

# Data sheet

## Made with REGEN™ filaments



### REGEN™ PHA 1.0 Wood-filled

Wood-filled filament is a premium grade wood composite material designed specifically for 3D printers. Filled with real wood, it is made to print decorative parts or objects with an authentic wood appearance.

REGEN™ is a compostable and certified biobased bioplastic made by BOSK Bioproducts. It is made from renewable sources, while conventional plastics are derived from petrochemicals. This Canadian-made PHA compound is a sustainable alternative to conventional plastic.

Compared to the commonly used PLA, REGEN™ filaments are less brittle, are stronger with a smoother finish, display higher heat deflection temperatures, and biodegrade faster.

REGEN™ PHA 1.0 Wood-filled filament is ideal for printing small and technical parts such as figurines, spare parts, home accessories, office supplies, game accessories, kitchen gadgets, and many more...

Visit [made-with-regen.ca](http://made-with-regen.ca) for more information.



#### Recommended Print settings

Printing Temperature	185°C - 205°C
Bed Temperature	Cold - 60°C
Nozzle	0.6mm or larger <b>harden steel</b> nozzle
Fan speed	0 - 100%
Print speeds	40mm/s to 100mm/s
Layer height	0.2mm or lower
Flow rate	97%

Pre-drying is recommended for better layer adhesion.  
Glue stick or masking tape is recommended for better adhesion on glass bed. No bed adhesion issue with steel bed.  
You may experience warping when printing larger parts.

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