

Technical Data Sheet

Spectrum Filaments ASA 275

Identification	
Trade name	ASA 275
Chemical name	Acrylonitrile styrene acrylate
Use	Additive Manufacturing
Origin	Spectrum Group Sp. z o.o.

Filament Specification	
Diameter:	1.75 & 2.85 ± 0.05mm

Material properties		
Melt Flow Rate ¹	5 g/10 min	ASTM D1238
Melt temperature	200-230°C	-
Density	1.08 g/cm ³	ASTM D793
Vicat softening temperature	94°C	ASTM D1525
Heat deflection temperature	86°C	ASTM D648
Tensile Strength at Yield ²	42 Mpa	ASTM D638
Tensile Elongation at Break ³	35%, (Min)	ASTM D638
Tensile Modulus ⁴	1800 MPa	ASTM D638
Flammability 1.5mm / 3.0mm	HB	UL 94

¹Test conditions: T = 220°C; m = 10.0 kg

^{2,3,4} Test conditions: 23°C, 50mm/min, 3.2mm

Guideline for print settings*	
Nozzle temperature	200-240°C
Bed temperature	40-60°C
Active cooling fan	YES (up to 100%)
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 – 2.4 mm
Print speed**	40 – 200 mm/s

*Settings are based on a 0,4 mm nozzle.

** The range depends on the geometrical complexity

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All shown data are typical properties. Users should confirm results by their own tests.