



# PLASTIKATRČEK

## ABS FR technical data sheet

RECOMMENDED PRINTING SETTINGS	VALUE	STANDARD
Extruder temp.	220-240°C	
Bed temp.	80°C	
Fan speed	100%	
Printing speed	50 mm/s	
Mechanical properties		
Tensile Yield Strength, 3,2mm	440 kg/cm <sup>2</sup>	D638
Tensile Modulus, 3,2mm	23,000 kg/cm <sup>2</sup>	D638
Tensile elongation at break 3,2mm	20%	D638
Notched Izod Impact Strength 3,2mm	24 kg.cm/cm	D256
Flexural Strength 6,4mm	720 kg/cm <sup>2</sup>	D790
Flexural Modulus 6,4mm	27,000 kg/cm <sup>2</sup>	D790
Rockwell Hardness (R-Scale)	104	D785
Physical properties		
Specific Gravity, g/cc	1,19	D792
Thermal		
Vicat softening temperature	83 °C	D1525
Flammability	Class V-0	UL94

### Additional info :

Printing temperature, bed temperature and printing speed can vary from printer to printer and also nozzle diameter.

Filament is used for FFF/FDM 3D printing.

Tend to absorb moisture from environment. Long exposure to moisture can develop printing problems if not sealed correctly.

**Disclaimer:** Plastika Trček d.o.o. does not carry any responsibilities for injury caused by our filaments.