

# TECHNICAL DATA SHEET

## StoneFil

Date of issue: 16-1-2020

Date of update: 23-8-2024

### Product specifications

StoneFil is a PLA-based 3D printer filament with a 50% powdered stone filling, which give 3D printed parts true stone-like aesthetics and a rough and matt stone-like surface finish.

### Important key features

50% gravimetric powdered stone filling  
±37% heavier than regular PLA  
Matte and rough stone-like finish

### Suitable applications

Art  
Home deco  
Sculptures

### Recommended pretreatment

**Drying**  
Recommended  
30 - 40 °C  
6 h

**Print with**  
Enclosure Yes  
Dry box No

### Recommended print settings regular speed

Print speed 25 - 80 mm/s  
Nozzle temperature 185 - 225 °C  
Bed temperature 50 - 60 °C  
Fan speed 80 - 100 %

Material properties	Typical value	Unit of Measure	Test method	Test condition
Density				
Specific gravity	1,24	g/cm <sup>3</sup>	ASTM D792	
Melt flow rate	6	g/10min	ASTM D1238	210°C/2,16kg

### Mechanical properties

Impact strenght	16	J/m	ISO D882	Izod notched 23°C
Tensile strenght at yield	60	MPa	ISO D882	
Tensile strenght at break	53	MPa	ISO D882	
Tensile modulus	3,5	MPa	ISO D882	
Elongation at yield	6	%	ISO D882	
Elongation at break				
Flexural strenght	83	MPa	ISO D790	
Flexural modulus	3,8	MPa	ISO D790	
Rockwell hardness				

### Thermal properties

Melting temperature				
Heat deflection temperature	55	°C	ASTM E2092	HDT A
Vicat softening temperature				
Glass transition temperature	60	°C	ASTM D3418	

### Product export information

HS code	Description	Origin
39169090	Monofilament for 3D printing	European Union

### Disclaimer

The product- and technical data provided in this datasheet is correct to the best of FormFutura BV's knowledge and are intended for reference and comparison purposes only. Actual values may vary according to printing conditions, model complexity, environmental conditions, etcetera. Typical values are indicative only and are not to be construed as being binding specifications. All other information supplied, including that herein, is considered accurate but is furnished upon the express condition that the customer shall make its own assessment to determine a product's suitability for a particular purpose. We make no warranty, express or implied, including regarding any information supplied or the data upon which it is based or the results to be obtained from the use of such products or information, or concerning product, whether of satisfactory quality, merchantability, fitness for any particular purpose or otherwise, or with respect to intellectual property infringement as a result of use of information or products, and none shall be implied.

