



# Ultrafuse® ABS Fusion+

Efficient Engineering-filament Printing – for non-print Engineers

Ultrafuse® ABS Fusion+ is an easy-to-print engineering material and enables a much more efficient printing process. Meaning 3D printing operators will spend less time tinkering and more time exploiting the full potential of your 3D printing rig. To top it off, Ultrafuse® ABS Fusion+ adheres to water-soluble support – no more hassle with chemicals, just dissolve your support in water after printing! The 3D printing community has so far considered ABS an unforgiving material: Now, thanks to the unique properties of ABS Fusion+ you can look forward to a high success rate with greatly improved dimensional stability.

## Benefits at a Glance

- Easy to print
- Direct printing on heated glass or print bed surfaces
- High heat resistance
- Adheres to water soluble support

## Example Applications

- Jigs & fixtures
- Automotive parts

## Material Properties

Tensile strength (MPa)	17.9 (ZX), 29.5 (XY)
Flexural modulus (MPa)	878(ZX), 1133 (XZ), 1406 (XY)
Elongation (Break)	2.1 % (ZX), 10.9 % (XY)
Impact strength Izod notched (kJ/m <sup>2</sup> )	2.2 (ZX), 38.4 (XZ), 26.4 (XY)
Impact strength Izod unnotched (kJ/m <sup>2</sup> )	6.6 (ZX), 131.1 (XZ), 73.1 (XY)
HDT @ 0.45 MPa	91 °C

## Printing Guidelines

Nozzle temperature	240-260 °C
Bed temperature	100-120 °C
Fan speed	0 % (max. 25 %)
Bed adhesion	clean with ethanol
Print speed	40-80 mm/ sec
Top/ bottom thickness	0.8-1.0 mm
Layer height	0.1-0.2 mm

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