version 1.0
08/2024

Technical Data Sheet (TDS)

Silk PLA Tri-Color

Eryone-Silk PLA Tri-Color is a product made by co-extruding three different colored silk filaments from a single nozzle. The printed model surface can present a dazzling and silky texture, and the gradient effect can be observed from different angles, providing a more stunning visual experience. By adjusting the nozzle temperature and printing speed, the glossiness of the model surface can be controlled. A higher printing temperature or lower printing speed can make the model display a stronger glossiness.

Part I: Suggests Printing Parameters

Parameter	Set up
Nozzle temperature	190-220 ℃
Bed temperature	55-70℃
Bed material	glass, PEI, spring steel plate
Bottom printing temperature	190-220℃
Sealed printing	supports open printing, and the sealing effect is better if it is sealed
Printing speed	30-100mm/s
Drying conditions	50-60℃, 6h

Part II: Physical Properties of Materials

Property	Testing Method	Unit	Typical Value
Density(g/cm³ at 21.5 ° C)	ASTM D792 (ISO 1183, GB/T 1033)	g/cm³	1.32
Vicat Softening Temperature(° C)	ASTM D1525 (ISO 306 GB/T 1633)	℃	56
Heat distortion temperature(° C)	ASTM D648 0.45MPa	℃	53
Glass transition temperature (° C)	DSC, 10 ° C/min	℃	63
Melt Index(g/10 min)	220 ° C, 10kg 240 ° C, 2.16 kg	g/10min	20.5±1.5

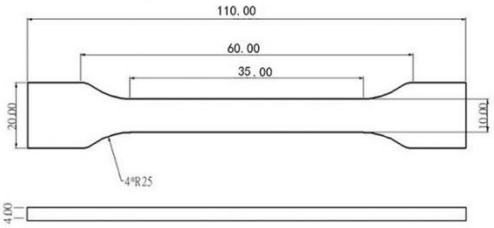
Part III: Mechanical Properties of Printed Samples

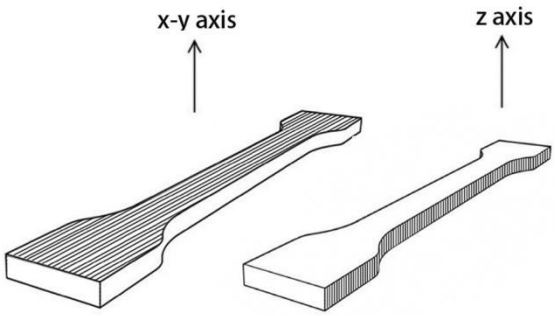
Property	Test conditions	Test standards	unit	Typical Value
Tensile strength X-Y	50mm/min	GB/T 1040.4	MPa	49.8
Tensile modulus X-Y	50mm/min	GB/T 1040.1-2006	MPa	1724.9
Elongation at break X-Y	50mm/min	GB/T 1040.4	%	1.7
Tensile strength X-Z	50mm/min	GB/T 1843	MPa	12
Tensile modulus X-Z	50mm/min	GB/T 1040.1-2006	MPa	1653.5
Elongation at breakX-Z	50mm/min	GB/T 1040.4	%	1.1
Bending strength	2mm/min	GB/T 9341	MPa	66.7
Bending modulus	2mm/min	GB/T 9341	MPa	2315.5
Charpy Impact strenght	2.75J	GB/T 1043.1-2008	kJ/m2	7.5

Note: All splines are printed under the following conditions: printing temperature=210 ° C, printing speed=80mm/s, base plate 60 ° C, filling=100%, nozzle diameter=0.4mm

TENSILE TESTING SPECIMEN

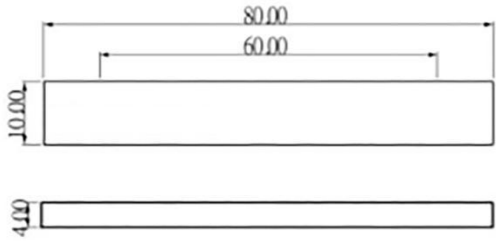
ISO 527,GB/T 1040

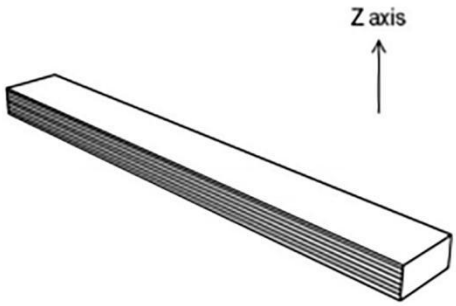




FLEXURAL TESTING SPECIMEN

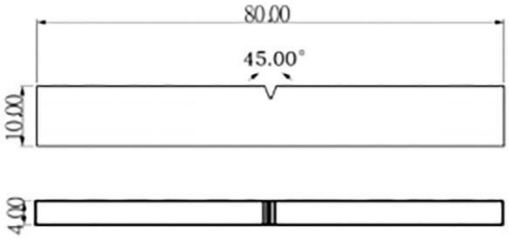
ISO 178,GB/T 9341

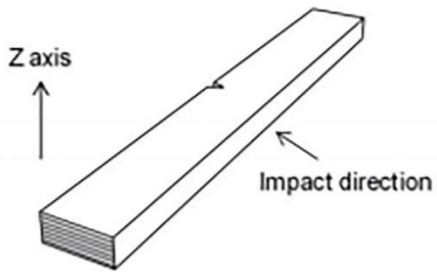




IMPACT TESTING SPECIMEN

ISO 179,GB/T 1043





Disclaimers

The values given in this data table are for reference and comparison only. They should not be used for design specifications or quality control. The actual value may vary depending on the printing conditions. The final performance of printed components depends not only on the material, but also on the component design, environmental conditions, printing conditions, and so on. Product specifications are subject to change without prior notice.