



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	240-260	internal
plate temp	C°	90	internal
min. nozzle diameter	mm.	0,2	internal
fan	%	0-20	internal
print speed	mm/l°	30-60	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.10	ISO 1183
Mechanical at 23°C / 50% rh			
Young modulus	MPa	2140	ISO 527
Tensile stress	MPa	30	ISO 527
Strain at break	%	22	ISO 527
Charpy notched impact strength	kJ/m ²	9	ISO 180
Thermal			
Melting point	°C	128	ISO 11357
H.D.T.	°C	88	ISO 75-2
Electrical			
Surface resistivity	Ohm/sq	>1.00.10 ⁶	IEC 167

Disclaimer

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ADDITIONAL INFORMATIONS

In General filaments made with ABS ESD can be processed on conventional 3D printer using FDM / FFF technology.

ABS ESD is a special ABS developed for 3D printing and to obtain best results we recommend pre drying the filaments at 70° for 2 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 210°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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