

THE FILAMENT ASA

MATERIAL PROPERTIES

General Properties

Specific Gravity	1.07 g/cm3	D 792
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Mechanical Properties

Tensile Strength at Yield	46 MPa	D 638
Tensile Elongation	34%	D 638
Tensile Modulus	1870 MPa	D 638
Flexural Strength	63 MPa	D 790
Izod Impact Strength, Notched, 3.2mm,	450 J/m	D 256

Thermal Properties

Heat Deflection Temperature	86°C	D 648
VICAT	92°C	D 1525

GUIDELINE FOR PRINT SETTINGS\*

Nozzle temperature	230-265°C
Nozzle temperature (High Speed)	
Bed temperature	75-100°C
Closed chamber for printing	recommended for larger prints
Dry box recommended	No
Ruby or hardened nozzle recommended	No
Adhesive	not necessary (if you need increased adhesion or prevent warping: glue stick, Dimafix, 3DLac, Magigoo)
Cooling	0-20%
Surface finish	shiny
Features	resistance to external exposure, changing weather conditions & UV resistance, VICAT - 93°C

\* settings are based on a 0,4 mm nozzle.  
\*\* depending on the geometrical complexity

STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.

SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at [support@spectrumfilaments.com](mailto:support@spectrumfilaments.com)

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