

## TECHNICAL DATA SHEET FOR PRODUCT: ABS FILAMENT

<b>Use</b>	is a material for the FDM (FFF) 3D printing additive technology		
<b>Material</b>	Acrylonitrilbutadienstyrene, petroleum product		
<b>Diameters</b>	1,75 or 2,90 mm		
<b>Tolerance</b>	± 0,05 mm		
<b>Weight</b>	0,5 kg netto ± 5% / 0,7 kg brutto ± 5%		
	1,0 kg netto ± 5% / 1,3 kg brutto ± 5%		
<b>Packing</b>	spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil		
<b>Colours</b>	views on web <a href="https://www.filament-pm.com/abs-not-dead">https://www.filament-pm.com/abs-not-dead</a>		
<b>Solvents</b>	Acetone		
<b>Printing Properties:</b>			
<b>Temperature HE</b>	220 – 250 °C		
<b>Temperature HB</b>	100 °C		
<b>Surface bed</b>	kapton, ultem, PET foil, commons for FDM printing		
<b>Cooling print object</b>	NO		
<b>Nozzle</b>	All diameters		
<b>Printer space</b>	Open / Close		
<b>Material Properties:</b>			
<b>Thermal</b>	vicat softening temperature	ISO 306	<b>94 °C</b>
	heat deflection temperature	ISO 75	<b>89 °C</b>
<b>Mechanical</b>	impact strength	ISO 179	<b>20 kJ/m<sup>2</sup></b>
	flexural modulus	ISO 178	<b>1800 MPa</b>
<b>Physical</b>	Density	ISO 1183/B	<b>1,04 g/cm<sup>3</sup></b>
	Melt Flow Index	ISO 1133	<b>40 g/10 min</b>