

# PRIMASELECT™

## PLA PRO

### Why should I use PrimaSELECT™ PLA PRO?

- Engineered for high print speeds >120mm/s which means that you cut down on your production time
- High Heat Resistance 95°C+ (after annealing) - perfect for demanding applications
- Easy to print with and extremely low shrinkage, dimensional accuracy, combined with excellent mechanical properties
- Nice matte surface finish that helps concealing the printed layers for optimum appearance



\* Please see our website for latest options and colors available.



### PRIMASELECT™ PLA PRO

PrimaSelect™ PLA PRO is the next generation of high performance PLA for demanding industrial applications. Designed to be able to print fast >120mm/s so you can save on production time. Very high heat resistance (95°C+) after annealing. Excellent mechanical properties combined with a matte surface finish that helps concealing the printed layers for optimum appearance.

### COLORS AVAILABLE



### CONTACT INFORMATION:

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[www.primafilaments.com](http://www.primafilaments.com)

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### INFORMATION:

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#### Print Faster

Print fast with PrimaSelect™ PLA PRO! Especially designed for printing fast >120mm/s. Increased printing speed means that you can cut down on your printing time and save valuable hours. When printing fast you need a print temperature set to 240°C ± 10°C to keep good flow.

#### More heat

Higher print temperature also means that our PLA PRO withstands more heat after your print is ready. Even more so if you post process your print by annealing it.

#### Annealing your print (Bake it!)

Make your print even better! To get even better strength and higher heat resistance you can anneal your print. This procedure means that you heat the printed part in your oven, preferably on a piece of aluminum sheet. Pre-heat the oven to 110°C and hereafter bake the parts for 30 - 60 min. Turn off the oven and let it cool down to normal room temperature with the prints still in it. Take out your improved prints afterwards.

Normally filament shrinks (3 - 5%) during this process but with our formula we are down to about 0,27%.

#### Easy to print

As easy as ordinary PLA to print with. If you have a heated bed we recommend you set it to 55°C ± 10°C. Sticks well to most print beds but as always some adhesive or special build plate is always good, we recommend BuildTak or a PEI sheet. When printing fast you need to use a higher temperature (120mm/s 240°C ± 10°C) and when you go to lower speeds, a lower temperature is sufficient (around 50mm/s 220°C ± 10°C)

#### Say goodbye to ABS

With PrimaSelect™ PLA you get the advantages of ABS but you don't get the smell and shrinkage problems.

### Dimensions

Size:	Ø tolerance	Roundness
1,75 mm	± 0,05 mm	≥ 95 %
2,85 mm	± 0,10 mm	≥ 95 %

### Physical properties

Description:	Testmethod	Typical value
Specific gravity	ISO 1183	1,27g/cc
MFI 210°C / 2,16kg	ISO 1133	6 g/10 min*
Tensile strength	ISO 527	39 MPa
Elongation at break	ISO 527	58%
Tensile modulus	ISO 527	3900 MPa
Impact strength – Charpy notched 23°C	ISO 179	22 KkJ/m²

### Thermal properties

Description:	Testmethod	Typical value
Printing temp.		50mms Speed - 220°C ± 10°C 120mms Speed - 240°C ± 10°C
Printbed Temperature	Recommended	55°C ± 10°C
Melting temp.		190 - 220°C
Heat Deflection temp. (B) (after annealing)	ISO 75	95°C+

Reseller: