



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	235-250	internal
plate temp	C°	90	internal
min. nozzle diameter	mm.	0,2	internal
fan	%	0-70	internal
print speed	mm/l°	30-60	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.05	ISO 1183
Mechanical			
Tensile strength	MPa	47	ISO 527
Tensile elongation	%	30	ISO 527
Charpy impact (23°C)	kJ/m ²	21	ISO 179
Flexural strenght	MPa	76	ISO 178
Thermal			
H.D.T.	°C	83	ISO 75 A
Vicat softening temp.	°C	104	ISO 306

Disclaimer

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ADDITIONAL INFORMATIONS

In General filaments made with ABS Food can be processed on conventional 3D printer using FDM / FFF technology.

ABS Food is a special ABS developed for 3D printing and to obtain best results we recommend pre drying the filaments at 70° for 2 h. Increase drying time for spools up 1 kg.

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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DECLARATION OF FOOD CONTACT COMPLIANCE

MANUFACTURER: TREED filaments
PRODUCT: ABS food

Food contact regulation - Food contact materials and articles

Regulation (EC) No. 1935/2004 : Framework regulation
Regulation (EC) No. 2023/2006 : Good manufacturing practice

Food contact regulation - Plastic materials and articles

Commission regulation : (EU) No. 10/2011 and its amendments :
(EU) 2016/1416, (EU) 2017/752, (EU) 2015/174, (EU) 321/2011, (EU) 1282/2011, (EU) 1183/2012 and (EU) 202/2014

Test condition

Contact time : 10 days
Contact temperature : 40°C
Food simulates : Acetic acid 3% / ethanol 10% / ethanol 20%

The requirement of regulation (EU) No 1935/2004, regulation (EU) No 10/2011 and its amendments up to date (EU) 2016/1416, (EU) 2017/752, (EU)2015/174, (EU) 321/2011, (EU) 1282/2011, (EU) 1183/2012 and (EU) 202/2014 for use in contact with food.

Compliance with the provisions of regulation (EU) No 1935/2004 especially the suitability of the articles for the given application, the affect on smell and taste of the food, and the observance of any given limitations, must be ensured by the entry who introduces the articles into the distribution.

Recommended applications

Food processors	Yes
Water purification equipment	Yes
Liquid containers	Yes
Food containers	Yes
Food packaging	No

Certification

GB - EU - FDA - JHPC

For more technical infos, please contact us : team@treedfilaments.com

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