

ABS

Acrylonitrile-Butadiene-Styrene

| FEATURES | APPLICATIONS |
|--|---|
| <ul style="list-style-type: none"> • High strength and toughness • Low shrinkage, excellent dimensional stability • Excellent print performance | <ul style="list-style-type: none"> • Industrial models • Art crafts • Adornments |

| 属性 ^[1] | テスト標準 | テスト条件 | S.I. 単位 | S.I. 一般値 ^[2] | |
|-----------------------------|-----------|----------|-------------------|-------------------------|------|
| | | | | 造形 | 射出成形 |
| 物理的特性 | | | | | |
| 密度 | ISO 1183 | 23℃ | g/cm ³ | 1.02 | |
| ガラス転移温度 | ISO 11357 | 10℃/min | ℃ | 93 | |
| メルトインデックス | ISO 1133 | 220℃,5kg | g/10min | 6.2 | |
| 機械的屬性 | | | | | |
| 引張強さ | ISO 527 | 50mm/min | MPa | 32.5 | 45.2 |
| 切断時伸び | ISO 527 | 50mm/min | % | 10.2 | 35.3 |
| 曲げ強さ | ISO 178 | 2m/min | MPa | 34.6 | 50.5 |
| 曲げ弾性率 | ISO 178 | 2m/min | MPa | 2270 | 2390 |
| アイゾッド衝撃,ノッチ付き | ISO 180 | 23℃ | KJ/m ² | 12.2 | 21.5 |
| Thermal Properties | | | | | |
| Heat distortion temperature | ISO 75 | 0.45MPa | ℃ | 90 | |
| Flammability | UL94 | 1.6mm | Class | HB | |

記載された値はあくまでも一般値なので、実際と異なる場合があります。

造形条件：造形温=230℃、造形速度=80mm/s、さや数=2、ノズルサイズ=0.4mm, 100% 充填

射出成形条件：温度=220℃;背圧=0-1MPa; 成形温度=30-40℃

<http://www.bosikj.com>

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造形時の一般的条件

| 属性 | 一般値 |
|-----------|---------------|
| エクストルーダ温度 | 220-240℃ |
| 造形速度 | 30-100mm/s |
| 床温度 | 100-120℃ |
| 層高 | 0.1-0.2mm |
| インフィル | 必要に応じ100%充填まで |
| 注意事項 | 保温 |

The parameter is just for referential purpose only. In actual processing, the parameter should be adjusted by construction of 3D machine, shape and size of product, and so on.

SAFETY AND HANDLING CONSIDERATIONS

Material safety data sheets (MSDS) for resins are available from Guangzhou Popbit 3D Technology Co. Ltd. and its subsidiaries. MSDS sheets are provided to help customers satisfy their own handling, safety, disposal needs, and those that may be required by locally applicable health and safety regulations.

The following comments are general and applied only to panels as supplied.

These panels have a very low degree of toxicity under normal conditions of use and should pose no unusual problems from ingestion, eye, or skin contact. However, caution is advised when handling, storing, using, or disposing of these panels.

Caution must be used when cutting banding off coil due to

spring-back of material. Always protect eyes with goggles; cover nose and mouth with a filter mask when cutting panels.

Color change of the product may be caused by UV exposure in general. So it is recommended that storage should keep in dry, cool place and avoid direct sunlight

We encourage customers and potential users of our products to review their applications for such products from the standpoint of human health and environmental quality. To help ensure that our products are not used in ways for which they were not intended or tested, our personnel will assist customers in dealing with ecological and product safety considerations. Your sales representative can arrange the proper contacts.