



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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