



SUGGESTED PRINT SETS (I)			
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	1.06	ISO 1183
Mechanical			
Tensile strength yield	MPa	46	ISO 527
Tensile strength break	MPa	34	ISO 527
Tensile elongation	%	31	ISO 527
Charpy impact (23°C)	kJ/m²	20	ISO 179
Charpy impact (-30°C)	kJ/m²	10	ISO 179
Flexural strenght	MPa	76	ISO 178
Flexural modulus	GPa	2.2	ISO 178
Izod impact strength (23°C)	kJ/m²	19	ISO 180/1A
Izod impact strength (-30°C)	kJ/m²	9	ISO 180/1A
Thermal			
Heat distortion temp. (unannealed)	°C	83	ISO 75 A
Heat distortion temp. (annealed)	°C	98	ISO 75 A
Coefficient of linear thermal expansion	-	8.6 x 10-5	ISO 11359
Flammability	-	1.5 mm HB	UL 94
Mold shrinkage	%	0.4-0.7	ISO 294-4
Vicat softening temp.	°C	104	ISO 306

Disclaimer

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ADDITIONAL INFORMATIONS

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

ABS MED 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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CONTAIN NO FOLLOWING SUBSTANCES

- | | |
|---|---|
| 1. Halogen (F, Br, I) and its compound | 31. Natural latex |
| 2. Halogen (C1) | 32. Dioxina and furans |
| 3. PBDEs (polybrominated biphenyl ethers) | 33. Primary aromatic amines (PAA) |
| 4. PBBs (polybrominated biphenyls) | 34. Perchlorate |
| 5. Ozone depleting chemicals (CFCs & HCFCs) | 35. Hexachlorobenzene |
| 6. Chlorinated paraffin (C10-C13) | 36. Mirex |
| 7. Polyvinyl chloride (PVC) | 37. Specified amine compounds |
| 8. Mercury (Hg) and its compounds | 38. Benzene |
| 9. Lead (Pb) and its compounds | 39. Polyamide |
| 10. Cadmium (Cd) and its compounds | 40. PVDC (polyvinylidene chloride) |
| 11. Chromium (Cr) and its compounds | 41. ESBO (expoxidized soybean oil) |
| 12. Arsenic (As) and its compounds | 42. Formamide |
| 13. Antimony (Sb) and its compounds | 43. Hexabromocyclododecane (HBCDD) |
| 14. Selenium (Se) and its compounds | 44. Red phosphorus |
| 15. Barium (Ba) and its compounds | 45. Aniline - formaldehyde polycondensate |
| 16. Beryllium (Be) and its compounds | 46. Fluorescent powder |
| 17. Bismuth (Bi) and its compounds | 47. 4,4' - Sulfonyldiphenol (BPS) |
| 18. Organic tin compounds (TBT, TPT, DOT, DBT) | 48. Diisononyl phthalate (DINP) |
| 19. Poly naphthalenes | 49. Di-isodecyl phthalate (DIDP) |
| 20. Asbestos | 50. Di-n-octyl phthalate (DnOP) |
| 21. Phthalates | 51. Diethyl phthalate (DEP) |
| 22. 2-(2'-hydroxy-3', 5'-di-tert-butylphenyl) benzotriazole | 52. Dimethyl phthalate (DMP) |
| 23. PFOA, PFOS | 53. Cobalt |
| 24. Bisphenol A | 54. Mica |
| 25. Formaldehyde | 55. Graphite |
| 26. Dimethylfumarate (DMF) | 56. Manganese (Mn) and its compounds |
| 27. Triclosan | 57. Tri-o-cresyl phosphate |
| 28. Nickel | 58. Tris (2-chloroethyl)phosphate(TCEP) |
| 29. REACH - candidate list of SVHC | 59. Tris (aziridiny) phosphate |
| 30. Radioactive substances | 60. Tris (2,3-dibromopropyl) phosphate |

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- 61. Tris (1-chloro-2-propyl) phosphate (TCPP)
- 62. Tris (1,3-dichloro-2-propyl) phosphate (TDCPP)
- 63. Perfluorohexane-1-sulphonic acid and its salts (PFHxS)
- 64. Benzenamine, N-phenyl-, reaction products with styrene and 2,4,4-trimethylpentene (BNST)
- 65. Polychlorinated biphenyls (PCBs) and terphenyls (PCTs) and naphthalenes (PCNs)
- 66. Azo colorants (according to REACH-ANNEX-XVII-APPENDIX 8)
- 67. APEO: including alkyl phenol (AP), octylphenol (OP), Nonylphenol (NP), octylphenol ethoxylates (OPE), nonylphenol ethoxylates (NPE)

With regard to composition of above grades of products, the aforesaid products, comply with the Directives of RoHS (2011/65/EU), 2003/11/EC

Racommended applications

Home care	Yes
Medical devices	Yes
Medical supplies	Yes
Assistive devices	Yes

Certifications

USP<88> class VI

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

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