ANYCUBIC
3D PRINTER FILAMENT
Version: 3.0

Product Name:

Anycubic ABS

Anycubic ABS is a widely used consumer-grade filament that offers several advantages. It can withstand temperatures up to 85°C and is known for its high toughness and impressive printing success rates. Additionally, it features enhanced anti-warping properties, which help prevent corner lifting, even when printing models with a size of 220mm x 220mm.

Physical Properties

Property	Testing Method	Unit	Typical Value
Density/（g/cm^3）	ISO 1183,at 23°C	g/cm^3	1.05
Melt Index/ (g/10min)	ISO 1133	g/10min	32.1±0.63
Moisture Content	ISO 787-2	%	0.25

Mechanical Properties

Property	Testing Method	Unit	Typical Value
Tensile Strength / MPa (X-Y)	ISO 527	MPa	34
Tensile Strength / MPa (Z)			22
Young's Modulus / MPa (X-Y)	ISO 527	MPa	2200
Young's Modulus / MPa (Z)			/
Elongation at Break / % (X-Y)	ISO 527	%	11
Elongation at Break / % (Z)			/
Bending Strength / MPa (X-Y)	ISO 178	MPa	63
Bending Strength / MPa (Z)			/
Bending Modulus / MPa (X-Y)	ISO 178	MPa	2200
Bending Modulus / MPa (Z)			/
Izod Impact Strength (kJ/m^2) (X-Y)	ISO 179	kJ/m^2	40
Izod Impact Strength (kJ/m^2) (Z)			/

*All data are based on printed test samples. '(X-Y)' and '(Z)' indicate different testing orientations (refer to the direction schematic).

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Thermal Performance

Property	Testing Method	Unit	Typical Value
Glass Transition Temperature	ISO 11357-1, 10℃/min	℃	105
Melting Temperature	ISO 11357-1, 10℃/min	℃	/
Crystallization Temperature	ISO 11357-1, 10℃/min	℃	/
Vicat Softening Temperature (VST)	ISO 306, 10N	℃	95
Heat Deflection Temperature (HDT)	ISO 75-2, 1.8 MPa	℃	/
Heat Deflection Temperature (HDT)	ISO 75-2, 0.45MPa	℃	85

Recommended Printing Parameters

*Based on a 0.4mm nozzle, printing conditions may vary with different nozzle diameters

Parameter	Recommended Value
Nozzle Temperature	240-280
Bed Temperature	80-100
Dry Environment	70-80℃，8-12h
Printing Speed	50-150
Extrusion Multiplier	0.95
Max Volumetric Flow Rate	15
Fan Speed	80%
Cooling Time	3
Minimum printing Speed	20
Raft Separation Distance	0.8
Retraction Speed	40

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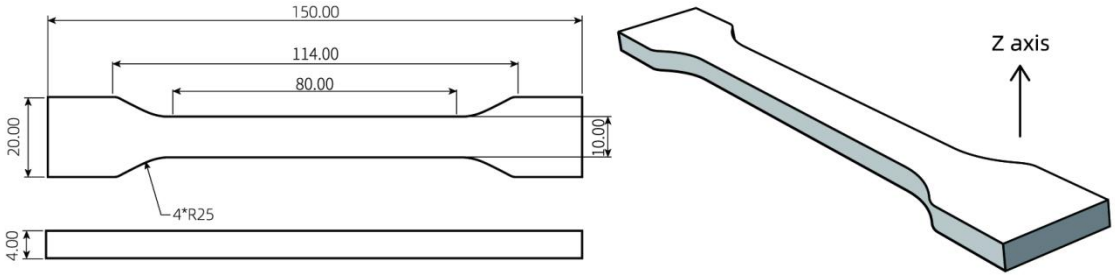
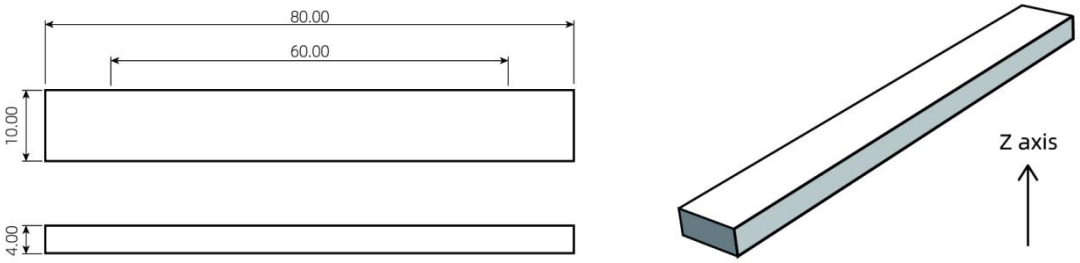
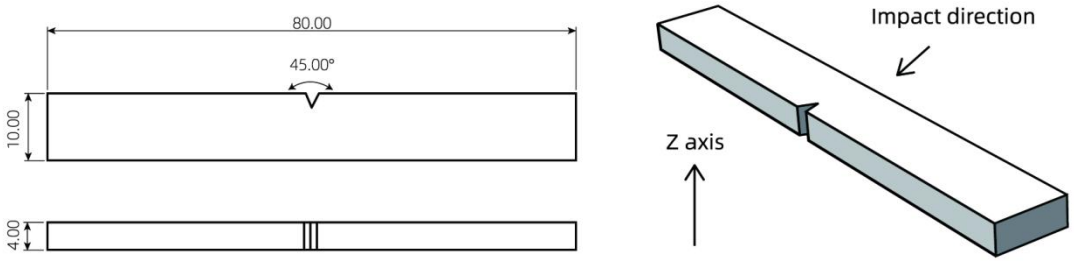
TENSILE TESTING SPECIMEN



FLEXURAL TESTING SPECIMEN



IMPACT TESTING SPECIMEN



Disclaimer：

The values shown in this chart are for comparison purposes only and are not appropriate for design specifications or quality assurance. Variations may arise due to printing conditions. The end-use performance of printed parts depends on materials, design, environmental conditions, and printing conditions. Please note that product specifications are subject to change without notice.

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