



FDM DETAILS

Layer thickness: 0.13 – 0.25 mm (for ABS)
0.25 mm (for ULTEM™ 9085)

Standard accuracy: $\pm 0.1\%$ (min ± 0.2 mm)

Datasheet			
<i>ABS (Acrylonitrile / butadiene / styrene)</i>			
	Units	ASTM#	Range
Tensile Strength	MPa	D638	22
Tensile Modulus	MPa	D638	1627
Flexural Strength	MPa	D790	41
Flexural Modulus	MPa	D790	1834
Notched Izod Impact	J/m	D256	107
Unnotched Izod Impact	J/m	D256	214
Heat Deflection Temp	°C	D648	at 0.45 MPa: 90 at 1.81 MPa: 76
Density	g/cm ³		1.05
Elongation at Break	%		6
Colours	Blue, yellow, red, steel grey, green, black, white, grey		
	Actual values may vary with build conditions		



Datasheet			
ULTEM™ 9085			
	Units	ASTM#	Range
Tensile Strength	MPa	D638	72
Tensile Modulus	MPa	D638	2220
Flexural Strength	MPa	D790	115
Flexural Modulus	MPa	D790	2507
Notched Izod Impact	J/m	D256	106
Unnotched Izod Impact	J/m	D256	613.8
Heat Deflection Temp at 1,81 MPa	°C	D648	153
Density	g/cm ³		1.34
Elongation at Break	%		5.9
Oxygen Index	%	D2863	49
Vertical Burn (Test a (60s), passes at)	secs	FAR25.853	2
FAA Flammability (Method A/B)		FAR25.853	<5
OSU Peak Heat Release (5 minute test)	kW/m ²	FAR25.853	36
OSU Peak Heat Release (2 minute test)	kW/min-/m ²	FAR25.853	16
Flammability		UL94	V-0 1.5 mm
Colour	Tan or Black available		
	Actual values may vary with build conditions		