TECHNICAL DATA SHEET

ABS

/Acrylonitrile Butadiene Styrene/

Kings 3D Printing

RoHS COMPLIANT

- High Impact Resistance
- High Light Transmission
- Good Toughness
- Good Fluidity

Material Overview

Combining high strength, high toughness, and superb heat resistance, ABS can readily tackle intricate designs and demanding conditions during model building, making it a perfect option for industrial prototyping, artistic figures, and beyond.

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Kings 3D Printing

Filament Diameter	1.75mm/2.85mm/ 3.50mm
Net Weight	1KG \ Inner Box Dimension: 206*71*208mm \ G.W.: 1.35KG
Package	1KG*10PCs \ Outer Carton Dimension: 382*226*433mm \ G.W.: 14KG/CTN

Printing Tips

- Best printing temperature ranges from 220℃ to 250℃
- Best phototype can be achieved through 50℃ drying for 2-4 hours
- Print Temp: 250-260℃ 50-100mm/s
- Print Temp: 260-280℃ 100-200mm/s
- Platform Temp.: 80-100℃
- Bubble: 100% no bubble
- Melt Mass Flow Rate: 12-19g/10min
- (220℃,10kg) * Breaking Elongation: 25%

Colors

Nature Black Red Yellow Blue Green Purple

Pink Gold Silver Orange Grey Glow blue Glow green

(Standardized pantone colors are available)

Data Table

Physical Properties	Standard Value	Test Method
Density	1.05-1.18g /cm^3	ASTM D792
MFR (220℃, 2.16KG)	12-19g / 10 minutes	ASTM D1238
Water absorption (saturation, 23℃)	0.3%	ASTM D570

Mechanical Properties	Standard Value	Test Method
Tensile strength	≥46 MPa	ASTM D638
Flexural strength	≥46 MPa	ASTM D638
Tensile modulus	≥2,270 MPa	ASTM D638
Notch impact strength (IZOD, 23℃)	≥3KJ/m^2	ISO 180
Elongation at break	≥3.0%	ASTM D638

Accuracy	Standard Value	Test Method
Filament diameter	1.75mm/2.85mm/3.50mm	Q/WT 001-2014
Roundness deviation	≤0.02mm	Q/WT 001-2014

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