

# eABS-GF

## Technical Data Sheet

Adding glass fiber reinforced materials to ABS and modifying, it strengthens the rigidity and toughness of ABS, it has excellent impact resistance and chemical corrosion resistance, and has good performance in scenes with high strength requirements such as some tooling and fixtures.

<b>Material Status</b>	<b>Mass Production</b>		
Characteristics	<ul style="list-style-type: none"> <li>• High strength</li> <li>• Wear resistance</li> <li>• Impact resistance</li> </ul>	<ul style="list-style-type: none"> <li>• Chemical resistance</li> </ul>	
Applications	<ul style="list-style-type: none"> <li>• Aerospace</li> </ul>	<ul style="list-style-type: none"> <li>• Automotive</li> </ul>	<ul style="list-style-type: none"> <li>• Industrial applications</li> </ul>
Form	<ul style="list-style-type: none"> <li>• Filament</li> </ul>		
Processing method	<ul style="list-style-type: none"> <li>• 3D Print, FDM Print</li> </ul>		

	testing method	Typical value	
<b>Physical Properties</b>			
Density	GB/T 1033	1.07	g/cm <sup>3</sup>
Melt Flow Index	GB/T 3682	13.2	(220°C/10KG)
<b>Mechanical Properties</b>			
Tensile Strength	GB/T 1040	19.84	MPa
Elongation at Break	GB/T 1040	3.82	%
Flexural Strength	GB/T 9341	60.08	MPa
Flexural Modulus	GB/T 9341	2185.5	MPa
IZOD Impact Strength	GB/T 1843	4.42	kJ/m <sup>2</sup>
<b>Thermal Properties</b>			
Heat distortion Temperature	GB/T 1634	97.65°C	(0.45Mpa)
Continuous Service Temperature	IEC 60216	N/A	
Maximum (short term) Use Temperature		N/A	
<b>Electrical Properties</b>			
Insulation Resistance	DIN IEC 60167	N/A	
Surface Resistance	DIN IEC 60093	N/A	

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### Recommended printing parameters

Extruder Temperature	240 - 280°C
Build Platform Temperature	90°C
Fan Speed	10%
Printing Speed	40-300mm/s

Based on Bambu P1S 0.4 mm nozzle and Orcaslicer1.7.0 Beta. Printing conditions may vary with different

### nozzle diameters Drying Recommendations

N/A

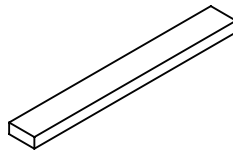
### Precautions:

When slicing, it is best to turn on the Z seam alignment and starting point alignment functions, turn off the Z-axis lift and exit, avoid passing through the shell when idling, optimize the slicing printing path, and appropriately reduce the printing speed to achieve the best printing effect.

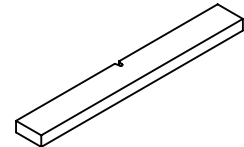
### Mechanical Properties



Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1043

The physical properties, mechanical properties, thermal properties, and electrical properties of the filament are obtained based on the injection molding spline test.

### Print test condition:

Extruder Temperature	275°C
Build Platform Temperature	90°C
Outline/Perimeter Shells	2
Top/Bottom Layers	3
Infill Percentage	100%
Fan speed	10%
Maximum volumetric flow rate	4mm <sup>3</sup> /s

Based on Bambu P1S 0.4 mm nozzle and Orcaslicer2.1.0 Beta.

### Notice

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