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.