

Technical data sheet

ABS

Use	It is a material for the FDM (FFF) 3D printing additive technology.
Material	Acrylonitrilbutadienstyrene, petroleum product
Diameter	1,75 mm / 2,85 mm
Tolerance	± 0,05 mm
Weight	0,5 kg netto ± 5 % / 0,7 kg brutto ± 5 % 1,0 kg netto ± 5 % / 1,3 kg brutto ± 5 % 2,0 kg netto ± 5 % / 2,4 kg brutto ± 5 %
Packing	Spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil.
Colour	See www.filament-pm.com
Solvents	Aceton

Printing Properties

Temperature HE	Ø 1,75: 220 - 250 °C / Ø 2,85: 230 - 260 °C
Temperature HB	100 - 110 °C
Surface bed	Kapton, Ultem, PET foil, commons for FDM printing
Cooling print object	No
Nozzle	All diameters
Printer space	Open / Close

Material Properties

Thermal	Vicat softening temperature	IISO 306	96 °C
	Heat deflection temperature	ISO 75	89 °C
Mechanical	Impact strength	ISO 179	20 kJ/m ²
	Flexural modulus	ISO 178	1 800 MPa
Physical	Density	ISO 1183/B	1,04 g/cm ³
	Melt Flow Index	ISO 1133	40 g/10 min



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