



## Description

**ABS Prime** is our high-end zero warp engineering filament, based on regular ABS. Due to our enhanced formulation, ABS Prime has exceptional strength with an increased impact resistance and excellent interlayer adhesion.

With ABS Prime you will create precise, detailed prints that are both durable and have a beautiful surface finish.

## Typical properties

	Standard	Value	Unit
Specific gravity	ISO 1133	1.13	g/cc
Melt flow rate	ISO 1133	39	cm <sup>3</sup> /10 min
Melting temp.	ISO 294	235±10	°C
Heat deflect. temp.	ISO 75	97	°C

## Typical properties (3D printed)

	Standard	XY Value	XZ Value	ZX Value	Unit
Tensile Strength	ISO 527-2	30.9	33.5	11.5	MPa
Yield Strength	ISO 527-2	25.2	26.6	/	MPa
Tensile Modulus	ISO 527-2	1600	1600	1400	MPa
Strain at Yield	ISO 527-2	3.2	3.2	0.9	%
Flexural Strength	ISO 178	47.3	55.5	24.3	MPa
Flexural Modus	ISO 178	1600	1700	1500	MPa
Impact Strength	ISO 179	55.5	/	/	kJ/m <sup>2</sup>

All specimens were printed with 100% infill, 2 shells and a layer height of 0.2mm

## Printing recommendations

	Standard	Value	Unit
Printing temp.	AF	245±10	°C
Bed temp.	AF	90	°C
Printing speed	AF	≤250	mm/s
Cooling	AF	30	%
Bed surface	/	Textured PEI	/

