



Technical specification

Everfil™ PLA-wood

DESCRIPTION

Everfil PLA-wood is a filament, like other filaments from the Natural Fibers series, it is filled with about 20% fiber and wood powder. Everfil PLA-wood is a very easy to print material, it does not require any special conditions.

The main advantages of the Wood filament are, for example:

First of all, its appearance, structure and smell resemble real wood. Secondly, a large filling with wood particles gives a spectacular effect on the printed detail. Everfil PLA-wood is very easy to print: it does not shrink or curl, it offers excellent fiber flow. It is characterized by excellent adhesion of the first layer, as is the case of adhesion between layers. In addition, it can be printed at high speeds

Application:

- great for prototyping
- production of end-use components
- production of non-standard components
- for printing items with varying levels of detail
- for printing biodegradable jewelry, figurines, toys and others

TYPICAL PROPERTY VALUES

Filament	Nominal Value	Unit	Test Method
Filament diameter	1,75 , 2,85	mm	-
Diameter tolerance	+/- 0,03	mm	-
Spool weight	1,0 , 3,0 , 5,0	kg netto	-

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1,20	g/cc	D792
MFR	-6,5	g/10min	ASTMD1238
Clarity	Non transparent		

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	39	N/mm2	ISO 527
Tensile Modulus	3600	N/mm2	ISO 527
Notched Izod Impact/amorphous/	160	J/m	D256
Strain (tensile)	4	%	ISO 527
Fiber containe	20	%	
Impact Strenght, Charpy	20	Kj/m2	ISO 179/1eU
Heat Deflection Temp.	67 psi (0.45 MPa)	°C	ASTME2092



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PRINT CONDITIONS

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(may be different for different printers)

3D Printers	Typical Value	Unit
Extruder temperature	190-225	°C
Bed temperature (if needed)	45-60	°C
Printing speed	40-130	mm/s
Print cooling	60-100	%
Retraction	± 5	mm
Nozzle diameter	≥ 0.5	mm

STORAGE

Filament can't handle moisture very well and that is why we recommend storing your filament in a cool, dry environment, ideally in a package vacuum sealed with silicate.

