1.75mm ±0.03mm— Pure White/ Milk White/ Carbon Black

HIGH TEMP PLA

The printing parameters of QTS High-Temperature PLA are the same as common PLA. The specially engineered QTS HT-PLA allows the user to produce high quality 3D printed models effortlessly with little warpage.
The enhanced thermal and mechanical properties of the QTS HT-PLA can be achieved with a short 10 minutes post-print heat treatment (Annealing). The HDT of QTS HT-PLA can be up to 137°C (282°F). That is significantly higher than the common PLA (55°C/131°F) on the market. In comparison to the HDT of ABS, the QTS HT-PLA HDT is 37°C (70°F) higher (137°C vs 100°C).
The superior characteristics of the QTS HT-PLA, (ease of printing, minimal warpage, high heat resistance,) can expand its uses in demanding applications that common PLA has not been able to meet.

TYPICAL MATERIAL PROPERTIES

Rev 1.4

Physical properties	Unit	Value	Method	Remark
Tensile strength	Kgf/cm2	502	ASTM D638	No Heat Treated
		554.6		25°C 50%RH
		420.6		70°C 50%RH
		331.9		130°C 15hr
Elongation	%	31.3	ASTM D638	No Heat Treated
		1.6		25°C 50%RH
		1.3		70°C 50%RH
		0.8		130°C 15hr
Charpy unnotched impact strength	kJ/m2	12.3	ISO 179-1/1 eU	
Charpy notched impact strength		2.58		
		12.8		No Heat Treated
Heat Deflection Temperature	°C	85	ASTM D648-07	No Heat Treated
		137		10-minute annealimg at 120°C (248°F)

※The enhanced thermal and mechanical properties of the QTS HT-PLA can be achieved with a short 10 minutes post-print heat treatment (Annealing) at 120°C (248°F). The HDT of QTS HT-PLA can be up to 137°C (282°F).

PRINT SETTING(Based on zortrax M200 Plus Profile)

Setting	Unit	Value
Nozzle Temperature	°C	200 ~ 220
Heated Bed Temperature	°C	50 ~ 60
Print Speed	mm/s	40 ~ 70 mm/s
Nozzle Diameter	mm	0.4
Layer Thickness	mm	0.14
Flow Rate/Extrusion Multiplier	%	100
Extruder Flow Ratio	%	0 ~ 10