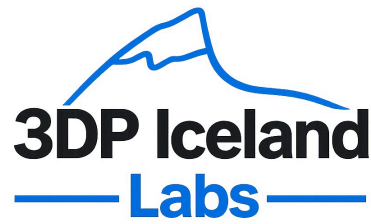


Public printing recommendation

Winkle Silk PLA Silk Green

MaterialID MAT0089



3DP Iceland Labs

Generated with 3DP Iceland Engineering Platform v60.0.6

WORKFLOW-RELIABILITY - Bug Fixes and Workflow

Reliability

2026-08-25 19:05:46

Guidance boundary: values below are shared base-material guidance resolved only through the canonical BaseMaterialId link. They are not manufacturer-, spool- or printer-specific validated settings. Missing fields remain Not recorded.

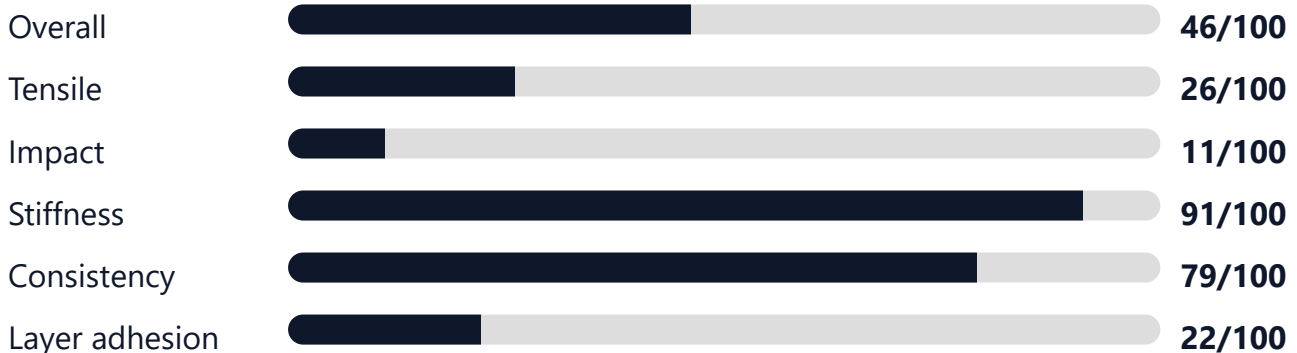
Overall
46/100

Engineering axes
6/5

Public rank
126 / 234

MSRP USD/kg
27.96

Engineering profile



Recommended applications

- Rigid brackets, fixtures and shape-stable prototypes
- Repeatable print jobs and production-style batches
- Cosmetic parts, concept models or low-load prototypes
- Avoid high tensile load applications
- Avoid high impact components

Measured strengths

- Consistency: 79/100. Repeatability is one of the stronger signals in this material profile.
- Stiffness: 91/100. Stiffness is a relative advantage in this comparison group.

Limitations

- Tensile: 26/100. Avoid using this as the primary choice for tensile-loaded parts.
- Impact: 11/100. Avoid high impact or shock-loaded components without additional validation.
- Layer adhesion: 22/100. Z-axis performance should be treated with caution.

Engineering trade-offs

- Good repeatability does not compensate for low tensile capability in load-bearing designs.
- Stiffness is useful for shape stability, but impact tolerance is a separate limitation.
- The report should be read as a suitability warning rather than a general-purpose recommendation.

Base-material printing guidance

Guidance	Minimum	Recommended	Maximum	Unit
Nozzle temperature	195	230	230	°C
Bed temperature	60	60	70	°C
Print speed	55	165	165	mm/s
Cooling	20	80	85	%
Guidance	Value			Unit
Cooling guidance	High			
Drying temperature	50			°C
Drying time	5			hours
Enclosure	Not required			
Printer / G-code reference	PrusaCoreOneL			
Slicer profile reference	Prusament PLA			

Print workflow checks

- Confirm nozzle temperature, bed temperature, speed, cooling and drying requirements from the manufacturer profile or spool label.
- Print a small validation part before committing to a long, costly or safety-relevant print.
- Orient the part so the governing load does not rely on an unverified or weak engineering axis.
- Layer-adhesion evidence is weak; avoid critical Z-axis loading without additional validation.

Decision guidance

- Use this material mainly for low-load, visual or experimental parts.
- Review the listed alternatives if the application needs stronger overall performance.
- Do not choose it as a tensile-strength benchmark material.
- Avoid selecting it for impact-focused testing or shock-loaded designs.

Stronger same-family 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

Confirm exact settings against the manufacturer profile, spool label and actual printer/material combination. Results do not replace application-specific validation.

[Testing methodology](#) · [Download PDF](#)

reports/printing-recommendations/MAT0089/