

# MATERIAL PROPERTY

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# COMPOSITUM FILAMENT SERIES™

## COMPOSITUM ABS EX™

### ISO (ASTM) Property

Item	Measuring Method	Condition	Unit	Value
<b>Physical</b>				
Specific Gravity	ISO 1183	Natural color	g/cm <sup>3</sup>	<b>1.040</b>
Melt Flow Index	ASTM D1238	200°C/5kg 220°C/10kg	g/10min	<b>3.8</b> <b>38.3</b>
<b>Mechanical</b>				
Tensile Strength	ASTM D638	5mm/min	MPa	<b>39.23</b>
Flexural Strength	ASTM D790	2.8mm/min	MPa	<b>56.88</b>
Flexural Modulus	ASTM D790	2.8mm/min	MPa	<b>2059</b>
IZOD Impact Strength	ASTM D256	1/1 inch	kgfcm/cm	<b>22</b>
Rockell Hardness	ASTM D785	R Scale		<b>108</b>
<b>Thermal</b>				
Heat Deflection Temperature	ASTM D648		°C	<b>85</b>
VICAT Softening Temperature	ISO R 306	5kg	°C	<b>98</b>
<b>Flammability</b>				
Flammability	UL94	HB	mm	<b>1.0, 1.5,</b> <b>3.0, 6.0</b>

The output parameters of the control samples:

- filling: 100%
- layer: 0.2mm
- nozzle: 0.4mm
- print temperature: 250°C
- platform temperature: 110°C
- Temperature of the working chamber: 54°C

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