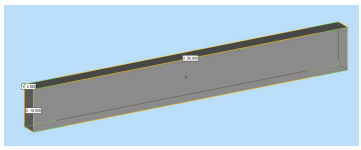
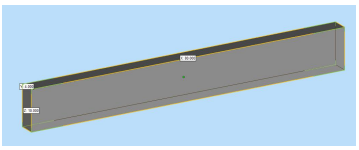
Filament Data Sheet

ABS+

Revision Date:08/01/2026
Application: FDM
Version：01

RECOMMENDED PRINTING CONDITIONS	
Nozzle Temperature	240-270°C
Bed Temperature	50-70°C
Closure Chamber	Recommended open printing
Drying Setting	70°C for 8H

FLEXURAL TESTING SPECIMEN	TENSILE TESTING SPECIMEN	IMPACT TESTING SPECIMEN
ISO 178/T 9341	ISO 527,GB/T 1040	ISO 180,GB/T1043
		

PHYSICAL PROPERTIES				
Performance	**Condition**	**Starndards**	**Unit**	**Values**
Density	25°C	ISO 1183	g/cm³	1.033
Melt Flow Rate	250°C/2.16kg	ISO 1133	g/10min	11.1

MECHANICAL PROPERTIES				
Performance	Condition	Starndards	Unit	Values
TensileStrength （X-Y）	10*4mm sample	ISO 527-2	MPa	34.79
TensileStrength （Z）	10*4mm sample	ISO 527-2	MPa	22.94
Elongation at break（X-Y）	10*4mm sample	ISO 527-2	%	11.26
Elongation at break（Z）	10*4mm sample	ISO 527-2	%	5.31
Bending modulus(X-Y)	10*4mm sample	ISO178	MPa	1539.06
Bending modulus(Z)	10*4mm sample	ISO178	MPa	1104.19
Bending strength (X-Y)	10*4mm sample	ISO178	MPa	49.98
Bending strength (Z)	10*4mm sample	ISO178	MPa	32.36
Notched impact strength (X-Y)	10*4mm sample notched	ISO180	KJ/㎡	17.48
Notched impact strength (Z)	10*4mm sample notched	ISO180	KJ/㎡	4.50
Non-notched impact strength (X-Y)	10*4mm sample non notched	ISO180	KJ/㎡	31.07
Non-notched impact strength (Z)	10*4mm sample non notched	ISO180	KJ/㎡	12.09

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