

Date of issue: October 27 , 2022  
Version: v1.0

WoodFill is a blend of PLA/PHA and specifically sourced woodfibres. The added recycled woodfibres in this blend make this a unique 3D printing filament. Your prints will look amazing and your 3d printer cave will smell like a woodshop!

**TYPICAL MATERIAL PROPERTIES – 3D Printed**

<b>Physical properties</b>	<b>Unit</b>	<b>Value</b>	<b>Method</b>
Tensile modulus	MPa	2478,86	ISO 527
Yield strength	MPa	28,36	ISO 527
Yield strain	%	2,03	ISO 527
Tensile strength	MPa	28,36	ISO 527
Tensile strain at tensile strength	%	2,03	ISO 527
Tensile stress at break	MPa	25,90	ISO 527
Tensile strain at break	%	4,50	ISO 527
Charpy unnotched impact strength	kJ/m2	12,28	ISO 179-1/1 eU
Charpy notched impact strength	kJ/m2	3,81	ISO 179-1/1 eU

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#### TYPICAL MATERIAL PROPERTIES – Injection molded

Physical properties	Unit	Value	Method
Density	g/cm <sup>3</sup>	1,15	ISO 1183
Modulus of elasticity	MPa	3290	ISO 527
Tensile strength	MPa	46	ISO 527
Tensile strain at tensile strength	%	4,8	ISO 527
Tensile stress at break	MPa	42	ISO 527
Tensile strain at break	%	5,5	ISO 527
Flexural modulus	MPa	3930	ISO 178
Flexural strain at break	%	5	ISO 178
Flexural stress at 3.5% strain	MPa	70	ISO 178
Notched impact strength (Charpy), RT	kJ/m <sup>2</sup>	4,2	ISO 179-1/1 eA
Impact strength (Charpy), RT	kJ/m <sup>2</sup>	19,0	ISO 179-1/1 eU
Melting temperature	°C	>155	ISO 3146-C

#### FILAMENT SPECIFICATION

Nominal diameter:	Diameter tolerance	Ovality
1,75 mm	± 0,05	≥ 95%
2,85 mm	± 0,10	≥ 95%

**Netto filament weight** 600g

#### GUIDELINE FOR PRINT SETTINGS

Nozzle temperature	195 - 220°C
Bed temperature	50 - 60°C
Bed surface / modification	-
Active cooling fan	100%
Print speed	40-100 mm/s

#### Notes

The reported properties are an average of a batch of 3D printed specimens. The specimens have been printed in XY plane, using 0.15mm layerheight, 100% infill, 0.4mm nozzle, 210°C nozzle temperature and 55°C bed temperature.

#### Disclaimer

The product- and technical information provided in this datasheet is correct to the best of our knowledge. The information given is provided as a guidance for good use, handling and processing and is not to be considered as a quality specification. The information only relates to the specific product and the material properties.