



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	°C	210-230	internal
plate temp	°C	75-95	internal
min. nozzle diameter	mm.	0,3	internal
fan	%	0-30	internal
print speed	mm/l°	60-90	internal
PROPERTY			
Physical			
Specific gravity	g/cm <sup>3</sup>	1.04	ISO 1183
Water absorption	%	0.1	ISO 62
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	1800	ISO 527
Tensile stain (yield)	%	1.5	ISO 527
Charpy impact (23°C)	kJ/m <sup>2</sup>	12	ISO 179
MFR	g/10 min	4	ISO 62
Thermal			
Melting point	°C	240	ISO 11357
Vicat softening temp.	°C	96	ISO 306

### Disclaimer

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### ADDITIONAL INFORMATIONS

In general filaments made with STIRON (HIPS) can be processed on conventional 3D printer using FDM / FFF technology.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 210°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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