

## TECHNICAL DATA SHEET

<b>Use</b>	is a material for the FDM (FFF) 3D printing additive technology		
<b>Material</b>	Acrylonitrilbutadienstyrene MMA, Petroleum product		
<b>Diameter</b>	1,75 mm / 2,85 mm		
<b>Tolerance</b>	± 0,05 mm		
<b>Weight</b>	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>	See <a href="http://www.filament-pm.com">www.filament-pm.com</a>		
<b>Solvents</b>	Aceton		
<b>Printing Properties</b>			
<b>Temperature HE</b>	Ø 1,75: 230 - 250 °C, Ø 2,85: 250 - 280 °C		
<b>Temperature HB</b>	100 - 110 °C		
<b>Surface bed</b>	Kapton, Ultem, PET foil, commons for FDM printing		
<b>Cooling print object</b>	No		
<b>Nozzle</b>	All diameters / for glitter using nozzle min 0,5 mm and more		
<b>Printer space</b>	Open / Close		
<b>Material Properties</b>			
<b>Thermal</b>	Vicat softening temperature	ISO 306	100 °C
	Heat deflection temperature	ISO 75	97 °C
<b>Mechanical</b>	Impact strength	ISO 179	20 kJ/m <sup>2</sup>
	Flexural modulus	ISO 178	2000 MPa
<b>Physical</b>	Density	ISO 1183/B	1,08 g/cm <sup>3</sup>
	Melt Flow Index	ISO 1133	2 g/10 min