

eABS-HT

Technical Data Sheet

Based on the modification of ABS material, compared with various ABS materials, it has enhanced temperature resistance, with a heat deformation temperature as high as 100°C, and can meet high temperature application scenarios. eABS-HT inherits the good toughness and impact resistance of ABS and can print strong and durable parts.

Material Status	Mass Production		
Characteristics	<ul style="list-style-type: none"> • High temperature • Wear resistance • High strength 		
Applications	• Hand-board applications	• Automotive	• Electronic and electrical appliances
Form	• Filament		
Processing method	• 3D Print, FDM Print		

	testing method	Typical value	
Physical Properties			
Density	GB/T 1033	1.04	g/cm ³
Melt Flow Index	GB/T 3682	7.0	(220°C/10KG)
Mechanical Properties			
Tensile Strength	GB/T 1040	23.06	MPa
Elongation at Break	GB/T 1040	3.78	%
Flexural Strength	GB/T 9341	71.56	MPa
Flexural Modulus	GB/T 9341	2372.8	MPa
IZOD Impact Strength	GB/T 1843	16.094	kJ/m ²
Thermal Properties			
Heat distortion Temperature	GB/T 1634	104.35°C	(0.45Mpa)
Continuous Service Temperature	IEC 60216	N/A	
Maximum (short term) Use Temperature		N/A	
Electrical Properties			
Insulation Resistance	DIN IEC 60167	N/A	
Surface Resistance	DIN IEC 60093	N/A	

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Recommended printing parameters

Extruder Temperature	230 - 270°C
Build Platform Temperature	55°C
Fan Speed	100%
Printing Speed	40-300mm/s

Based on Bambu P1S 0.4 mm nozzle and Orcaslicer1.7.0 Beta. Printing conditions may vary with different

nozzle diameters Drying Recommendations

N/A

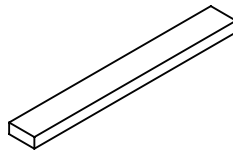
Precautions:

When slicing, it is best to turn on the Z seam alignment and starting point alignment functions, turn off the Z-axis lift and exit, avoid passing through the shell when idling, optimize the slicing printing path, and appropriately reduce the printing speed to achieve the best printing effect.

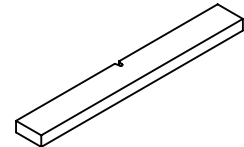
Mechanical Properties



Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1043

The physical properties, mechanical properties, thermal properties, and electrical properties of the filament are obtained based on the injection molding spline test.

Print test condition:

Extruder Temperature	270°C
Build Platform Temperature	90°C
Outline/Perimeter Shells	2
Top/Bottom Layers	3
Infill Percentage	100%
Fan speed	10%
Maximum volumetric flow rate	4mm ³ /s

Based on Bambu P1S 0.4 mm nozzle and Orcaslicer2.1.0 Beta.

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