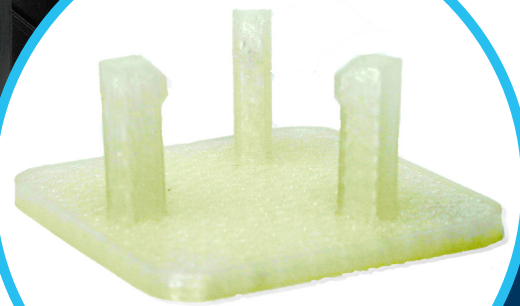
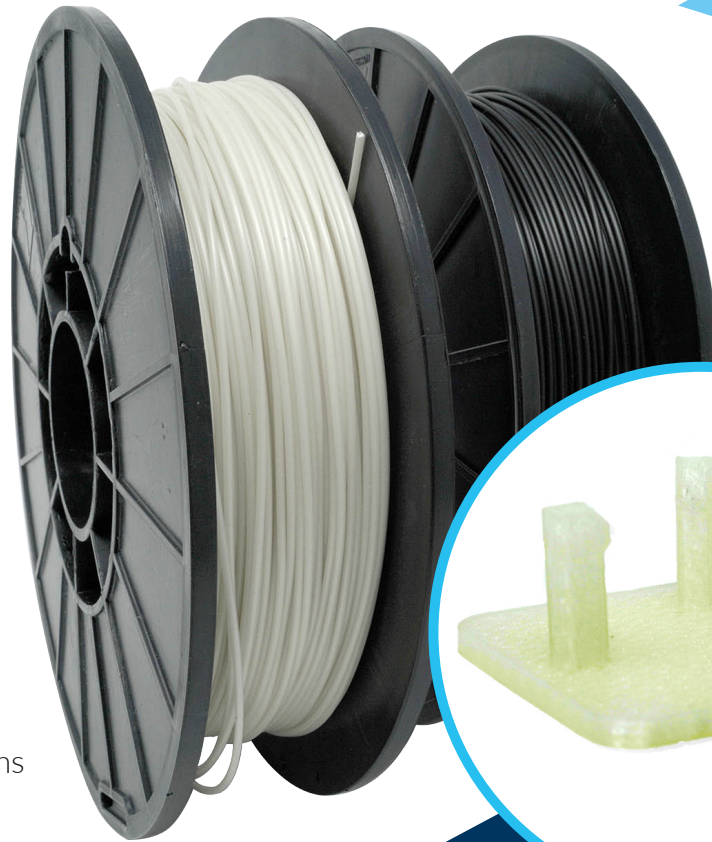


## ABS 1400 LW

### Overview

Jabil's ABS 1400 LW is easy to print with balanced properties that consistently lay flat. It has minimal warping when printed with 100% infill in a non-heated chamber system. It also maintains good layer-to-layer adhesion from the bottom of the build to the top, with excellent surface appearance. The ABS 1400 LW is great for applications where the properties of ABS are wanted, but low warp is required.



### Applications:

- Brackets
- Housings
- Jig, Fixtures and Tooling to aid in manufacturing

### Advantages:

- Excellent bed adhesion
- Stiffer than most ABS filament
- Reduce CLTE
- Improved dimensional stability
- Consistent lot-to-lot print properties
- Good chemical resistance to most fluids

Scan for more information:



## ABS 1400 LW



### Print Temperature

The optimal printing range is 275°C to 295°C.



### Bed Temperature

The hotter the better, up to 110°C.



### Printing Speed

Base printing speed of 60 mm/s  
 Infill speed of 45 mm/s  
 Wall speed of 40 mm/s  
 Initial layer speed of 20 mm/s



### Cooling

For best results, use a cooling fan speed of 5%.  
 Some printers will run best with no cooling fan.  
 Make sure to have the fan off for the first layer.



### Bed Adhesion

Suitable adhesion can be obtained with PVA-based glue stick on a glass bed. A brim should be used. If the printer being used is unable to maintain the recommended bed temperature, an ABS/acetone slurry or a PEI sheet may be used to help adhesion.



### Colors Available

Natural & Black



### Diameters Available

1.75mm & 2.85mm

Scan to get  
print profiles:



Mechanical Properties <sup>1</sup>			
	Test Condition	Typical Value	Method
Tensile Modulus (MPa)	XY coupons, Ambient	2730	ASTM D638, Type I
Tensile Elongation at Break (%)		3.3	
Ultimate Tensile Strength (MPa)		35.3	
Flexural Modulus (MPa)	XY coupons, Ambient	2450	ASTM D790
Flexural Strength (MPa)		59.8	
Izod Impact, Notched (J/m)	XY coupons, Ambient	39	ASTM D256
Izod impact, Unnotched (J/m)	XY coupons, Ambient	235	

1. Testing conducted on bars printed at 295°C.

Thermal Properties			
	Test Condition	Typical Value	Method
Heat Deflection Temperature (°C)	0.455 MPa	101	DMA
Heat Deflection Temperature (°C)	1.82 MPa	92	
Glass Transition Temperature (°C)	20°C/min ramp	111	DSC

Other Physical Properties			
	Test Condition	Typical Value	Method
Density (g/cm <sup>3</sup> )	Ambient	1.10 - 1.12	ASTM D792
Moisture Absorption (weight %)	24 hours	0.3 %	ASTM D570