

ENHANCED ABS

ABS+ Filament

1.75 mm · 1 kg spool · ±0.03 mm tolerance

Enhanced ABS with improved layer bonding and dimensional stability, for durable functional parts with a satin finish.

- ✓ Tough and impact resistant
- ✓ HDT 85 °C
- ✓ Satin finish
- ✓ Enclosure recommended

Recommended Print Settings

Nozzle temperature	220–240 °C 230 °C recommended
Bed temperature	80–110 °C 100 °C recommended
Print speed	40–60 mm/s
Support material	HIPS, ABS+ (self supported)

Use an enclosed printer and a heated bed to limit warping and cracking.

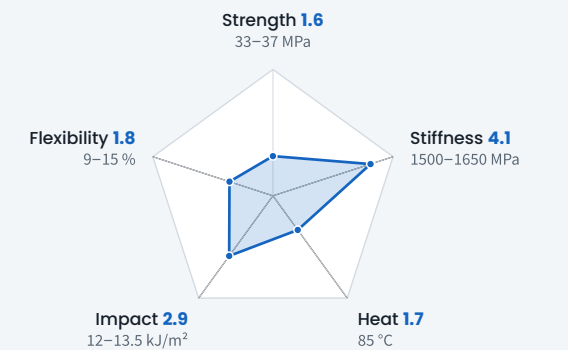
Filament Specifications

Material	Enhanced ABS (ABS+)
Diameter	1.75 mm
Diameter tolerance	±0.03 mm
Net filament weight	1 kg

Spool & Packaging

Empty spool weight	150 g
Spool with filament	1.15 kg
Spool outer diameter	200 mm
Hub diameter	52 mm
Spool width	65 mm
Shipping weight	1.3 kg
Box dimensions	210 × 220 × 75 mm

Property Profile



Scores from 1 to 5 relative to the OzFDM filament range, based on the typical values in this sheet (stiffness and impact on a log scale).

Storage & Handling

- Drying

80 °C for a minimum of 5 hours in a filament dryer or food dehydrator.
- Storage

Airtight bag or container with desiccant in a cool, dark and dry area to prevent moisture absorption. For optimal long term storage we recommend drying the filament prior to sealing the filament spool in a vacuum bag with desiccant.

Mechanical Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Tensile strength	ISO 527	33–37 MPa
Elongation at break	ISO 527	9–15 %
Tensile modulus	ISO 527	1500–1650 MPa
Flexural strength	ISO 178	65–67 MPa
Impact strength	ISO 180	12–13.5 kJ/m ²

Physical Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Density	ISO 1183	1.08–1.1 g/cm ³
Melt flow rate (220 °C, 5 kg)	ISO 1133	2–5 g/10min
Moisture absorption (23 °C, 24 h)	ISO 62	1 %

Thermal Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Heat deflection temperature (0.455 MPa)	ISO 75	85 °C

Available Colours 18

							
Black	White	Natural	Gold	Silver	Grey	Red	Traffic Red
							
Green	Blue	Purple	Pink	Rose	Orange	Brown	Yellow
							
Skin	Olive						

Swatches are indicative only. Colours vary between screens and with print settings.

NOTES

Values shown are typical results measured on test specimens and are provided for guidance only. They are not guaranteed specifications and should not be used as design limits. Printed part properties vary with printer, settings, print orientation and part geometry. Test your parts for suitability before use in critical applications.