

MATERIAL PROPERTY

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COMPOSITUM FILAMENT SERIES™

COMPOSITUM ABS AT™

ASTM Property

Item	Measuring Method	Condition	Unit	Value
Physical				
Specific Gravity	ASTM D791	Natural color	g/cm ³	1.04
Melt Flow Index	ASTM D1238	220°C/10kg	g/10min	23.0
Mechanical				
Tensile Strength	ASTM D638	50mm/min	MPa	51.24
Flexural Strength	ASTM D790	15mm/min	MPa	79.11
Flexural Modulus	ASTM D790	15mm/min	MPa	2759
Tensile Modulus	ASTM D638	1mm/min	MPa	2221
Tensile Elongation at Break	ASTM D638	50mm/min	%	30
IZOD Impact Strength 3.2mm	ASTM D256	23°C	kg·cm/cm	23
		-30°C		8
IZOD Impact Strength 6.4mm	ASTM D256	23°C	kg·cm/cm	20
		-30°C		8
Rockwell Hardness	ASTM D785	R Scale		110
Thermal				
Heat Deflection Temperature	ASTM D648	0.45MPa	°C	90.1
Heat Deflection Temperature	ASTM D648	1.8MPa	°C	86.3
VICAT Softening Temperature	ASTM D1525	B/50	°C	94.2

The output parameters of the control samples:

- filling: 100%
- layer: 0.2mm
- nozzle: 0.4mm
- print temperature: 250°C
- platform temperature: 100°C

CORO Technology Tomasz Kielbasa
Złota Góra 27B
33-131 Ilkowice
NIP: PL 993-061-87-33
REGON: 360132346

Office
Kolejowa 2
33-132 Niedomice
POLAND

Contact
Office: office@corotechnology.com
Sales: sales@corotechnology.com
Support: support@corotechnology.com