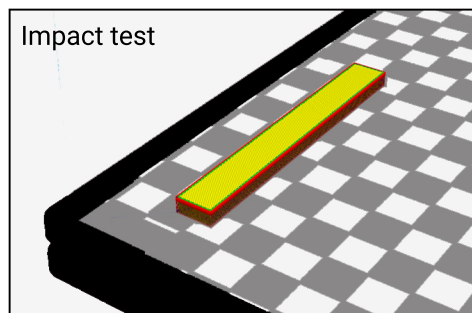
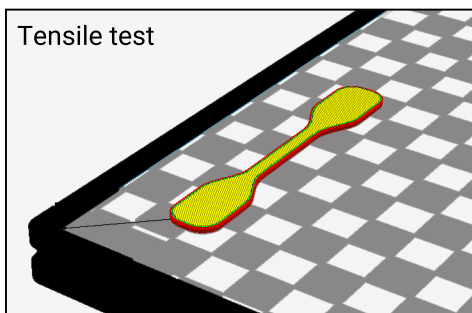


## ABS ESD Filament

ABS ESD Filament has been designed for protection of electronic devices which are sensitive to electrostatic discharges. The material prevents the risk of damage to vulnerable electronic components due to its dissipative properties. Its surface resistivity ranging from  $10^7$  to  $10^9$  Ohm. The filament is ideal for industrial applications like housings / casings for connectors, sensors and measuring devices. Available in black and its natural color.

MATERIAL PROPERTIES	TYPICAL VALUE	TEST METHOD
Density	1.03 g/cm <sup>3</sup>	ISO 1183
Tensile Strength	24.3 MPa	ISO 527
Elongation at Tensile Strength	3.1 %	ISO 527
Tensile Modulus	1,121 MPa	ISO 527
Tensile Stress at Break	19.8 MPa	ISO 527
Tensile Elongation at Break	6.4 %	ISO 178
Charpy impact resistance	10.9 kJ/m <sup>2</sup>	ISO 179
Shore Hardness	66,7D	ISO 868
Glass transition temp. (Tg)	106 °C	ISO 11357
Surface resistivity	107 - 109 Ohms/m2	ASTM D257
PRINT RECOMMENDATIONS		
Nozzle Temperature	250-270 °C	
Bed Temperature	100°C	
Print Speed	40 mm/s	
Drying recommendations	2-4 hours, 80°C	

**Disclaimer:** 3D4Makers makes no warranties what so ever, either expressed or implied, including but not limited to, any implied fitness for any particular purpose. From the moment the product is shipped it is beyond our control. The information in this document is believed to be correct at the time of writing. However, handling, processing, settings, the type of 3D printer, slicing and other variables are completely up to the user. The method through which the product is used can be varied. It is up for the customer to determine how it is 3D printed and whether it is fit for purpose or suited to a particular application.



- ☒ Nozzle temp : 260°C
- ☒ Bed temp : 100°C
- ☒ Infill : 100%
- ☒ Infill angle : 45°/-45°
- ☒ Print speed : 40 mm/s

**Additional info:** To get the best results while printing we advise you to keep the 3D printer in a room where there is hardly any draft and/or temperature fluctuations. Keep the 3D printer out of direct sunlight. When the 3D printer is not being used it is important to keep the 3D4Makers ABS ESD filament in a bag and stored in a cool, dry and dark place until it is used again.