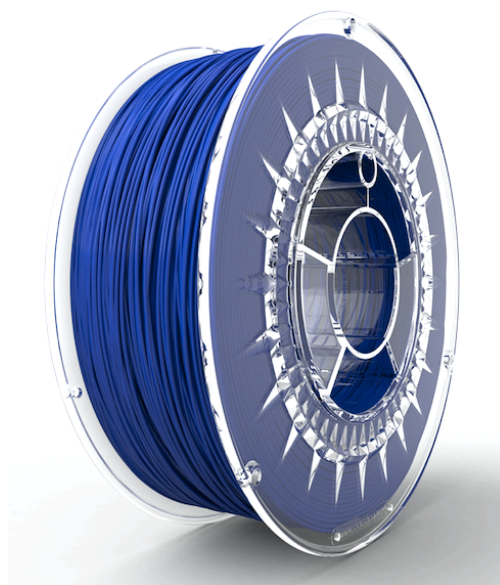


Product card: ABS+ filament for 3D printing.

**Product description:** Filament ABS+ - thermoplastic product in the form of fiber, used for 3D printing using the FFF method. Filament wound on a spool, vacuum packed with a moisture absorber. The spool contains 1 kg of net material. It can be used in all FFF printers that are not protected from external suppliers and open source structures before using. ABS+ is easily machined such as grinding, drilling or smoothing, the material is soluble in acetone.

Physical properties of the product:

|                                   |                           |
|-----------------------------------|---------------------------|
| Diameter of filament              | 1.75 mm / 2.85 mm         |
| Dimensional tolerance of filament | +/- 0.05 mm               |
| Roundness of filament             | +/- 0.02 mm               |
| Surface of the material           | Gloss                     |
| Shrinkage of the material         | Large                     |
| Product weight                    | 1.0 kg net, 1.4 kg gross  |
| Spool - material                  | Transparent polycarbonate |
| Weight of the empty spool         | ~257 g                    |
| The diameter of the spool         | 200 mm                    |
| Width of spool                    | ~70 mm                    |
| Diameter of mounting hole         | 52 mm                     |
| Packaging                         | Printed cardboard         |
| Package size                      | ~230x210x80 mm            |
| Vacuum packing                    | Yes                       |
| Moisture absorber                 | Yes                       |



Suggested printing parameters:

|                      |                 |
|----------------------|-----------------|
| Hotend               | 230-240°C       |
| Heated bed           | 90-100°C        |
| Cooling the printout | Not recommended |

*Due to the structural differences of printers, the above figures should be considered as guidelines and the corresponding values must be determined experimentally.*

## Physical properties of the material:

|                             |                        |            |
|-----------------------------|------------------------|------------|
| Specific Gravity            | 1.04 g/cm <sup>3</sup> | ASTM D792  |
| Vicat Softening Temperature | 94°C                   | ASTM D1525 |
| Flammability                | HB                     | UL 94      |
| Rockwell Hardness (R-Scale) | 105                    | ASTM D785  |
| Tensile Strength - Yield    | 430 kg/cm <sup>2</sup> | ASTM D638  |
| Tensile Elongation - Break  | 30%                    | ASTM D638  |

## Availability of colors and diameters:

| Color         | Kolor        | 1.75 | 2.85 |
|---------------|--------------|------|------|
| Natural       | Naturalny    | ✓    |      |
| White         | Biały        | ✓    | ✓    |
| Vanilla       | Waniliowy    | ✓    |      |
| Bright Yellow | Jasnożółty   | ✓    | ✓    |
| Yellow        | Żółty        | ✓    |      |
| Orange        | Pomarańczowy | ✓    |      |
| Pink          | Różowy       | ✓    |      |
| Lilac         | Wrzosowy     | ✓    |      |
| Hot Red       | Czerwień     | ✓    |      |
| Red           | Czerwony     | ✓    | ✓    |
| Raspberry Red | Malinowy     | ✓    |      |
| Pc Gray       | Jasnoszary   | ✓    |      |
| Gray          | Szary        | ✓    |      |
| Blue          | Błękitny     | ✓    |      |
| Super Blue    | Niebieski    | ✓    | ✓    |
| Navy Blue     | Granatowy    | ✓    |      |
| Violet        | Fioletowy    | ✓    |      |
| Mint          | Seledynowy   | ✓    |      |
| Bright Green  | Jasnozielony | ✓    | ✓    |
| Green         | Zielony      | ✓    |      |
| Gold          | Złoty        | ✓    |      |
| Aluminum      | Aluminiowy   | ✓    |      |
| Beige         | Beżowy       | ✓    |      |
| Brown         | Brązowy      | ✓    |      |
| Black         | Czarny       | ✓    | ✓    |

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