

ELIX ABS-3D GP

All-purpose ABS material optimized for FDM 3D-printing technology

Major Benefits

- High resolution
- High strength
- Easy printability
- Versatile material
- Hands-free support removal

Chemical composition

Acrylonitrile-butadiene-styrene (ABS) copolymer

Physical form

White to slightly yellowish pellets.

3D printing material properties

<i>Properties</i>	<i>Values</i>
Flowability	Medium
Heat Resistance	Medium
Strength	High
Warping	Standard
Resolution	Good

ABS General properties

Properties	Test condition	Unit	Standard	Value
Rheological properties				
Melt Volume- flow Rate	220°C, 10 Kg	cm ³ /10'	ISO 1133	18
Mechanical Properties (23°C /50% H.R.)				
Yield Stress	50 mm/min	MPa	ISO 527-1,2	39
Elongation at Break	1 mm/min	%	ISO 527-1,2	13
Tensile modulus	1 mm/min	MPa	ISO 527-1,2	2100
Flexural modulus	2 mm/min	MPa	ISO 178	2000
Izod notched impact strength	23 °C	KJ/m ²	ISO 180-1A	19
Izod notched impact strength	- 30 °C	KJ/m ²	ISO 180-1A	10
Ball Indentation Hardness		N/mm ²	ISO 2039-1	95
Thermal properties				
Vicat softening temperature	B50, 50 °C/h	°C	ISO 306	95
Burning behavior UL 94	1.6 mm	Class	UL94	HB
Other properties				
Density	25°C	g/cm ³	ISO 1183-1	1040

Processing conditions for 3D printing	Value
Temperature resistance	95 °C
Slumping temperature	105 °C
Printing temperature	230 – 250 °C
Recommended printbed temperature	80 – 100 °C

Disclaimer for sales products

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Test values

Unless specified to the contrary, the values given have been established on standardised test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the colouring.

Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

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