

# Twinkling

## Technical Data Sheet

This material is based on PLA material which bring it not only with characteristic of easy to print as PLA but also with special glittering color.

Material Status	Mass Production
Characteristics	<ul style="list-style-type: none"> <li>• Special glittering color.</li> <li>• Easy to print as PLA.</li> </ul>
Applications	<ul style="list-style-type: none"> <li>• Toys</li> <li>• Decoration</li> </ul>
Form	<ul style="list-style-type: none"> <li>• Filament</li> </ul>
Processing method	<ul style="list-style-type: none"> <li>• 3D Print, FDM Print</li> </ul>

	testing method	Typical value	
Physical Properties			
Density	GB/T 1033	1.41	g/cm³
Melt Flow Index	GB/T 3682	2.5	190°C/2.16kg
Mechanical Properties			
Tensile Strength	GB/T 1040	58	MPa
Elongation at Break	GB/T 1040	N/A	%
Flexural Strength	GB/T 9341	70	MPa
Flexural Modulus	GB/T 9341	2100	MPa
IZOD Impact Strength	GB/T 1843	4	kJ/m²
Thermal Properties			
Heat distortion Temperature	GB/T 1634	67	°C
Continuous Service Temperature	IEC 60216	N/A	
Maximum (short term) Use Temperature		N/A	
Electrical Properties			
Insulation Resistance	DIN IEC 60167	N/A	
Surface Resistance	DIN IEC 60093	N/A	

Wuhan University Building A403-I,A901,No.6 Yuexing 2 Road,Nanshan District,Shenzhen,Guangdong

China

Tel +86 755 86581960

fax +86 755 26031982

Email: bright@brightcn.net

www.esun3d.net

### Recommended printing parameters

Extruder Temperature	200- 230°C
Build Platform Temperature	45-60°C
Fan Speed	100%
Printing Speed	40 - 100mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2. Printing conditions may vary with different nozzle diameters

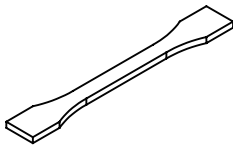
### Drying Recommendations

N/A

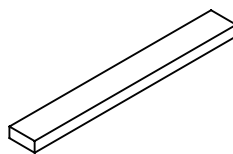
### Precautions:

The material is not easy to bend as the strong rigidity. Try to avoid any bending in feeding.

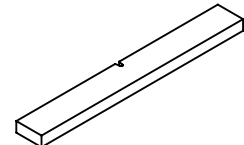
### Mechanical Properties



Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1043

The physical properties, mechanical properties, thermal properties, and electrical properties of the line are obtained based on the injection molding spline test.

### Print test condition :

Extruder Temperature	190-230°C
Build Platform Temperature	45°C
Outline/Perimeter Shells	4
Top/Bottom Layers	4
Infill Percentage	20%
Fan speed	100%
Printing speed	40mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2.

### Notice

All information supplied by or on behalf of eSUN in relation to this product, whether in the nature of data, recommendations or otherwise, is supported by research and, in good faith, believed reliable, but the product is sold "as is". eSUN assumes no liability and makes no representations or warranties, express or implied, of merchantability, fitness for a particular purpose, or of any other nature with respect to information or the product to which information refers and nothing herein waives any of the seller's conditions of sale.