

## Technical specification - Everfil™ ABS-L.01

### DESCRIPTION

**ABS** Acrylonitrile butadiene styrene is a common thermoplastic polymer. ABS is amorphous and therefore has no true melting point.

**Everfil™ ABS-L.01** filament is a formulation of ABS plastic intended to help your 3D prints stand out with a beautiful, glossy, opaque finish and best used when producing high quality, precision 3D prints. Printed parts Everfil™ ABS-L.01 filament will withstand higher temperatures than PLA plastic.

The natural material is an opaque ivory colour and is readily coloured with pigments or dyes.

### TYPICAL PROPERTY VALUES

Filament	Nominal Value	Unit	Test Method
Filament diameter	1,75 , 2,85	mm	-
Diameter tolerance	+/- 0,03	mm	-
Spool weight	1,0 , 3,0	kg netto	-

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1,04	g/cc	ISO 1133
MFR	5,5	g/10min	ISO 1133
Molding Shrinkage (Flow), 3.2mm	0.4 ~0.8	%	ISO 294-4
Vicat Softening Temperature	98	°C	ISO 306
Clarity	Non transparent		

Mechanical	Nominal Value	Unit	Test Method
Tensile Yield Strength	40	MPa	ISO 527
Rockwell Hardness	100	-	ISO 2039
Tensile Modulus	2,10	MPa	ISO 527
Charpy Impact Strength	33.0 (23°C)	kJ/m2	ISO179/1eA
IZOD Impact Strength	33.0 (23°C)	kJ/m2	ISO 180/1A
Flexural Strength	60	MPa	ISO 178
Flexural Modulus	2,0	MPa	ISO 178
Heat Deflection Temp.	82 (0.45 MPa)	°C	ISO 75/Ae

### PRINT CONDITIONS Everfil™ ABS-N.01 (may be different for different printers)

3D Printers	Typical Value	Unit
Extruder temperature	220 – 245	°C
Bed temperature (is required)	90 – 110	°C
Cooling (according to design)	10 – 30	%

### STORAGE

Filament can't handle moisture very well and that is why we recommend storing your filament in a cool, dry environment, ideally in a package vacuum sealed with silicate.

