

alzament

Alzament Filament

Technical Data Sheet V1.0

PLA Chameleon

· Basic Info

Alzament PLA Chameleon is made by adding high-grade glitter powder and chameleon powder through special processing, with a glittering texture on the surface; the color changes at different angles, and the powder particles are blue.

· Specifications

Subjects	Data
Diameter	1.75 mm
Net Filament Weight	1 kg
Filament Length	330m
Tolerance	±0.02mm

· Recommended Printing Settings

Subjects	Data
Nozzle temperature	190-230(°C)
Build surface material	Glass, PEI Film or Coating with PVP glue
Build plate temperature	45-60(°C)
Cooling fan	on
Printing speed	40-100 (mm/s)
Raft separation distance	0.2 (mm)
Retraction distance	3 (mm)
Retraction speed	40mm/s

• Properties

Alzament has tested the differing aspects in the performance of PLA-CF material, including physical and chemical properties. Typical values are listed as followed:

Physical Properties		
Subjects	Testing Methods	Data
Density	ISO 1183,GB/T1033	1.21 g/cm ³
Melt Index	220 °C, 2.16 kg	3.7±0.6 g/10 min
Light transmission	N/A	N/A
Flame retardancy	N/A	N/A

Mechanical Properties		
Subjects	Testing Methods	Data
Flexural Strength	GB/T 9341	115.6 MPa
Flexural Modulus		3303 MPa
Tensile strength (X-Y)	ISO 527, GB/T 1040	26.1 MPa
Tensile strength (Z)		26.1 MPa
Elongation at break	ISO 527, GB/T 1040	3.9 %
Heat distortion Temperature	GB/T 1634	52°C
Surface Resistance	DIN IEC 60093	N/A
IZOD Impact strength	GB/T 1843	3KJ/m ²

• Additional Suggestions

1. The wear resistance of copper nozzle is poor. It is recommended to use stainless steel or hardened steel nozzle to print, which can effectively improve the printing quality.

2. Please put filament into a dry box, which can effectively reduce the oozing, rough surface and so on.

• Disclaimer

The performance values are tested by standard samples at Alzament, and the values are for design reference and comparison only. Actual 3D printing model performance is related to many other factors, including printers, printing conditions, printing models, printing parameters, etc.

In the process of using Alzament 3D printing filaments, users are responsible for the legality, safety, and performance indicators of printing. Alzament is not responsible for the use of materials and scenarios and is not responsible for any damage that occurs in the process of using our filaments.

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