



# TECHNICAL DATA SHEET

## ABS

**ABS** - universal material, characterized by durability and high mechanical strength. It is also a material easy to to post-process. ABS is used in production, especially in prototyping elements with higher rigidity.



### PHYSICAL PROPERTIES

	VALUE	UNIT	TEST METHOD
Density	1,04	g/cm <sup>3</sup>	ASTM D792
Water Absorption	0,85	%	-

## MECHANICAL PROPERTIES

	VALUE	UNIT	TEST METHOD
Young's modulus	2,5	GPa	-
Elasticity	2	GPa	-
Tensile Strength	520	kg/cm <sup>2</sup>	ASTM D638
Tensile Elongation	30	%	ASTM D638
Flexural strength	800	kg/cm <sup>2</sup>	ASTM D790
Izod impact strength 23°C	20	kg×cm/cm	ASTM D256
Izod impact strength 30°C	8	kg×cm/cm	ASTM D256
Rockwell Hardness	110	-	ASTM D785

## THERMAL PROPERTIES

	VALUE	UNIT	TEST METHOD
Heat Deflection Temperature 0,45 MPa	90	°C	ASTM D648
Heat Deflection Temperature 1,8 MPa	86	°C	
VICAT Softening Temperature	94	°C	ASTM D1525
Flammability class	HB	-	UL94

## RECOMMENDED PRINTING PARAMETERS



Nozzle temperature

235 – 255°C



Bed temperature

70 – 110°C



Heated chamber

65°C



Drying temperature

60°C

