information provided in this datasheet is correct to the best of our knowledge. The information given is provided as a guidance for good use, handling and processing and is not to be considered as a quality specification. The information only relates to the specific product and the material properties.