

MINGDA FDM Printing Material Technical Data Sheet

MINGDA ABS-HF

High-speed print ABS material

产品优势

Product Advantages

- High liquidity
ABS-HF has high liquidity and supports 200mm/s printing speed.
- Low Warpage
ABS-HF has low insulation requirements, and printing on an open printer can also maintain better adhesion with the bottom plate.

产品描述

Product Description

MINGDA ABS-HF is a MINGDA Odorless ABS for high-flow modification ABS consumables. It retains low smells and supports higher printing speeds. At the same time, it has better resistance to warping and excellent impact resistance.

产品详情

Available

Color: 纯色 Natural/黑色 Black

Line diameter: 1.75mm

Net weight: 1KG

物性表

Material Properties

测试项目 Property	测试方法 Testing method	典型值 Typical value
密度 Density	ISO 1183	1.05g/cm ³

玻璃化转变温度 Glass transition temperature	ISO 11357	80℃
熔融指数 Melt index	250℃, 2.16kg	13g/10min
维卡软温度 Vicat softening temperature	ISO 306	/℃
热变形温度 Determination of temperature	ISO 75: Method A ISO 75: Method B	65℃ (1.8MPa) 72℃ (0.45MPa)
拉伸屈服强度 (X-Y) Tensile yield strength	ISO 527	37.13 ± 0.59MPa
拉伸屈服伸长率 (X-Y) Tensile Yield elongation		2.32 ± 0.07%
杨氏模量 (X-Y) Young's Modulus		2115.10 ± 24.02MPa
拉伸断裂强度 (X-Y) Tensile breaking strength		30.29 ± 2.28MPa
断裂伸长率 (X-Y) Elongation at break		3.65 ± 1.52%
拉伸断裂强度 (Z) Tensile breaking strength	ISO 527	33.48 ± 0.23MPa
杨氏模量 (Z) Young's Modulus		2097.03 ± 37.77MPa
断裂伸长率 (Z) Elongation at break		4.07 ± 0.57%
弯曲强度 (X-Y) Bending strength	ISO 178	57.46 ± 0.25MPa
弯曲模量 (X-Y) Bending Modulus		2117.02 ± 32.46MPa
缺口冲击强度 (X-Y) Charpy impact strength	ISO 179	23.16 ± 2.32KJ/m ²

试样打印参数: 喷嘴大小 0.4mm, 喷嘴温度 250℃, 底板加热 80℃, 打印速度 50mm/s, 填充率 100%, 填充角度 ±45°

Specimens printed under the following conditions: Nozzle size 0.4mm, Nozzle temp 250℃, Bed temp 80℃, Print speed 50mm/s, Infill 100%, Infill angle ±45°

建议打印参数

Recommended printing conditions

喷头温度 Nozzle temperature	230-250°C
建议喷嘴大小 Recommended nozzle diameter	≥0.2 mm
建议底板材质 Recommended build surface	玻璃、PEI 膜或 PC 膜 Glass、PEI Film or PC Film
底板温度 Build plate temperature	70-80°C
Raft 间距 Raft separation distance	0.2-0.22mm
冷却风扇 Cooling fan speed	0-50%
打印速度 Print speed	30-200 mm/s
回抽距离 Retraction distance	1-3 mm
回抽速度 Retraction speed	1800-3600 mm/min
建议支撑材料 Recommended Support Material	/

Additional Suggestions:

1. Turn on the unused filaments that have not been used for a long time. If the phenomenon of bubbles drawing bubbles during the printing process is found during the printing process, please put the wires at 70°C for 4-6h.
2. It is recommended to place the printer in a ventilated environment when printing.