

**Technical Data for TierTime ABS+ Material****6/30/2020**

Filament Name	TierTime ABS+			
Weight	500g/1kg	Price (kg)		
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#	Properties	Testing Methods	Unit	Value
1	Density	ISO 1183	g/cm <sup>3</sup>	1.05
2	Mold Shrinkage	ASTM D955	%	0.4~0.7
3	Melt Flow Index	ASTM D1238 ISO 1183	g/10min	8
4	Melt viscosity	ASTM D3825		
5	Rockwell hardness	ASTM D785		108
6	Tensile Yield Strength	ASTM D638	MPa	48
7	Tensile Breaking Strength	ASTM D638	MPa	42
8	Elongation at Break	ASTM D638	%	8.7
9	Elongation at Yield	ASTM D638	%	2.7
10	Tensile Modulus	ASTM D638	MPa	2300
11	Flexural Strength	ASTM D790	MPa	79
12	Flexural Modulus	ASTM D790	MPa	2500
13	Izod Impact Strength	ASTM D256	KJ/m <sup>2</sup>	2.9
14	Vicat Softening Point	ASTM D1525	°C	96
15	Flammability	UL94-2013	1.6 mm	HB
16	Heat Deflection Temperature	ASTM D648	°C	86