

**Technical Data for Tiertime PLA Material****6/30/2020**

Filament Name	Tiertime PLA			
Weight	500g/700g/1kg	Price (kg)		
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#	Properties	Testing Methods	Unit	Value
1	Density	ISO 1183	g/cm ³	1.23
2	Mold Shrinkage	ASTM D955	%	0.4
3	Melt Flow Index	ASTM D1238 ISO 1183	g/10min	6
4	Melt Viscosity	ASTM D3825		
5	Rockwell hardness	ASTM D785		89
6	Tensile Yield Strength	ASTM D638	MPa	60
7	Tensile Breaking Strength	ASTM D638	MPa	60
8	Elongation at Break	ASTM D638	%	6
9	Elongation at Yield	ASTM D638	%	6
10	Tensile Modulus	ASTM D638	MPa	1800
11	Flexural Strength	ASTM D790	MPa	90
12	Flexural Modulus	ASTM D790	MPa	3000
13	Izod Impact Strength	ASTM D256	KJ/m ²	4
14	Vicat Softening Point	ASTM D1525	°C	65
15	Flammability	UL94-2013	1.6 mm	V2
16	Heat Deflection Temperature	ASTM D648	°C	60