

IDENTIFICATION OF THE MATERIAL

Trade name	ABS PRO
Chemical name	Acrylonitrile butadiene styrene
Chemical family	Thermoplastic Copolymers
Use	3D printing
Brand	3dcolors

GUIDELINE FOR PRINT SETTINGS - Settings are based on a 0.4 mm nozzle

Nozzle temperature	245 ± 10 °C
Bed temperature	80 - 90 °C
Bed modifications	Tape, glue or other adhesives
Active cooling fan	No/Yes (up to 15%)
Layer height	0.08 - 0.2 mm
Layer thickness	0.4 - 0.8 mm
Print speed	50 - 100 mm/s

THERMAL PROPERTIES

		Test Method
Melting temperature	235 ± 10 °C	ISO 294
Printing temperature	245 ± 10 °C	/
Vicat softening temp.	97 °C	ISO 306

FILAMENT SPECIFICATIONS AND TOLERANCE

Diameter 1.75	1.75 ± 0.05 mm
Roundness	95%
Net weight on reel	750 g ± 2%

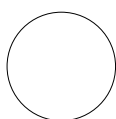
Think it, make it!

PHISICAL PROPERTIES	Typical value	Test Method
Specific gravity	1,1 g/cc	ISO 1183
MFR 260°C (5kg)	41 gr/10min	ISO 1133
Tensile strength at yield	43,6 Mpa	ISO 527
Strain at break	34%	ISO 527
Tensile modulus	2030 MPa	ISO 527
Impact strength *Charpy notched 23°C	58 kJ/m ²	ISO 179

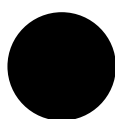
ABS PRO FEATURES:

- Zero warp technology
- Excellent interlayer adhesion
- Reliable bed adhesion (Glass, tape & other adhesives)
- Enhanced mechanical properties over regular ABS
- Great strength & aesthetics
- High temperature resistance (up to 97 °C)

LIST OF COLOURS:



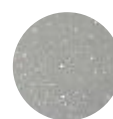
White
RAL 9003



Black
RAL 9017



Grey
RAL 7011



Silver
RAL 9006



Green
RAL 6018



Blue
RAL 5002



Red
RAL 3020



Orange
RAL 2008

Think it, make it