

DP021015GN001-TDS

COCOON PLA-Mineral

COCOON PLA-Mineral is a PLA material with a silky texture, offering great impact resistance and easy to print. The printed parts feature bright, glossy colors and a fine, smooth surface, achieving a metallic luster and silky texture without the need for painting or polishing. It is fast, safe, energy-efficient, and eco-friendly, making it ideal for aesthetic creative designs, artwork, sculptures, and figurines that require a high-quality surface finish in 3D printing applications.

Part 1 Printed Specimen Performance

Testing Items	Testing Conditions	Testing Methods	Units	Typical Values
Mechanical Properties				
Tensile Strength(X-Y)	50mm/min	ISO 527-1	MPa	63
Tensile Modulus(X-Y)	50mm/min	ISO 527-1	MPa	2700
Tensile Strength(Z)	50mm/min	ISO 527-1	MPa	22
Tensile Modulus(Z)	50mm/min	ISO 527-1	MPa	2500
Flexural Strength	2mm/min	ISO 178	MPa	87
Flexural Modulus	2mm/min	ISO 178	MPa	2700
Impact Strength, Notched	2.75J	ISO 179-1	kJ/m ²	15

Note: All specimens are printed under the following conditions: nozzle temperature = 200°C, printing speed = 130 mm/s, build plate temperature=60°C infill = 100%, nozzle diameter = 0.4mm.



Printing Path Direction of Specimen (Z)



Printing Path Direction of Specimen (X-Y)

Part 2 Printing Guidelines

Parameters	Settings
Nozzle Temperature	190-220°C
Build Plate Temp.	50-65°C
Build Plate Material	Glass、PEI、Steel Spring Build Plate
Bottom Layer Printing Temp.	200-210°C
Enclosed-chamber Printing	/
Print Speed	60-200mm/s
Drying recommendations	40-50 °C in a hot air dryer for 4-8hours

Disclaimer:

The values provided in this data sheet are for reference and comparison purposes only. They should not be used for design specifications or quality control. Actual values may vary depending on printing conditions. The ultimate performance of printed parts depends not only on the material but also on the part design, environmental conditions, and printing conditions. The product specifications are subject to change without notice.

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