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Our fully biobased formulation of stoneFill mimics stone surfaces really well. The key difference with many other filaments is that our formulation does not incorporate 'stone powder', which makes this filament easy to work with and a joy to print!

### TYPICAL MATERIAL PROPERTIES – 3D Printed

Physical properties	Unit	Value	Method
Tensile modulus	MPa	3325	ISO 527
Yield strength	MPa	43	ISO 527
Yield strain	%	2,4	ISO 527
Tensile strength	MPa	43	ISO 527
Tensile strain at tensile strength	%	2,4	ISO 527
Tensile stress at break	MPa	42	ISO 527
Tensile strain at break	%	3,7	ISO 527
Flexural modulus	MPa	2947	ISO 178
Flexural strain at standard deflection	MPa	79	ISO 178
Flexural strength	MPa	82	ISO 178
Flexural strain at flexural strength	%	4,4	ISO 178
Flexural stress at break	MPa	46	ISO 178
Flexural strain at break	%	6,1	ISO 178
Charpy unnotched impact strength	kJ/m2	TBD	ISO 179-1/1 eU
Charpy notched impact strength	kJ/m2	TBD	ISO 179-1/1 eU

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#### TYPICAL MATERIAL PROPERTIES – Injection molded

Physical properties	Unit	Value	Method
Density	g/cm <sup>3</sup>	TBD	
Glass Transition Temperature	°C	TBD	DSC
Tensile Strength	MPa	TBD	ISO 527-1
Tensile Modulus	MPa	TBD	ISO 527-1
Tensile Elongation	%	TBD	ISO 727-1
Impact Strength (Ch-N 23°C)	kJ/m <sup>2</sup>	TBD	ISO 179-1

#### FILAMENT SPECIFICATION

Nominal diameter:	Diameter tolerance	Ovality
1,75 mm	± 0,05	≥ 95%
2,85 mm	± 0,10	≥ 95%

#### GUIDELINE FOR PRINT SETTINGS

Nozzle temperature	195 - 220°C
Bed temperature	50 - 60°C
Bed surface / modification	-
Active cooling fan	100%
Print speed	40-100 mm/s

#### Notes

The reported properties are an average of a batch of 3D printed specimens. The specimens have been printed in XY plane, using 0.15mm layerheight, 100% infill, 0.4mm nozzle, 210°C nozzle temperature and 55 °C bed temperature.

#### Disclaimer

The product- and technical information provided in this datasheet is correct to the best of our knowledge. The information given is provided as a guidance for good use, handling and processing and is not to be considered as a quality specification. The information only relates to the specific product and the material properties.