

# Huracan PLA

## MATERIAL PROPERTIES

Specific Gravity	1.22 g/cm <sup>3</sup>	D 792
MFR	15 g/10 min	D 1238
<b>Mechanical Properties*</b>		ASTM Method
Tensile Strength	42 MPa	D 638
Tensile Modulus	2950 MPa	D 638
Flexural Strength	75 MPa	D 790
Flexural Modulus	2500 MPa	D 790
Notched Izod Impact [crystalline]	240 J/m	D 256
<b>Thermal properties</b>		
Heat Distortion Temperature*	80°C	E 2092
Glass Transition Temperature	55-60°C	D 3418

\* annealed

## GUIDELINE FOR PRINT SETTINGS\*

Nozzle temperature	190 - 230°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 - 350 mm/s
Closed chamber	not necessary
Dry box	not necessary
Ruby or hardened nozzle	not necessary

\* settings are based on a 0.4 mm nozzle.

\*\* depending on the geometrical complexity

## DESCRIPTION

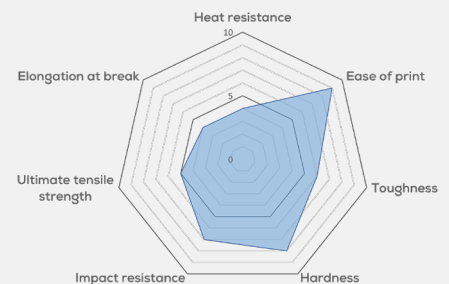
Huracan PLA is an innovative filament designed for high speed 3D printing (up to 350mm/s), which combines incredible printing speed with unique mechanical and thermal (post-annealed) properties. This material is characterized by exceptional efficiency and quality, making it ideal for a wide range of applications.

## FEAUTURES

- High flow rate enabling fast printing (up to 350 mm/s)
- Easy to print
- Better mechanical and thermal strength after annealing
- High strength comparable to ABS
- Increased temperature resistance after annealing

## 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)