



OVERTURE ROCK PLA TECHNICAL DATA SHEET

Rock PLA is a unique PLA composite that combines the benefits of regular PLA with stunning surface effects reminiscent of marble.

Physical Properties

Property	Testing method	Typical value
Density	ISO 1183, GB/T 1033	1.37 (g/cm ³ at 21.5 °C)
Vicat Softening temperature*	ISO 306 GB/T 1633	62(°C)
Melt index	210 °C, 2.16 kg	14.66 (g/10 min)
Melting temperature	DSC, 10°C/min	161.2 (°C)

Tested with 3D printed specimen of 100% infill

Mechanical Properties

Property	Testing method	Typical value
Young's modulus (X-Y)	ISO 527, GB/T 1040	2356.8 ± 88 (MPa)
Tensile strength (X-Y)	ISO 527, GB/T 1040	25.9 ± 0.4 (MPa)
Tensile strength (Z)	ISO 527, GB/T 1040	16.6 ± 0.2 (MPa)
Elongation at break (X-Y)	ISO 527, GB/T 1040	25.6 ± 2.3 (%)
Bending modulus (X-Y)	ISO 178, GB/T 9341	2516.1 ± 73 (MPa)
Bending strength (X-Y)	ISO 178, GB/T 9341	40.1 ± 3.4 (MPa)
Notched Charpy impact strength (X-Y)	ISO 179, GB/T 1043	8.1 ± 0.3 (kJ/ m ²)

All testing specimens were printed under the following conditions:

nozzle temperature = 210 °C, printing speed = 60 mm/s, build plate temperature = 40 °C, infill = 100%

All specimens were conditioned at room temperature for 24h prior to testing

Recommended Printing Conditions

Nozzle temperature	190 - 230 (°C)
Build surface material	OVERTURE Build Surface, Textured PEI
Build surface treatment	None, Applying PVA glue to the build surface
Build plate temperature	50 - 70 (°C)
Cooling fan	Turned on
Printing speed	60-300 (mm/s)
Raft separation distance	0.1-0.3 (mm)
Retraction distance	1-3 (mm)
Retraction speed	20-40 (mm/s)
Threshold overhang angle	60 (°)

Based on 0.4 mm nozzle.

Printing conditions may vary with different nozzle diameters



Disclaimer

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End- use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

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