

## WOOD@df

WOOD @df 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, even with common 0,4mm nozzles as the wood particles don't block the nozzle. We at Dutch Filaments believe that this makes WOOD @df one (if not the) best performing wood filaments on the market.

### Features:

- Feels and smells like WOOD
- Easy to print at low temperature
- Very low warping
- Biodegradable
- Easily printable with  $\geq 0,4$ mm nozzle



### Colours:

WOOD @df is available from stock in 5 different colours.



### Packaging:

WOOD @df is available in nearly any type of packaging and labelling. Ask our team to help you customizing your product.

### Additional info:

Due to its low tendency to warp WOOD @df can also be printed without a heated bed. If you have a heated bed the recommended temperature is  $\pm 35-60^{\circ}\text{C}$ . We advise a nozzle  $\geq 0,4$ mm.

WOOD @df can be used on all common desktop FDM or FFF technology 3D printers.

Storage: Cool and dry ( $15-25^{\circ}\text{C}$ ) and away from UV light. This enhances the shelf life significantly.

### Dimensions

Size	$\varnothing$ tolerance	Roundness
1,75mm	$\pm 0,05$ mm	$\geq 95\%$
2,85mm	$\pm 0,10$ mm	$\geq 95\%$

### Physical properties

Description	Testmethod	Typical value
Specific gravity	ASTM D1505	1,20 g/cc
MFI	-	5,0 g/10 min
Tensile strength	ASTM D882	70 MPa (MD) 100 MPa (TD)
Elongation at break	ASTM D882	170% (MD) 110% (TD)
Tensile modulus	ASTM D882	1900 MPa (MD) 2300 Mpa (TD)
Impact Strength	-	7,0 KJ/m <sup>2</sup>

### Thermal properties

Description	Testmethod	Typical value
printing temp.	DF	205-235°C
melting temp.	-	150° C $\pm$ 10°C
melting point	ASTM D3418	140-150°C
vicat softening temp.	ISO 306	$\pm 45^{\circ}\text{C}$