

Technical Data Sheet

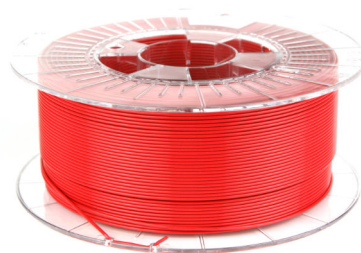
smart ABS Filament

The material offered by Spectrum Group Sp. z o.o. has been developed and adapted to general modeling. Tests performed by Spectrum Group have showed that it is feasible to use the offered product in most 3D printers operating in FDM/FFF technology available on the market. Before the first use, it is advisable to print out a hard proof to check if the filament is compatible with your 3D printer.

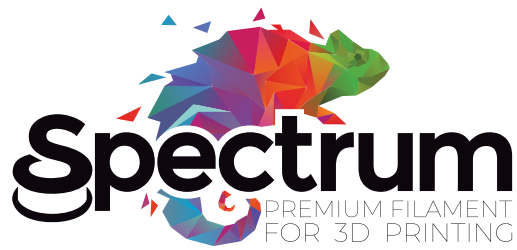
Physical properties	Typical value	Test Method
Material density	1.04 g/cm ³	ASTM D792
Melt Flow Rate (220°C, 10kg)	21 g/10min	ASTM D1238
Molding Shrinkage	0.4%	ASTM D955
Dimensional tolerance	± 0.05mm	

Mechanical properties	Test condition	Typical value	Test Method
Tensile Strength	50mm/min	460 kg/cm ²	ASTM D638
Tensile Elongation	50mm/min	>10%	ASTM D638
Notched Izod Impact 3.2mm	23°C	33 kg*cm/cm	ASTM D256
Rockwell Hardness	R-Scale	108	ASTM D785
Flexural Modulus	15mm/min	25,000	ASTM D790
Flexural Strength	15mm/min	740	ASTM D790

Thermal properties	Test condition	Typical value	Test Method
Heat Deflection Temperature	18.6kg	85°C	ASTM D648
Vicat Softening Temperature	5kg, 50°C/h	93°C	ASTM D1525



Technical data is provided according to the data of the base material and it is for information only.

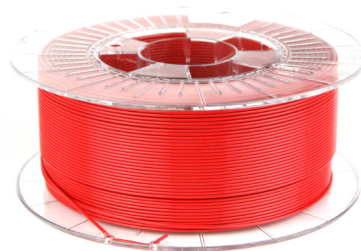


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Flammability	Typical value	Test Method
1.5mm	class HB	UL 94
3.0mm	class HB	UL 94

Printing properties	Typical value	Test Method
Printing temperature	230-255°C	
Bed temperature	100°C	



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