

SPARKLE FINISH ABS

ABS+ Sparkling Filament

1.75 mm · 1 kg spool · ± 0.03 mm tolerance

ABS+ with a sparkling finish, for tough functional parts with added visual depth.

✓ Sparkling finish

✓ Tough and impact resistant

✓ HDT 85 °C

✓ Enclosure recommended

Recommended Print Settings

Nozzle temperature 220–240 °C
230 °C recommendedBed temperature 80–110 °C
100 °C recommended

Print speed 40–60 mm/s

Support material HIPS, ABS (self supported)

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

Filament Specifications

Material Sparkle finish 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

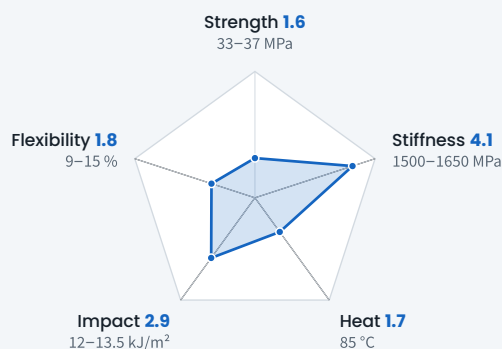
Hub diameter 52 mm

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 5



Glitter Black



Glitter Grey



Glitter Red



Glitter Blue



Glitter Purple

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.