



## Torwell Technologies Co. , Limited

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### ABS filament

Printing Parameters		
Item	Results	Unit
Nozzle Temp	220-260	°C
Ideal Temp	235°C	°C
Heated Bed Temp	80°C~110°C	°C
Print speed	30~50	mm/s
Materials Parameters		
Density	1.05	g/cm <sup>3</sup> , 21.5°C
Melt Flow Index	1.8	g /10 min, 220°C/5kg
Heat Distortion Temp	95	°C
Tensile Strength	45	Kg/cm <sup>2</sup>
Tensile Elongation	25	%
Flexural Strength	77	Kg/cm <sup>2</sup>
Flexural Modulus	25000	Kg/cm <sup>2</sup>
Impact Strength	18	KJ/m <sup>2</sup>
Diameter Accuracy	1.75mm: 1.70~1.78mm; 3.0mm: 2.90~3.0mm	