

Add:North Enhanced PLA Clear

Material Engineering Report
MaterialID MAT0122

3DPiceland Engineering Platform
3DPiceland Labs

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RELIABILITY - Bug Fixes and Workflow Reliability
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Public-data contract: This static report contains only allowlisted material identity, public links, canonical MSRP and existing Verified Material Summary / governed score outputs. It excludes raw specimen rows and non-public operational data.

TEST COVERAGE

Complete

ENGINEERING AXES

5/6

PUBLIC MSRP

\$32.00 USD/kg

Material identity

MaterialID	MAT0122
Material	Add:North Enhanced PLA Clear
Manufacturer	Add:North
Product line	Enhanced
Base material	PLA
Category	Standard
Variant / finish	—
Reinforcement	—
Color	Clear

Governed engineering profile

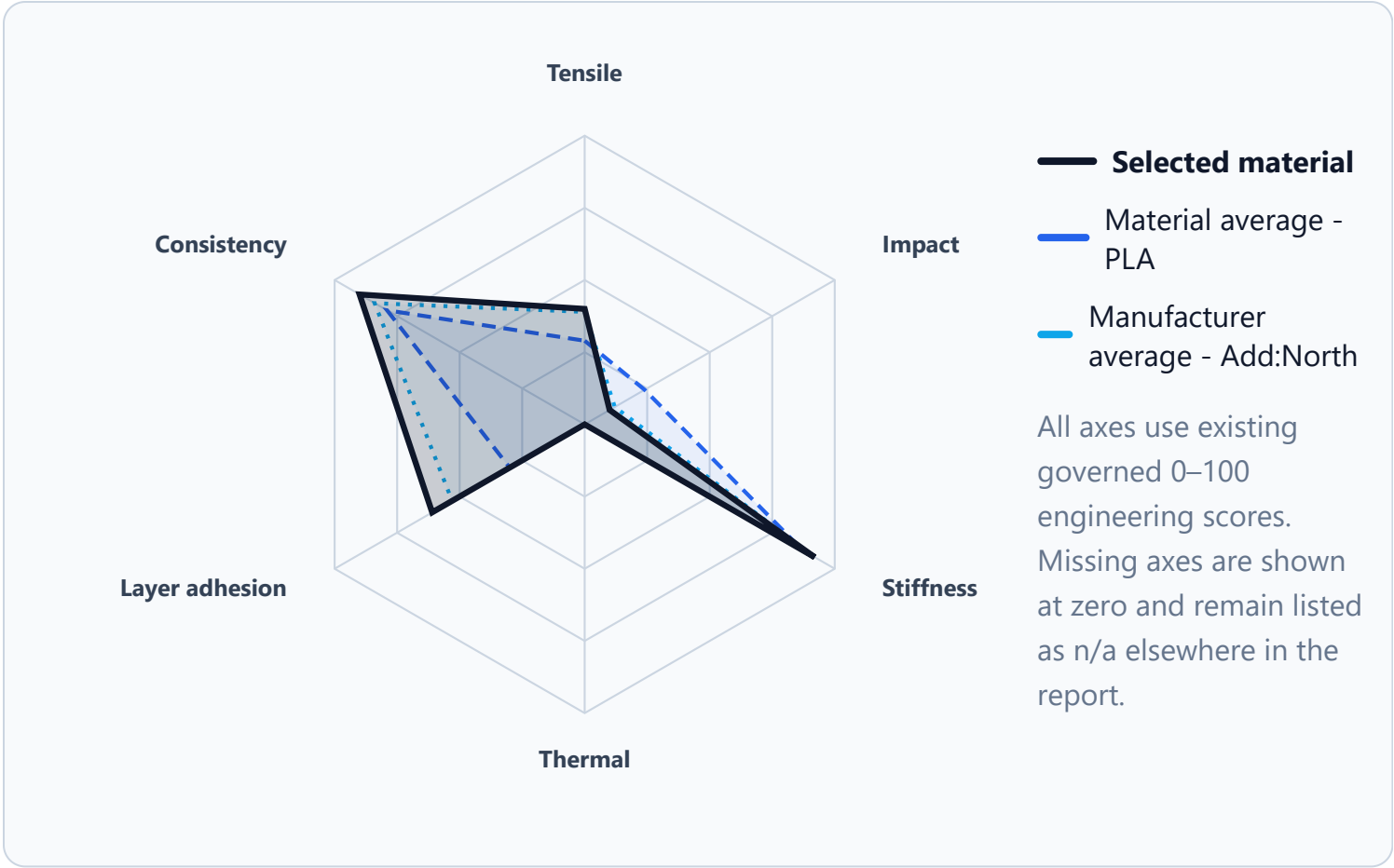
Overall	59/100
Tensile	40/100

Impact	10/100
Stiffness	92/100
Consistency	90/100
Layer adhesion	61/100
Thermal	—
Best available axis	stiffness

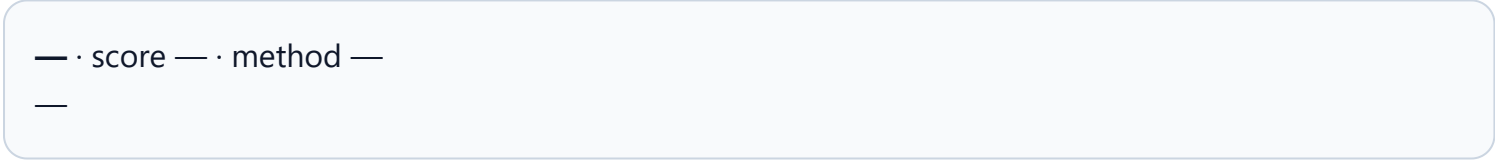
Engineering score profile



Engineering radar



Fixture thermal result



Material and manufacturer context

Metric	Selected material	Material average	Manufacturer average
Overall	59/100	50/100	54/100
Tensile	40/100	29/100	39/100
Impact	10/100	24/100	12/100
Stiffness	92/100	87/100	91/100
Consistency	90/100	79/100	84/100
Layer adhesion	61/100	30/100	53/100
Thermal	—	—	—

Verified measurement results

Existing Verified Material Summary outputs. The public renderer does not read raw specimen rows or recalculate these values.

Measurement	Average	Std. deviation	CV	Samples	Confidence
Tensile upright	24.163 MPa	2.838 MPa	11.7%	10	10/10
Tensile flat	39.882 MPa	1.646 MPa	4.1%	10	10/10
Impact upright	45.051 kJ/m ²	7.071 kJ/m ²	15.7%	10	10/10
Impact flat	164.754 kJ/m ²	15.758 kJ/m ²	9.6%	10	10/10
Stiffness modulus	2753.914 MPa	—	—	—	—
Stiffness deflection	1.97 mm	—	—	—	—

Measurement provenance

Canonical per-module measured dates from SQLite, shown in unambiguous ISO format. Missing dates are not inferred.

Module	Measured date
Tensile	Not recorded
Impact	Not recorded
Stiffness	Not recorded
Thermal	Not recorded

Engineering interpretation

Summary: Add:North Enhanced PLA Clear has a balanced mid-range engineering profile. It is above its material-family average by 8,4 points and above its manufacturer average by 4,5 points. Its strongest measured axis is Stiffness, while the weakest axis is Impact.

Data-driven review: Add:North Enhanced PLA Clear is best understood as a balanced material for general functional prototypes. Compared with the current verified dataset, it ranks better than 95% overall, is above the material-family average by 8,4 points, and is above the manufacturer average by 4,5 points. Its strongest engineering signal is Stiffness, while Impact is the main limitation to consider before using it for demanding applications.

BEST FEATURE

Stiffness

MAIN LIMITATION

Impact

DATASET POSITION

Better than 95%
12 / 234

Strengths

- Layer adhesion: 61/100. Z-axis bonding is better than the material-family context.
- Consistency: 90/100. Repeatability is one of the stronger signals in this material profile.
- Tensile: 40/100. Tensile behavior is competitive against the material-family context.
- Stiffness: 92/100. Stiffness is a relative advantage in this comparison group.

Limitations

- Impact: 10/100. Avoid high impact or shock-loaded components without additional validation.

Engineering trade-offs

- Stiffness is useful for shape stability, but impact tolerance is a separate limitation.

Recommended applications

- Rigid brackets, fixtures and shape-stable prototypes
- Parts where Z-axis bonding is important
- Repeatable print jobs and production-style batches
- Cosmetic parts, concept models or low-load prototypes
- Avoid high impact components

Metric rankings and percentiles

Metric	Score	Rank	Percentile
Overall	59/100	12 / 234	Better than 95%
Tensile	40/100	10 / 226	Better than 96%
Impact	10/100	210 / 226	Better than 8%

Metric	Score	Rank	Percentile
Stiffness	92/100	65 / 223	Better than 71%
Consistency	90/100	5 / 231	Better than 98%
Layer adhesion	61/100	9 / 226	Better than 96%
Thermal	—	—	—

Decision guidance

- Use this material for moderate requirements after checking the weakest axis.
- Review the listed alternatives if the application needs stronger overall performance.
- Avoid selecting it for impact-focused testing or shock-loaded designs.

Better alternatives

MaterialID	Material	Manufacturer	Overall	Tensile	Impact
MAT0069	ProtoPasta HTPLA Blood of My Enemies PLA Red	ProtoPasta	100/100	—	—
MAT0079	Polymaker PolyLight PLA Pro Black	Polymaker	65/100	35/100	52/100
MAT0109	Polymaker PolyMax PLA Black	Polymaker	64/100	32/100	62/100

Peer context

Highest-scoring same-base-material peers from the current governed dataset. This context is descriptive and is not recalculated by the public renderer.

MaterialID	Material	Manufacturer	Overall	Tensile	Impact
MAT0069	ProtoPasta HTPLA Blood of My Enemies PLA Red	ProtoPasta	100/100	—	—
MAT0079	Polymaker PolyLight PLA Pro Black	Polymaker	65/100	35/100	52/100
MAT0109	Polymaker PolyMax PLA Black	Polymaker	64/100	32/100	62/100
MAT0080	Polymaker PolySonic PLA Pro Blue	Polymaker	64/100	30/100	58/100

MaterialID	Material	Manufacturer	Overall	Tensile	Impact
MAT0076	BambuLab Tough+ PLA Tough+ Black	BambuLab	63/100	26/100	59/100
MAT0108	Polymaker PolyLight PLA Black	Polymaker	61/100	33/100	14/100
MAT0074	Winkle Matte PLA Matte Red	Winkle	60/100	34/100	—
MAT0096	Prima Creator PrimaValue Light Gray PLA Plus Gray	Prima Creator	58/100	33/100	58/100

Public links

[Manufacturer website](#) [Video review](#) [Download PDF](#)

Methodology and limitations

Results are comparative 3DPIceland measurements from home-built test equipment. Thermal is a nearby BlueDOT probe-indicated fixture temperature, not ASTM D648, ISO 75 or specimen temperature. Missing evidence remains n/a. Scores and test results are not recalculated by this publishing layer and do not replace certified manufacturer datasheets or accredited laboratory testing.

- [Testing methodology](#)
- [Engineering methodology whitepaper](#)