

Product technical instructions

Product brand: Piocreat_ABS_013

Material No.: D3305010009

Basic Information			
Form	Particle		
Processing method	Extrude		
Physical properties	Rating	Unit	Test standards
specific gravity			
--	1.04	g/cm ³	ASTM D792
23°C	1.04	g/cm ³	ISO 1183
Melt flow rate (melt flow rate) (220°C/10.0kg)	3.0	g/10 min	ASTM D1238, ISO 1133
Shrinkage-Flow	0.40-0.70	%	Internal methods
Hardness	Rating	Unit	Test standards
Rockwell hardness			
Class R, 23°C	100		ASTM D785
R meter scale, 23°C	100		ISO 2039-2
Mechanical behavior	Rating	Unit	Test standards
Tension strength			
23°C	42.1	MPa	ASTM D638
23°C	42.0	MPa	ISO 527-2
Flexural modulus (23°C)	2250	MPa	ASTM D790, ISO 178
Bending strength (23°C)	68.0	MPa	ASTM D790, ISO 178
Impact properties	Rating	Unit	Test standards
Unnotched Izod Impact (23°C, 6.35mm)	380	J/m	ISO 180, ASTM D256
Thermal properties	Rating	Unit	Test standards
Thermal deformation temperature under load			ASTM D648, ISO 75-2/A
1.8MPa, not annealed, 12.7mm	86.0	°C	ASTM D648, ISO 75-2/A
1.8MPa, annealed	96.0	°C	ASTM D648, ISO 75-2/A
Vicat softening temperature	102	°C	ISO 306/A, ASTM D1525

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Flammability	Rating	Unit	Test standards
UL flame retardant grade (1.50mm, All Colors)	HB		UL94
Extrude	Rating	Unit	Test standards
Drying temperature	70.0-80.0	°C	
Drying time	2.0-3.0	hr	
Die temperature	190-230	°C	

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