

FilaPrint Bronze

The FilaPrint 80% bronze filled PLA based filament is pretty easy to print, sand & polish. With FilaPrint PLA Bronze you can create the most beautiful objects with real METAL characteristics, with 3 x higher weight than PLA, plus a METAL feel & touch and thermo-conductivity and due to the high percentage of fillers FilaPrint Bronze has virtually no shrinkage. A special lubricant increases the flow and prevents FilaPrint Bronze adhering to the nozzle.

Finally all above benefits combined with the correct hardness results in a filament that can be printed on almost every type of FDM 3d printer available on the market with retraction enabled on nozzles $\geq 0.35\text{mm}$.

Features:

Approx. 80% bronze content • PLA-based, 3 times heavier
Metal feel & “cold” touch

Excellent printability on both direct & Bowden style 3D printers

Processing additive added for easy & reliable printing



Printed

Sanded & Polished

Patinated

Quick & easy polishing and other post-processing

Possibility to print with retraction

Works on nozzles $\geq 0.35\text{ mm}$

Filament specs.

Size	Ø tolerance	Roundness
1,75mm	$\pm 0,05\text{mm}$	$\geq 95\%$
2,85mm	$\pm 0,10\text{mm}$	$\geq 95\%$

Material properties

Description	Testmethod	Typical value
Specific gravity	ISO 1183	3,39 g/cc
MFR 190°C/2,16 kg	-	n.a.
Tensile strength at yield	ISO 527	18,3 Mpa
Strain at break	ISO 527	8,0%
Tensile Modulus	ISO 527	3990 Mpa
Impact strength - Izod method 23°C	ISO 180/A	11,3 kJ/m ²
Printing temp.	DF	195-220°C
Melting temp.	ISO 294	195°C \pm 10°C
Vicat softening temp.	ISO 306	65°C

Additional info:

FilaPrint PLA Bronze can be printed without a heated bed, if you do have a heated bed the recommended temperature is $\pm 35\text{-}60^\circ\text{C}$. Storage: Cool and dry ($15\text{-}25^\circ\text{C}$) and away from UV light. This enhances the shelf life significantly. FilaPrint PLA Bronze can be used on all common desktop FDM or FFF technology 3D printers.

* Please consider the use of a hardened steel nozzle when printing with FilaPrint PLA Bronze

The bronze powder inside makes the filament abrasive and will result in fast wear of regular brass nozzles.

* Please have a look at the Printing, post-processing & other info document for further tips & tricks.