

# LUMBER

LUMBER is a modified PLA based type of filament, that smells and feels like wood. The different wood-types enable us to manufacture this wide range of natural wood colours. The filament is tough enough for supplies on reels up to 2,3kg and prints very easy. We recommend a nozzle size 0,5mm or larger. We believe that this makes LUMBER one (if not the) best performing wood filaments on the market.

## Material features:

- Feels and smells like WOOD
- Easy to print at low temperature
- Very low warping
- Biodegradable
- Easily printable with  $\geq 0,5$  mm nozzle

Filament specs.		
Size	Ø tolerance	Roundness
1,75mm	$\pm 0,05$ mm	$\geq 95\%$
Material properties		
Description	Testmethod	Typical value
Specific gravity	ASTM D1505	1,20 g/cc
MFI	-	5,0 gr/10 min
Impact strength	-	7 kJ/m <sup>2</sup>
Printing temp.	DF	200 $\pm$ 10°C*
Melting temp.	ASTM D3418	145 $\pm$ 5°C
Vicat softening temp.	ISO 306	45°C

## Additional info:

Due to its low tendency to warp LUMBER can also be printed without a heated bed. If you have a heated bed the recommended temperature is  $\pm 35$ -60°C. We advise a nozzle  $\geq 0,5$ mm.

LUMBER can be used on all common desktop FDM or FFF technology 3D printers.

Storage: Cool and dry (15-25°C) and away from UV light. This enhances the shelf life significantly.