3DUNIVERSE

TERRAFILUM™
ENGINEERED FILAMENTS

Technical Data Sheet

PLA_ABS (Rigid Polylactic Acid)

Physical Properties – Typical Values

Property	Value (SI Units)
Tensile Modulus (ASTM D638)	2400 MPa
Ultimate Tensile Strength	50 MPa
Elongation at Break	7%
Density, ASTM D792	1.15 gm/cm^3
Hardness (Shore), ASTM D785	9 - 100 R
Izod Impact, 23 C, ASTM D256	110 J /min
Glass Transition Temp, ASTM D792	45 to 50 °C
Heat Deflection Temp, ASTM D648	80 to 90 °C

3D Printing Guide

Property	Value (SI Units)
Recommended Print Speed	35 - 60 mm /s
Recommended Nozzle Temperature	240 – 260 °C
Recommended Bed Temperature	80 °C
Preferred Bed Adhesive	PEI Cover and Glue or Glass and Glue
Special Considerations	Fan Speed 20%

Suggested Applications

PLA_ABS is a composite material engineered to give the best properties of both materials. It is a great proto-typing material and has low odor compared to normal ABS. It has added heat-resistance and higher impact strength than straight PLA. This engineered material provides excellent performance for use as a mold with applications like urethanes and similar materials.

Available Colors: Natural, Black, Blue, Green, Red, Yellow, White, and Custom

Material is produced using both virgin and reprocessed materials from consistent sources.

Visit www.terrafilum.com to learn more