

## COLOUR SHIFTING ASA

## ASA Chameleon Filament

1.75 mm · 1 kg spool · ±0.05 mm tolerance

Weather resistant ASA with a colour shifting finish that changes with lighting and viewing angle.

✓ UV and weather resistant

✓ Colour shifts with viewing angle

✓ HDT 88 °C

✓ Enclosure recommended

## Recommended Print Settings

|                    |                                           |
|--------------------|-------------------------------------------|
| Nozzle temperature | 240–260 °C<br>250 °C recommended          |
| Bed temperature    | 100–120 °C<br>110 °C recommended          |
| Print speed        | 40–60 mm/s                                |
| Support material   | HIPS, ASA (as a self supported interface) |

i Use an enclosed printer to limit warping on larger parts.

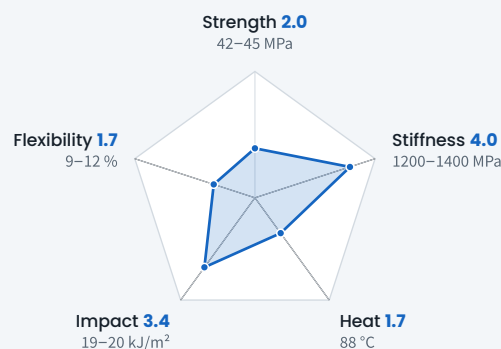
## Filament Specifications

|                     |                     |
|---------------------|---------------------|
| Material            | Colour shifting ASA |
| Diameter            | 1.75 mm             |
| Diameter tolerance  | ±0.05 mm            |
| Net filament weight | 1 kg                |

## Spool &amp; 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 &amp; 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     | 42–45 MPa     |
| Elongation at break | ISO 527     | 9–12 %        |
| Tensile modulus     | ISO 527     | 1200–1400 MPa |
| Flexural strength   | ISO 178     | 75–79 MPa     |
| Impact strength     | ISO 180     | 19–20 kJ/m²   |

### Physical Properties

| PROPERTY                          | TEST METHOD | TYPICAL VALUE   |
|-----------------------------------|-------------|-----------------|
| Density                           | ISO 1183    | 1.08–1.09 g/cm³ |
| Melt flow rate (220 °C, 10 kg)    | ISO 1133    | 20–25 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











Burnt Titanium

Nebula Purple

Noctiluca Blue

Abyssal Red

Abyssal 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.