



TREED FILAMENT DATASHEET

MATERIAL: Stiron HIPS

WE CARE ABOUT YOUR PRINTS

| Suggested printing specs. | Value | Unit | Standard |
|-----------------------------|-------------|-------------------|-----------|
| Extruder Temperature | 220° +/-10° | °C | Internal |
| Bed Temperature | 85° +/-10° | °C | Internal |
| Print speed | 60-90 | mm/s | Internal |
| Fan | 0-30 | % | Internal |
| Minimum Nozzle Diameter | 0,3 | mm | Internal |
| Material Properties | Value | Unit | Standard |
| Density | 1.04 | g/cm ³ | ISO 1183 |
| Water Absorption | 0.1 | % | ISO 62 |
| Tensile Modulus | 1800 | MPa | ISO 527 |
| Tensile Strain (Yeld) | 1.5 | % | ISO 527 |
| Charpy Impact at 23°C | 12 | kJ/m ² | ISO 179 |
| MFR | 4 | g/10 min | ISO 62 |
| Melting point | 240 | °C | ISO 11357 |
| Vicat Softening Temperature | 96 | °C | ISO 306 |

DISCLAIMER

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