

ABS natur + color masterbatch

- Temperature print: 220-250°C for 2,90 mm filament / 200–230°C for 1,75 mm filament
- Temperature pad: about 70-120°C

Material data sheet for ABS natur:

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.05 g/cm ³	1.05 g/cm ³	ISO 1183/B
Apparent Density	0.65 g/cm ³	0.65 g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.2 g/10 min	5.2 g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	0.323 in ³ /10min	5.30 cm ³ /10min	ISO 1133
Molding Shrinkage - Flow	0.0040 to 0.0070 in/in	0.40 to 0.70 %	ISO 294-4
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus			ISO 527-2
0.126 in (3.20 mm), Injection Molded	310000 psi	2140 MPa	
Tensile Stress			ISO 527-2/50
Yield, 0.126 in (3.20 mm), Injection Molded	6240 psi	43.0 MPa	
Tensile Strain			ISO 527-2/50
Yield, 0.126 in (3.20 mm), Injection Molded	2.7 %	2.7 %	
Flexural Modulus			ISO 178 ^{1,2}
0.126 in (3.20 mm), Injection Molded	297000 psi	2050 MPa	
Flexural Strength			ISO 178 ^{1,2}
0.126 in (3.20 mm), Injection Molded	9430 psi	65.0 MPa	
Elastomers	Nominal Value (English)	Nominal Value (SI)	Test Method
Fogging	98 %	98 %	ISO 6452 ³
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			
-22°F (-30°C), Injection Molded	6.2 ft-lb/in ²	13 kJ/m ²	ISO 179/1eA
-22°F (-30°C), Injection Molded	4.3 ft-lb/in ²	9.0 kJ/m ²	ISO 179/2C
73°F (23°C), Injection Molded	11 ft-lb/in ²	23 kJ/m ²	ISO 179/1eA
73°F (23°C), Injection Molded	7.1 ft-lb/in ²	15 kJ/m ²	ISO 179/2C
Notched Izod Impact Strength			ISO 180/1A
-22°F (-30°C), Injection Molded	5.71 ft-lb/in ²	12.0 kJ/m ²	
73°F (23°C), Injection Molded	11.9 ft-lb/in ²	25.0 kJ/m ²	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			ISO 75-2/A
264 psi (1.8 MPa), Annealed	214 °F	101 °C	
Vicat Softening Temperature	216 °F	102 °C	ISO 306/B50