Data Sheet: FDM-PC ABS

DEFAULT INFILL: SOLID

THERMAL PROPERTIES

Property	Unit	Value	Norm
Dimensional stability in heat, at 4.6 bar	°C	110	ASTM D648
Dimensional stability in heat, at 18.2 bar	°C	96	ASTM D648
Glass transition temperature	°C	125	DSC (SSYS)

MECHANICAL PROPERTIES

Property	Unit	Value	Norm
Tensile strength[i]	MPa	41	ASTM D638
Tensile Modulus[i]	MPa	1900	ASTM D638
Elongation at break[i]	%	5	ASTM D638
Flexural Modulus	MPa	1900	ASTM D790
Unnotched IZOD impact strength	J/m	480	ASTM D256
Notched IZOD impact strength	J/m	195	ASTM D256

PHYSICAL PROPERTIES

Property	Unit	Value	Norm
Density	g/cm³	1.1	ASTM D792
Vertical burn test	mm	HB 0.85	UL 94

TOLERANCES

Property	Unit	Value As Built
Achievable Part Accuracy[ii]	mm %	+/- 0.4 mm for parts up to 100 mm +/- 0.4 % for beyond 100 mm
Min. Wall Thickness	mm	1.2

Available Finishes with properties defined in this data sheet

1 | Standard

As built with support structure removal

Available Finishes for Surface Requirements

2 | Sanded

As built with support structure removal with additional manual sanding to achieve a homogeneous, smooth surface roughness. Surfaces that require sanding should be specified on the technical drawing or in the comment field on the MakerVerse platform.

3 | Sealed

As built with support structure removal with additional sealing to achieve air- and watertight geometries.

4 | Smoothed

As built with support structure removal with additional chemical smoothing to achieve a homogeneous, smooth surface roughness.

Available Finishes for Color Requirements

5 | Painted

As built with support structure removal with a color of choice applied to the part. Surfaces that require painting and the RAL color code should be specified on the technical drawing or in the comment field on the MakerVerse platform.

Available Combinations of Finishes

Many finishes can be combined or tuned to specific requirements. Please select "custom" in the "finish" dropdown on the MakerVerse platform and specify your requirements to request a quote for alternative finishing options.

Maximum build chamber size

914 MM X 610 MM X 914 MM

[i] Depending on build direction

[ii] As a result of the part's geometry, strong tensions may cause distortion in the part which may lead to greater deviation.