



## ABS-X @df

ABS-X @df is our take on a next-generation ABS filament. By applying our zero warp technology to the filament we have created a filament with far less cracking, proven near perfect interlayers, reliable bed adhesion (glass, tape & other adhesives) while improving the mechanical properties making ABS-X @df extra strong. These properties make ABS-X @df the ultimate ABS replacement that prints strong and beautiful parts on any FDM 3D printer without the common headaches associated with regular ABS like warping & horrible bed adhesion. ABS-X @df is the perfect material for strong objects that require an high impact tolerance.

### Features:

- Zero warp technology
- Excellent interlayer adhesion
- Reliable bed adhesion (Glass, tape & other adhesives)
- Enhanced mechanical properties over regular ABS
- Great strength & aesthetics



### Colours:

ABS-X @df is available from stock in 12 colours. For non stock colours a minimum of 40kg ± 10% is required.



### Packaging:

ABS-X @df is available in nearly any type of packaging and labelling. Ask our team to help you customizing your product.

### Additional info:

Recommended temperature for heated bed is ± 80°C.  
ABS-X @df is printed at high temperatures to make the final product extra strong.  
ABS-X @df can be used on all common desktop FDM or FFF technology 3D printers.  
Storage: Cool and dry (15-25°C). This enhances the shelf life significantly.

### Dimensions

Size	Ø tolerance	Roundness
1,75mm	± 0,05mm	≥ 95%
2,85mm	± 0,10mm	≥ 95%

### Physical properties

Description	Testmethod	Typical value
Specific gravity	ISO 1183	1,1 g/cc
MFR 260°C (5kg)	ISO 1133	41 gr/10min
Yield stress	ISO 527 50mm/min	43,6 Mpa
Strain at break	ISO 527 50mm/min	34%
Tensile (E) modulus	ISO 527 1mm/min	2030MPa
Impact strength Charpy method 23°C	ISO 179	58 KJ/m2

### Thermal properties

Description	Testmethod	Typical value
printing temp.	DF	240-260°C
melting temp.	ISO 294	235 °C +/- 10°C
vicat softening temp.	ISO 306	97°C