

TECHNICAL DATA SHEET FOR PRODUCT: PC/ABS FILAMENT

Use	is a material for the FDM (FFF) 3D printing additive technology		
Material	Polycarbonate/Acrylonitrilbutadienstyrene, petroleum product		
Diameters	1,75 mm		
Tolerance	± 0,1 mm		
	1,0 kg netto ± 5% / 1,3 kg brutto ± 5%		
Packing	spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil		
Colours	views on web https://www.filament-pm.com/pc-abs		
Solvents	Acetone		
Printing Properties:			
Temperature HE	240 – 260 °C		
Temperature HB	110 °C		
Surface bed	kapton, ultem, PCABS Juice (blend Acetone)		
Cooling print object	NO		
Nozzle	All diameters		
Printer space	Close		
Material Properties:			
Thermal	vicat softening temperature	ISO 306	115 °C
	heat deflection temperature	ISO 75	98 °C
Mechanical	impact strength	ISO 179	40 kJ/m²
	flexural modulus	ISO 178	2650 MPa
Physical	Density	ISO 1183/B	1,19 g/cm³
	Melt Flow Index	ISO 1133	11 g/10 min
Flammability	Fire resistance	UL94	V0 Class