

FGF PLA Stone

FGF PLA Stone contains ~50% stone powder. The material is heavier than normal PLA and shows a nice matte finish. FGF PLA Stone shows excellent print results. It gives the feeling of real stone, because of the higher weight of the material.

Material features:

- Matt surface finish
- Stone look
- Heavier than normal PLA
- Based on PLA



Colours:

Colours on request. Ask your accountmanager.

Packaging:

FGF PLA Stone is available in 20kg bag

Processing recommendations

Drying	8hr, 50°C*. <250ppm
Zone 1 Temperature	160±20 °C
Zone 2 Temperature	175±20 °C
Zone 3 Temperature	185±20 °C
Mass temperature	197 °C
Die temperature	195±20 °C

Material properties

Description	Testmethod	Typical value
Specific gravity	ISO 1183	1,7 g/cc
MFR 200°C/5 kg	ISO 1133	5,6 g/10min
Tensile Strength at Yield	ISO 527	44 Mpa
Tensile Strength at Break	ISO 527	44 Mpa
Elongation-Strain at Yield	ISO 527	1,7%
Elongation-Strain at Break	ISO 527	1,8%
Tensile modulus	ISO 527	6365 Mpa
Impact strength - Charpy notched 23°C	ISO 179	3,1 kJ/m2
Vicat softening temperature	ISO 306	57,7°C
Mold shrinkage	internal method (ISO 294-4 based)	N/A

Additional info:

*As PLA materials crystallize, it is advised to either have an agitated dryer, or dry at a lower temperature for a longer period. This avoids that the pellets stick to each other during drying.

The stone is mildly abrasive. Please consider the use of a hardened steel nozzle and, if used, a gear pump, when printing with FGF PLA Stone. The stone powder is mildly abrasive and can result in faster wear of brass nozzles.

Storage: Cool and dry (15-25°C) and away from UV light. This enhances the shelf life significantly.

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