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Technical Data Sheet

InnoFR by Innofil3D BV

Filament suitable for all commercially available leading brands 3D FDM/FFF printers

IDENTIFICATION OF THE MATERIAL	
Trade name	InnoFR Flame Retardant PLA
Chemical name	Polylactic Acid compound
Chemical family	Thermoplastic copolymer
Use	3D-Printing
Origin	Innofil3D BV

GUIDELINE FOR PRINT SETTINGS	
Nozzle temperature	210 ± 10 °C
Bed temperature	60 – 75 °C
Bed modification	Heated bed or tape.
Active cooling fan	Yes (up to 100%).
Layer height	0.08 – 0.2 mm
Shell thickness	0.8 – 2.0 mm
Print speed	40 – 80 mm/s

Settings are based on a 0.4 mm nozzle

MATERIAL PROPERTIES		Test Method
Melt temperature (Tm)	145 – 160 °C	ASTM D3418
Glass transition temperature (Tg)	Approx. 60 °C	ASTM D3418
Melt Flow Rate (MFR)[1]	Not determined.	ISO 1133
Melt Volume Rate (MVR)[1]	Not determined.	ISO 1133
Density (ρ)	1.24 g/cm^3	ASTM D1505
Odor	Odorless	/
Solubility	Insoluble in water	/
UL 94 classification	94V-0	ASTM D3801 ISO 1210

[1]Test conditions: T=210°C; m=2.16kg

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FILAMENT SPECIFICATIONS		Test Method
Diameter 1.75	1.75 ± 0.05 mm	Innofil3D
Diameter 2.85	2.85 ± 0.10 mm	Innofil3D
Max. roundness deviation 1.75	0.05 mm	Innofil3D
Max. roundness deviation 2.85	0.10 mm	Innofil3D
Net weight on reel	750 g ± 2%	Innofil3D

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