

ISO 9001:2008 Registered Quality System. Burlington, Ontario, CANADA SAI Global File: 004008

Description

The *Premium 3D Printer Filament—WOOD* is made with polylactic acid (PLA) polymer and wood.

Benefits and Features

- 1.75 mm diameter
- Low diameter variance
- Provides a wood like color and appearance
- Good moisture and chemical resistance

3D-Filament Processing Parameters

Processing Parameters	Recommendations
Working Temperature	185—230 °C [365-446 °F] ^{a)}
Bed Temperature	Not Required
Nozzle Size	≥0.5 mm ^{b)}

a) Values may vary depending on the printer type and environmental conditions. Adjust print temperatures by 5 °C until ideal flow and bed adhesion is obtained.

b) To avoid clogging of the nozzle, prefer larger nozzle sizes.

3D-Filament Properties

<i>Quality Control</i>	Method	Value
Density	ASTM D 1505	1.25 g/cm ³
Physical Properties Color Tensile Strength % Elongation Young's Modulus Optical Transmittance	Method ASTM D 882, Machine Direction " ASTM D 1003	Value Wood ^{a)} 37 N/mm ² [5 300 lb/in ²] 6% 3 100 N/mm ² [444 000 lb/in ²] 1.2%

a) Higher printing temperatures produce darker wood colors.

Thermal Properties	Method	Value
Melting Point	ASTM D 3418	130-210 °C [266-410 °F]



Storage and Shelf Life

Store between 18 to 27 °C [65 to 80 °F] and protect from direct heat or sunlight. Keep sealed in an air tight container, away from humidity.

Shelf Life	Value
Unopened package	1 y from the date of purchase
Opened package	Variable depending on storage conditions

Health and Safety

Please see the *Premium 3D Printer Filament-WOOD* **Safety Data Sheet** (SDS) for more details on transportation, storage, handling and other security guidelines.

Environmental Impact: This product doesn't have any known environmental toxicity.



This product meets the European Directive 2011/65/EU Annex II (ROHS); recasting 2002/95/EC.

Health and Safety: This product is not considered to be hazardous for human health under normal use. It is widely used in the packing and food industry.

HMIS® RATING











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WOOD

Packaging and Supporting Products

Cat. No.	Color	Diameter	Spool Weight	Filament Length	Spool Di Inner diameter	mensions Outer diameter	Width
WOOD17W5	Wood	1.75 mm	0.50 kg	170 m	32 mm	160 mm	57 mm
WOOD17W1	Wood	1.75 mm	1.0 kg	330 m	57 mm	180 mm	92 mm
WOOD30W1	Wood	2.85 mm	1.0 kg	120 m	57 mm	180 mm	92 mm
WOOD17D1	Dark wood	1.75 mm	1.0 kg	330 m	57 mm	180 mm	92 mm

Supporting Products

- 3D Printing Masking Tape, Cat. No. MAS100-15, MAS200-15
- 3D Printing Polyimide Tape, Cat. No. POL100, POL200
- Acetone, Cat. No. 434-1L, 434-4L
- d-Limonene, Pure Grade: Cat. No. 433-1L, 433-4L

Technical Support

Contact us regarding any questions, suggestions for improvements, or problems with this product. Application notes, instructions and FAQs are located at <u>www.mgchemicals.com</u>.

Email: support@mgchemicals.com

Phone: +(1) 800-340-0772 (Canada, Mexico & USA)

- +(1) 905-331-1396 (International)
- +(44) 1663 362888 (UK & Europe)
- Fax: +(1) 905-331-2862 or +(1) 800-340-0773

Mailing address:	Manufacturing & Support 1210 Corporate Drive	Heac 9347
	Burlington, Ontario, Canada	Surre
	L7L 5R6	V4N 4

Head Office 9347–193rd Street Surrey, British Columbia, Canada /4N 4E7

Warranty

M.G. Chemicals Ltd. warrants this product for 12 months from the date of purchase by the end user. *M.G.* Chemicals Ltd. makes no claims as to shelf life of this product for the warranty. The liability of *M.G.* Chemicals Ltd. whether based on its warranty, contracts, or otherwise, shall in no case include incidental or consequential damage.

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