



# Bilby 3D

## **MATERIAL DATA SAFETY SHEET**

Issued in Australia by Bilby 3D Pty Ltd.

The attached Material Data Safety Sheet has been prepared by the manufacturer outside Australia.

In accordance with Australia WHS regulations the following Australian contact details apply

### **Section 1: AUSTRALIAN COMPANY DETAILS**

In Australia the product is imported and distributed by:  
Bilby 3D Pty Ltd

Mailing Address :

Kingsgrove Business Centre, 7/192 Kingsgrove Rd, Kingsgrove NSW 2208

Head Office Address :

Kingsgrove Business Centre, 7/192 Kingsgrove Rd, Kingsgrove NSW 2208

Contact Phone: 1800 847 333

### **Section 2: AUSTRALIAN EMERGENCY CONTACT**

#### **Emergency Contact**

In the event of an emergency please contact:

Poisons Information Centre 24 hour Telephone Advice Line on 13 11 26

### **Section 3: AUSTRALIAN ISSUE DATA**

**Date of Issue** : 1 March 2020

# Technical Data Sheet

# Ultrafuse PLA PRO1

Date / Revised: 06.11.2020

Version No.: 3.3

## General information

### Components

Polylactic acid blend based filament for Fused Filament Fabrication.

### Product Description

PLA PRO1 is an extremely versatile tough PLA filament made for professionals. It reduces your printing time by 30% – 80%, (subject to printer and object limitations) and the strength exceeds overall mechanical properties of printed ABS parts. Printer settings can be tuned to achieve blazing fast speeds or an unrivaled surface finish. The excellent quality control ensures the highest levels of consistency between colors and batches, it will perform as expected, every time.

### Delivery form and warehousing

Ultrafuse PLA PRO1 filament should be stored at 15 - 25°C in its originally sealed package in a clean and dry environment. If the recommended storage conditions are observed the products will have a minimum shelf life of 12 months.

### Product safety

Recommended: Process materials in a well ventilated room, or use professional extraction systems. For further and more detailed information please consult the corresponding material safety data sheets.

### Notice

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

### Recommended 3D-Print processing parameters

Nozzle Temperature	200 – 220 °C / 392 – 428 °F
Build Chamber Temperature	-
Bed Temperature	50 – 70 °C / 122 – 158 °F
Bed Material	Glass, tape at low temperatures
Nozzle Diameter	≥ 0.4 mm
Print Speed	40 - 150 mm/s

### Drying Recommendations

Drying recommendations to ensure printability	PLA is in a printable condition, drying is not necessary
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### General Properties

Standard

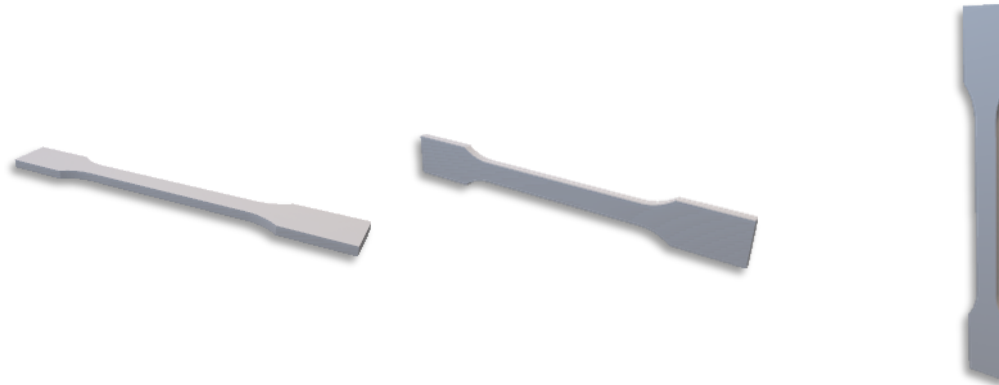
Printed Part Density	1250 kg/m <sup>3</sup> / 78.0 lb/ft <sup>3</sup>	ISO 1183-1
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### Thermal Properties

Standard

Glass Transition Temperature	63.0 °C / 145 °F	ISO 11357-2
Melting Temperature	170 – 180 °C / 338 – 356 °F	ISO 11357-3
Melt Volume Rate	18.2 cm <sup>3</sup> /10 min / 1.1 in <sup>3</sup> /10 min (210 °C, 2.16 kg)	ISO 1133

## Mechanical Properties



Print direction	Standard	XY Flat	XZ On its edge	ZX Upright
Tensile strength	ISO 527	48.0 MPa / 7.0 ksi	-	21.8 MPa / 3.2 ksi
Elongation at Break	ISO 527	21.9 %	-	0.9 %
Young's Modulus	ISO 527	3166 MPa / 459 ksi	-	2930 MPa / 425 ksi
Flexural Strength	ISO 178	92.4 MPa / 13.4 ksi	99.1 MPa / 14.4 ksi	-
Flexural Modulus	ISO 178	2823 MPa / 409 ksi	2340 MPa / 339 ksi	-
Flexural Strain at Break	ISO 178	4.3 %	4.4 %	-
Impact Strength Charpy (unnotched)	ISO 179-2	20.4 kJ/m <sup>2</sup>	18.8 kJ/m <sup>2</sup>	-