

## Technical Data Sheet

# PolyLite™ PLA

[www.polymaker.com](http://www.polymaker.com)

V5.0



PolyLite™ PLA is a high-quality PLA designed for reliability and ease of printing.

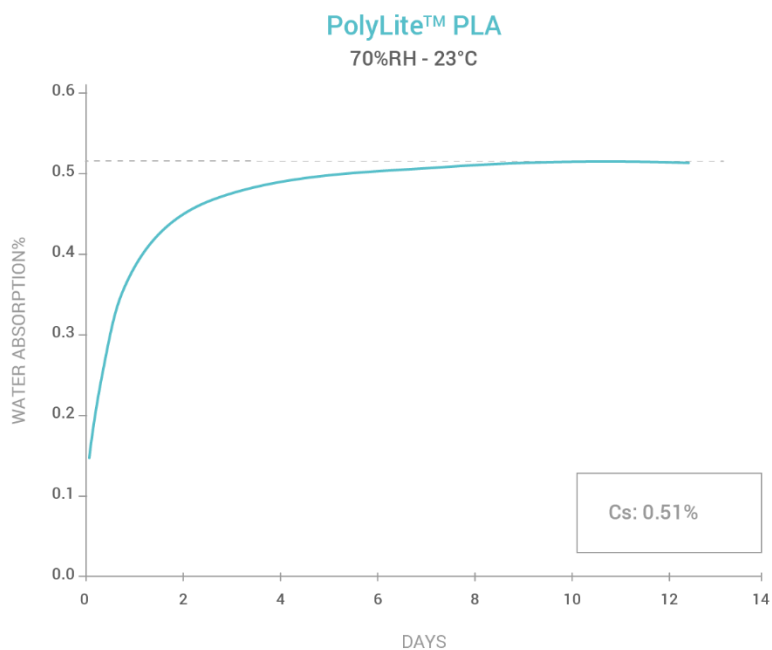
## PHYSICAL PROPERTIES

Property	Testing Method	Typical Value
Density	ISO1183, GB/T1033	1.17 g/cm <sup>3</sup> at 21°C
Melt Index	210°C, 2.16kg	7-10 g/10min
Light Transmission	N/A	N/A
Flame retardancy	UL94	V2

## CHEMICAL RESISTANT DATA

Property	Testing Method
Effect of weak acids	Not Resistant
Effect of strong acids	Not Resistant
Effect of weak alkalis	Not Resistant
Effect of strong alkalis	Not Resistant
Effect of organic solvent	No data available
Effect of oils and grease	No data available
Effect of Sunlight	No data available

## MOISTURE ABSORPTION CURVE

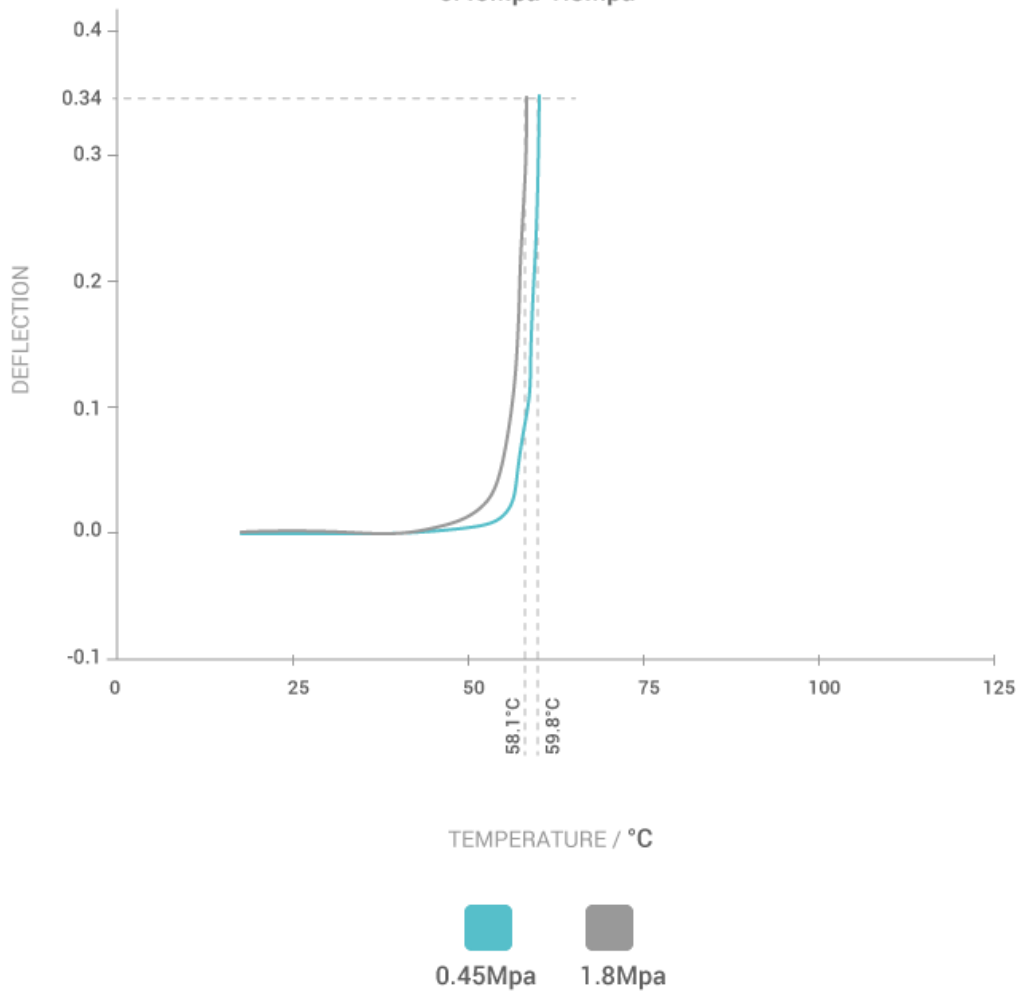


## THERMAL PROPERTIES

Property	Testing Method	Typical Value
Glass transition	DSC, 10°C/min	61 °C
Melting temperature	DSC, 10°C/min	150 °C
Crystallization temperature	DSC, 10°C/min	113.5 °C
Decomposition temperature	TGA, 20°C/min	N/A
Vicat softening temperature	ISO 306 GB/T 1633	62.9 °C
Heat deflection temperature	ISO 75 1.8MPa	58.1 °C
Heat deflection temperature	ISO 75 0.45MPa	59.8 °C
Thermal conductivity	N/A	N/A
Heat shrinkage rate	N/A	N/A

### HDT CURVE

PolyLite™ PLA  
0.45Mpa-1.8Mpa



## MECHANICAL PROPERTIES

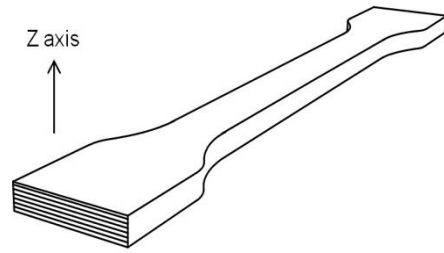
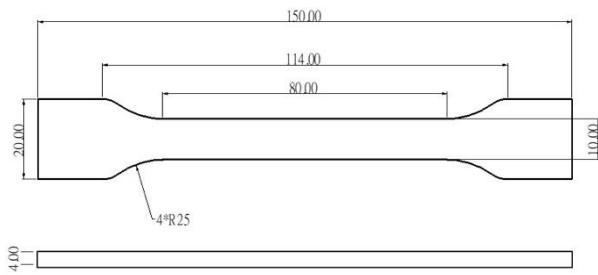
Property	Testing Method	Typical Value
Young's modulus (X-Y)	ISO 527, GB/T 1040	2636 ± 330 MPa
Young's modulus (Z)		N/A
Tensile strength (X-Y)	ISO 527, GB/T 1040	46.6 ± 0.9 MPa
Tensile strength (Z)		43.5 ± 3.1 MPa
Elongation at break (X-Y)	ISO 527, GB/T 1040	1.90 ± 0.21 %
Elongation at break (Z)		N/A
Bending modulus (X-Y)	ISO 178, GB/T 9341	3283 ± 132 MPa
Bending modulus (Z)		N/A
Bending strength (X-Y)	ISO 178, GB/T 9341	85.1 ± 2.9 MPa
Bending strength (Z)		N/A
Charpy impact strength (X-Y)	ISO 179, GB/T 9343	2.68 ± 0.16 kJ/m <sup>2</sup>
Charpy impact strength (Z)		N/A

## HOW TO MAKE SPECIMENS

Printing temperature	205 °C
Bed temperature	45 °C
Shell	2
Top & bottom layer	4
Infill	100%
Environmental temperature	25 °C
Cooling fan	ON

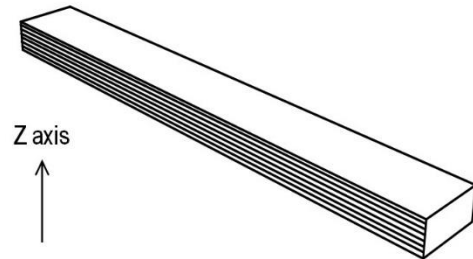
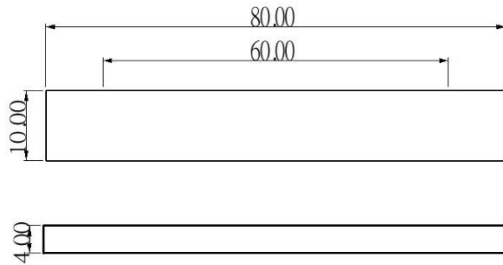
## TENSILE TESTING SPECIMEN

ASTM D638 (ISO 527, GB/T 1040)



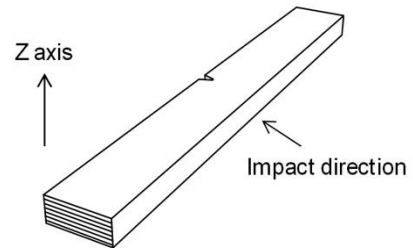
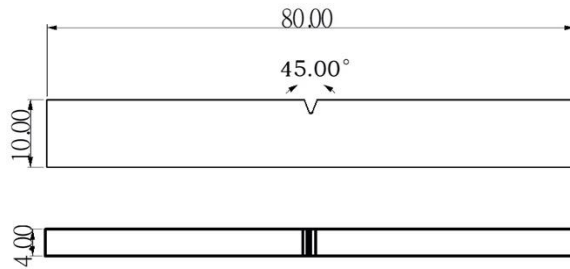
## FLEXURAL TESTING SPECIMEN

ASTM D638 (ISO 527, GB/T 1040)



## IMPACT TESTING SPECIMEN

ASTM D638 (ISO 179, GB/T 1043)



### DISCLAIMER:

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End-use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

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