



Bambu Filament

Technical Data Sheet V3.0

PLA Metal

• Basic Info

PLA is the most common material in 3D printing as it's easy to print and inexpensive. Meanwhile, its stiffness and strength can meet most printing needs. It is worth mentioning that it can biodegrade in some artificial composting conditions. Bambu PLA Metal is a metallic textured filament designed to enhance the aesthetic of your prints. With its advanced metallic shine, this filament offers a professional and high-end finish and a touch of sophistication to your prints while retaining almost the same comprehensive performance of regular PLA.

• Specifications

Subjects	Data
Diameter	1.75 mm
Net Filament Weight	1 kg
Spool Material	ABS (Temperature resistance 70 °C)
Spool Size	Diameter: 200 mm; Height: 67 mm

• Recommended Printing Settings

Subjects	Data
Drying Settings before Printing	Blast Drying Oven: 55 °C, 8 h X1 Series Printer Heatbed: 65 - 75 °C, 12 h
Printing and Storage Humidity	< 20% RH (Sealed with desiccant)
Nozzle Size	0.2, 0.4, 0.6, 0.8 mm
Nozzle Temperature	190 - 230 °C
Build Plate Type	Cool Plate, High Temperature Plate or Textured PEI Plate
Bed Surface Preparation	Glue
Bed Temperature	35 - 45 °C
Cooling Fan	Turn on
Printing Speed	< 300 mm/s
Retraction Length	0.6 - 1.0 mm

Retraction Speed	20 - 40 mm/s
Chamber Temperature	25 - 45 °C
Max Overhang Angle	55 °
Max Bridging Length	30 mm
Support Material	Support for PLA

• Properties

Bambu Lab has tested the differing aspects in the performance of PLA Metal material, including physical, mechanical, and chemical properties. Typical values are listed as followed:

Physical Properties		
Subjects	Testing Methods	Data
Density	ISO 1183	1.25 g/cm ³
Melt Index	210 °C, 2.16 kg	38.6 ± 3.7 g/10 min
Melting Temperature	DSC, 10 °C/min	160 °C
Glass Transition Temperature	DSC, 10 °C/min	60 °C
Crystallization Temperature	DSC, 10 °C/min	/
Vicar Softening Temperature	ISO 306, GB/T 1633	62 °C
Heat Deflection Temperature	ISO 75 1.8 MPa	58 °C
Heat Deflection Temperature	ISO 75 0.45 MPa	62 °C
Saturated Water Absorption Rate	25 °C, 55% RH	0.40%

Mechanical Properties		
Subjects	Testing Methods	Data
Young's Modulus (X-Y)	ISO 527, GB/T 1040	2010 ± 220 MPa
Young's Modulus (Z)	ISO 527, GB/T 1040	1710 ± 150 MPa
Tensile Strength (X-Y)	ISO 527, GB/T 1040	34 ± 4 MPa
Tensile Strength (Z)	ISO 527, GB/T 1040	31 ± 3 MPa
Breaking Elongation Rate (X-Y)	ISO 527, GB/T 1040	14.7 ± 1.5 %
Breaking Elongation Rate (Z)	ISO 527, GB/T 1040	4.5 ± 1.3 %
Bending Modulus (X-Y)	ISO 178, GB/T 9341	2290 ± 210 MPa
Bending Modulus (Z)	ISO 178, GB/T 9341	2150 ± 180 MPa
Bending Strength (X-Y)	ISO 178, GB/T 9341	66 ± 3 MPa
Bending Strength (Z)	ISO 178, GB/T 9341	51 ± 5 MPa
Impact Strength (X-Y)	ISO 179, GB/T 1043	58.9 ± 3.4 kJ/m ² ; 22.3 ± 0.9 kJ/m ² (notched)
Impact Strength (Z)	ISO 179, GB/T 1043	16.8 ± 1.2 kJ/m ²

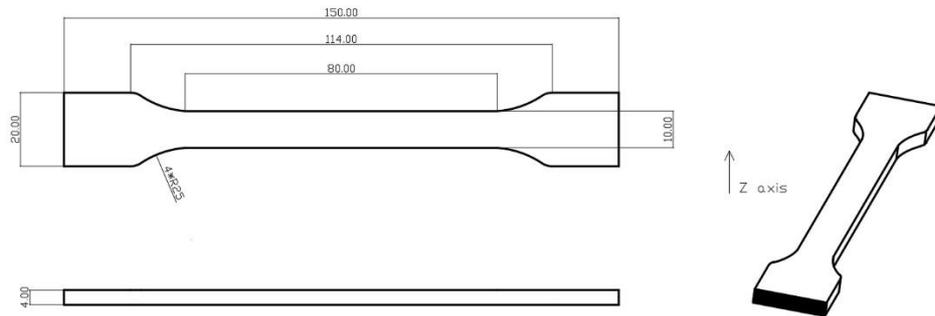
Other Physical and Chemical Properties	
Subjects	Data
Odor	Odorless
Composition	PLA
Skin Hazards	No hazard
Chemical Stability	Stable under normal storage and handling conditions
Solubility	Insoluble in water
Resistance to Acid	Not resistant
Resistance to Alkali	Not resistant
Resistance to Organic Solvent	Not resistant to some organic solvents
Resistance to Oil and Grease	Resistant to most kinds of oil and grease
Flammability	Flammable
Combustion Products	Water, carbon oxides
Odor of Combustion Products	Odorless

- **Specimen Test**

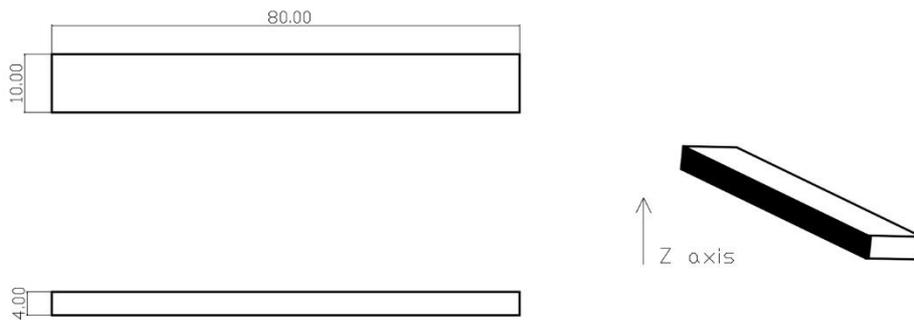
Specimen Printing Conditions	
Subjects	Data
Nozzle Temperature	220 °C
Bed Temperature	35 °C
Printing Speed	200 mm/s
Infill Density	100%

**All the specimens were annealed and dried at 55 °C for 8 h before testing. And the suggested annealing temperature of models printed with Bambu PLA Metal is 50 to 60 °C, and the time is 6 to 12 hours. The annealing effect depends on the annealing temperature, time and the model itself: size, structure, infill and other printing settings; some prints may deform and warp after annealing. When drying the filament and annealing the prints, it's required to use an oven that has big enough inside volume and can provides even temperature distribution, such as a blast drying oven (forced-air drying oven), and the filament and prints need to be away from the heater, and a micro-wave oven or kitchen oven is not compatible, otherwise the filament and prints can get damaged.*

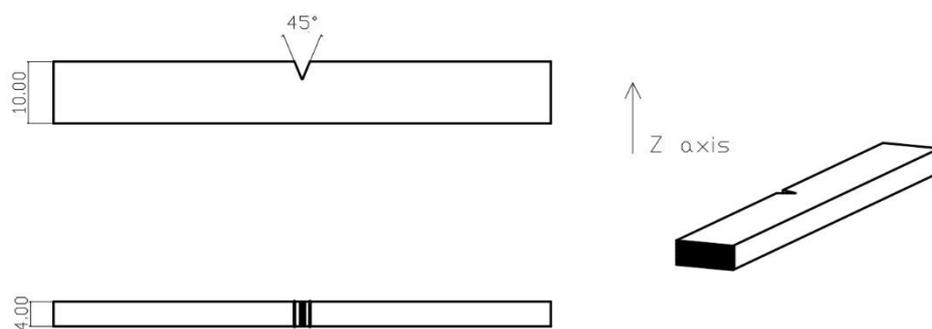
1. Tensile Testing



2. Bending Testing



3. Impact Testing



• Disclaimer

The performance values are tested by standard samples at Bambu Lab, and the values are for design reference and comparison only. Actual 3D printing model performance is related to many other factors, including printers, printing conditions, printing models, printing

parameters, etc.

In the process of using Bambu Lab 3D printing filaments, users are responsible for the legality, safety, and performance indicators of printing. Bambu Lab is not responsible for the use of materials and scenarios and is not responsible for any damage that occurs in the process of using our filaments.