

## ICE FILAMENTS ABS-X PRODUCT CARD

ICE Filaments ABS-X is our take on next-generation ABS filament. By applying our zero-warp technology to the filament we have created a filament with far less cracking, proven near perfect interlayers, reliable bed adhesion (glass, tape & other adhesives) while improving the mechanical properties making ICE Filaments ABS-X extra strong. These properties make ABS-X the ultimate ABS replacement that prints strong and beautiful parts on any FDM 3D printer without the common headaches associated with regular ABS, like warping & bed adhesion. ABS-X is the perfect material for strong objects that require an high impact tolerance.

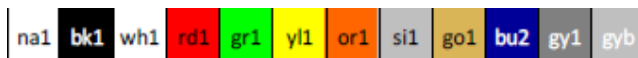
### FEATURES:

- ∞ Zero warp technology
- ∞ Excellent interlayer adhesion
- ∞ Reliable bed adhesion
- ∞ Enhanced mechanical properties
- ∞ Great strength and aesthetics



### COLOURS:

ICE Filaments ABS-X is available from stock in a variety of colors. Other colors on request.



FILAMENT SPECS		
Size	Ø tolerance	Roundness
1.75mm	± 0,05mm	≥ 95%
2.85mm	± 0,10mm	≥ 95%

MATERIAL PROPERTIES		
Description	Testmethod	Typical value
Specific Gravity	ISO 1183	1,1 g/cc
MFR 260°C/5kg	ISO 1133	41 gr / 10 min
Tensile strength at yield	ISO 527	43,6 Mpa
Strain at break	ISO 527	34%
Tensile Modulus	ISO 527	2030 Mpa
Impact Strength – Charpy notched 23°C	ISO 179	58 kJ/m <sup>2</sup>
Printing temperature	ICE FILAMENTS	240 – 260°C
Melting temperature	ISO 294	235°C ± 10°C
Vicat softening temperature	ISO 306	97°C

### ADDITIONAL INFO:

Recommended temperature for heated bed is ± 90 – 100°C.

ICE Filaments ABS-X is printed at high temperatures to make the final product extra strong.

ICE Filaments ABS-X can be used on all common desktop FDM or FFF technology 3D printers.

Storage: cool and dry (15 – 25°C) and away from UV light. This enhances the shelf life significantly.