



SUGGESTED PRINT SETS (I)			
Suggested print sets	unit	value	test method
extruder temp	°C	235-250	internal
plate temp	°C	90	internal
min. nozzle diameter	mm.	0,2	internal
fan	%	0-70	internal
Max print speed	mm/sec.	510	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.05	ISO 1183
Mechanical at 23°C / 50% rh			
Flexural modulus	MPa	2400	ISO 527
Tensile stress	MPa	45	ISO 527
Charpy impact (23°C)	kJ/m²	23	ISO 179
Charpy impact (-30°C)	kJ/m²	10	ISO 179
Thermal			
H.D.T. B	°C	90	ISO 75-2
H.D.T.A	°C	80	ISO 75-2
Vicat softening temp.	°C	100	ISO 306

Disclaimer

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ADDITIONAL INFORMATIONS

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

ABS FF 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 200°, 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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