

ESD ABS Filament

Technical Data Sheet



Main Specifications

Physical Properties	Test Means		
Density	ISO 1183	1.08~1.1	g/cm ³
MFR (220 °C/2.16Kg)	ISO 1133	8~12	g/10min
Moisture Absorption (23 °C/24h)	ISO 62	<1	%
Mechanical Properties			
Tensile strength (X-Y)	ISO 534	35~37	Mpa
Surface resistivity (X-Y)	ISO 2878	10 ⁶ ~10 ⁸	Ω/sq
Elongation at break (X-Y)	ISO 527	5~7	%
Flexural Modulus (X-Y)	ISO 527	1300~1500	Mpa
Flexural Strength (X-Y)	ISO 178	60~61	Mpa
Impact Strength (X-Y)	ISO 180	6~7	KJ/m ²
Thermodynamic Properties			
HDT @ 0.455 MPa (66 psi)	ISO 75	85	°C

Recommended Printing Parameters

Parameters	
Nozzle Temperature	220~240°C
Bed Temperature	100~120°C
Bed Materials	Tempered glass, BuildTak, Carbon fiber board
Nozzle Diameter	φ 0.4/0.6
Model Cooling Fan	0~20%
Layer	0.12~0.3mm
Printing Speed	40~60mm/s
Retraction Distance	1~3mm
Retraction Speed	30~50mm/s
Supporting Materials	Itself, HIPS