DUAL COLOUR SHIFTING PLA

PLA Chameleon Dual Colour Filament

1.75 mm · 1 kg spool · ±0.03 mm tolerance

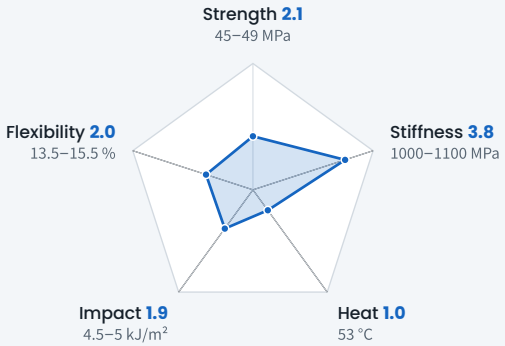
PLA with a dual colour blend that shifts between two tones as the light and viewing angle change.

- Dual colour shift
- No AMS or tool changes needed
- Prints at standard PLA settings
- No enclosure needed

Recommended Print Settings

Nozzle temperature	190–220 °C
Bed temperature	25–60 °C
Print speed	60–90 mm/s
Support material	PVA (as support interface)

Property Profile



Scores from 1 to 5 relative to the OzFDM filament range, based on the typical values in this sheet (stiffness and impact on a log scale).

Filament Specifications

Material	Dual colour shifting PLA
Diameter	1.75 mm
Diameter tolerance	±0.03 mm
Net filament weight	1 kg

Spool & Packaging

Empty spool weight	150 g
Spool with filament	1.15 kg
Spool outer diameter	200 mm
Hub diameter	52 mm
Spool width	65 mm
Shipping weight	1.3 kg
Box dimensions	210 × 220 × 75 mm

Storage & Handling

Drying

40–45 °C for 4–6 hours in a filament dryer or food dehydrator.

Storage

Airtight bag or container with desiccant in a cool, dark and dry area to prevent moisture absorption. For optimal long term storage we recommend drying the filament prior to sealing the filament spool in a vacuum bag with desiccant.

Mechanical Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Tensile strength	ISO 527	45–49 MPa
Elongation at break	ISO 527	13.5–15.5 %
Tensile modulus	ISO 527	1000–1100 MPa
Flexural strength	ISO 178	69–75 MPa
Impact strength	ISO 180	4.5–5 kJ/m²

Physical Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Density	ISO 1183	1.25–1.26 g/cm³
Melt flow rate (190 °C, 2.16 kg)	ISO 1133	4–8 g/10min
Moisture absorption (23 °C, 24 h)	ISO 62	<0.3 %

Thermal Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Heat deflection temperature (0.455 MPa)	ISO 75	53 °C
Continuous use temperature	IEC 60216	50 °C

Available Colours 3


Yellow-Green


Blue-Pink


Red-Orange

Swatches are indicative only. Colours vary between screens and with print settings.

NOTES

Values shown are typical results measured on test specimens and are provided for guidance only. They are not guaranteed specifications and should not be used as design limits. Printed part properties vary with printer, settings, print orientation and part geometry. Test your parts for suitability before use in critical applications.