

ePLA-Gloss

Technical Data Sheet

ePLA is a PLA material with high cost-effective ,environmentally friendly,easy to print.Compared with ABS, ePLA has higher rigidity and strength similar to PC, no need to close the cavity, low shrinkage rate, no warping, no cracking, and can print large size model;Compared with other materials, the support is easier to remove from the model, and the surface of the printed model is smooth and flat;No pungent smell when printing, safe and environmental friendly;The spool is made of plastic injection molding based on production waste and industrial waste such as PETG, ABS and PLA. The outer box is made of recyclable paper box. The concept of environmental friendly makes 3D printing more sustainable.Shinny and smooth surface;The filament is hard to break, long time printing smooth without plug, can be used for conceptual model, rapid prototyping.

Material Status	Mass Production
Characteristics	<ul style="list-style-type: none"> • Green and environment-friendly • High cost -effective • High speed printing • The support is easy to remove • Easy to print • Hard to break
Applications	<ul style="list-style-type: none"> • Decoration • COSPLAY
Form	<ul style="list-style-type: none"> • Filament
Processing method	<ul style="list-style-type: none"> • 3D Print, FDM Print

	testing method	Typical value
Physical Properties		
Density	GB/T 1033	1.26 g/cm ³
Melt Flow Index	GB/T 3682	3.3 (190°C/2.16kg)
Mechanical Properties		
Tensile Strength	GB/T 1040	64.51 MPa
Elongation at Break	GB/T 1040	31.54 %
Flexural Strength	GB/T 9341	68.99 MPa
Flexural Modulus	GB/T 9341	1514 MPa
IZOD Impact Strength	GB/T 1843	7.9 kJ/m ²
Thermal Properties		
Heat distortion Temperature	GB/T 1634	N/A
Continuous Service Temperature	IEC 60216	N/A
Maximum (short term) Use Temperature		N/A
Electrical Properties		
Insulation Resistance	DIN IEC 60167	N/A
Surface Resistance	DIN IEC 60093	N/A

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Recommended printing parameters

Extruder Temperature	190 - 230°C
Build Platform Temperature	60°C
Fan Speed	100%
Printing Speed	40 - 100mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2. Printing conditions may vary with different nozzle diameters

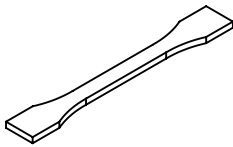
Drying Recommendations

N/A

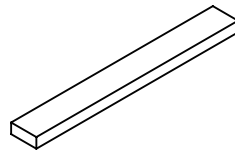
Precautions:

When slicing, it is best to turn on the Z seam alignment and starting point alignment functions, turn off the Z-axis lift and exit, avoid passing through the shell when idling, optimize the slicing printing path, and appropriately reduce the printing speed to achieve the best printing effect.

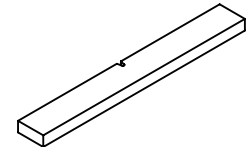
Mechanical Properties



Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1043

The physical properties, mechanical properties, thermal properties, and electrical properties of the line are obtained based on the injection molding spline test.

Print test condition:

Extruder Temperature	190-230°C
Build Platform Temperature	45°C
Outline/Perimeter Shells	4
Top/Bottom Layers	4
Infill Percentage	20%
Fan speed	100%
Printing speed	40mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2.

Notice

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