

TECHNICAL DATA SHEET FOR PRODUCT: ASA FILAMENT

Use	is a material for the FDM (FFF) 3D printing additive technology		
Material	Acrylonitril styren acrylate, petroleum product		
Diameters	1,75 or 2,85 mm		
Tolerance	± 0,05 mm		
Weight	0,75 kg netto ± 5% / 0,9 kg brutto ± 5%		
Packing	spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil		
Colours	views on web https://www.filament-pm.com/asa-1-75		
Solvents	Acetone		
Printing Properties:			
Temperature HE	Ø1,75: 240 – 260 °C		Ø 2,90: 250 – 270°C
Temperature HB	100 °C		
Surface bed	kapton, ultem, PET foil, commons for FDM printing		
Cooling print object	MAX 30%		
Nozzle	All diameters		
Printer space	Open / Close		
Material Properties:			
Thermal	vicat softening temperature	ISO 306	96 °C
	heat deflection temperature	ISO 75	87 °C
Mechanical	impact strength	ISO 179	12 kJ/m²
	flexural modulus	ISO 178	1800 MPa
Physical	Density	ISO 1183/B	1,07 g/cm³
	Melt Flow Index	ISO 1133	20 g/10 min