# BOUN PELLET

## TECHNICAL DATA SHEET VERSION 1.1 DATE: 01/03/2023

## BOUN

It is a completely compostable PLA-based filament, thanks to its low hardness slightly flexible parts can be printed. In addition, it stands out for providing a very soft touch in the printed piece reminiscent of materials made of rubber or latex.

Suitable for protective parts, grips or elements where it is necessary to protect from vibrations such as silentblock.



| | VALUES | UNIT OF MEASUREMENT | STANDARD |
|---|---|---|---|
| **PHYSICAL PROPERTIES** | | | |
| Chemical composition | Polylactic acid | | |
| Density | 1,24 | g/cm$^3$ | ISO 1183 |
| Fluency index (210°C/2,6 kg) | 6 | g/10 min | ISO 1133 – A |
| Melting temperature | 155 | ˚C | DSC |
| Glass transition temperature | 60 | ˚C | DSC |
| **MECHANICAL PROPERTIES** | | | |
| Tensile strength (until breakage, 23°C) | 45 | MPa | ISO 527 – 1 |
| Traction module | 3500 | MPa | ISO 527 – 1 |
| Elongation at break | ≤ 5 | % | ISO 527 – 1 |
| Charpy Impact Force (notch, 23°C) | ≤ 5 | kJ/m$^2$ | ISO 179 |
| **THERMAL PROPERTIES** | | | |
| Thermal deflection temperature (HDT-B) | 60 | ˚C | ISO 75 – 1 |

**PROCESSING RECOMMENDATIONS** [1]

| | |
|---|---|
| Pre-drying | 4 – 6 hours at 85°C |
| Input to feed | 20 – 40˚C |
| Fade zone | 170 – 190˚C |
| Mixing zone | 190 – 210˚C |
| Nozzle or outlet | 190 – 210˚C |

| SIZE | NET WEIGHT | GROSS WEIGHT | COLOR | PACKING |
|---|---|---|---|---|
| S | 1 kg | 1,1 kg | Natural (yellowish) | SmartBag, security seal. |
| M | 5 kg | 5,2 kg | Natural (yellowish) | PA bag, small cardboard box. |
| L | 15 kg | 15,5 kg | Natural (yellowish) | PA bag, large cardboard box. |

NOTICE: The information provided in the data sheets is intended for reference only. It should not be used as design or quality control values. Actual values may differ significantly depending on printing conditions. The final performance of printed components not only depends on materials, design and printing conditions are also important.