

HIGH SPEED ABS

ABS-HS (High Speed) Filament

1.75 mm · 1 kg spool · ±0.03 mm tolerance

ABS tuned for high speed printing, keeping the toughness and heat resistance ABS is known for.

✓ Up to 300 mm/s

✓ HDT 88 °C

✓ Tough and impact resistant

✓ Enclosure recommended

Recommended Print Settings

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

Print speed 40–300 mm/s

Support material HIPS, ABS (as support interface)

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

Filament Specifications

Material High speed 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

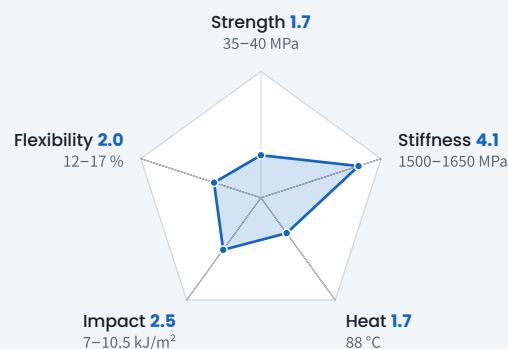
Hub diameter 52 mm

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	35–40 MPa
Elongation at break	ISO 527	12–17 %
Tensile modulus	ISO 527	1500–1650 MPa
Flexural strength	ISO 178	65–70 MPa
Impact strength	ISO 180	7–10.5 kJ/m ²

Physical Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Density	ISO 1183	1.04–1.06 g/cm ³
Melt flow rate (220 °C, 5 kg)	ISO 1133	2–4 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	88 °C

Available Colours 5



Black



White



Red



Grey



Natural

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.