

Technical Data for Tiertime UP Fila ABS Material

UP Fila ABS –Technical Properties

Test method	Mechanical properties	UP Fila ABS data
ASTM D638	Tensile Strength	28 MPa
ASTM D638	Tensile Modulus	1598 MPa
ASTM D790	Flexural Strength	39 MPa
ASTM D790	Flexural Modulus	1865 MPa
D 648	Heat Deflection Temperature	92 °C
AST 638	Elongation at Break	5%

UP Fila ABS+ – Technical Properties

Test method	Mechanical properties	UP Fila ABS+ data
ASTM D638	Tensile Strength	30 MPa
ASTM D638	Tensile Modulus	1831 MPa
ASTM D790	Flexural Strength	51 MPa
ASTM D790	Flexural Modulus	2002 MPa
D 648	Heat Deflection Temperature	93 °C
AST 638	Elongation at Break	6%

Technical Data for Tiertime UP Fila PLA Material

UP Fila PLA – Technical properties

Technical properties	UP Fila PLA data
Tensile Strength	>=60 MPa
Flexural Strength	65-90 Mpa
Flexural Modulus	2500-3000 MPa
Elongation at Break	4.4-6%
Extruding temperature (°C)	190-210 (°C)
Bed Temperature	0-70 (°C)
Melt Flow Index (g/10 min)	6-7.8
Impact Strength (kJ/m2)	4-4.3
Density	1.25±0.05 g/cm ³