



# ABS-ESD7

## PRODUCTION-GRADE THERMOPLASTIC FOR FORTUS 3D PRODUCTION SYSTEMS

ABS-ESD7™ (acrylonitrile butadiene styrene-electrostatic dissipative) is an ABS thermoplastic with static dissipative properties for applications where a static charge can damage products, impair their performance or cause an explosion. ABS-ESD7 prevents a buildup of static electricity, so it will not produce a static shock or cause other materials like powders, dust and fine particles to stick to it. Ideal for electronic products with circuit boards and for the transportation and industrial equipment industries. Most widely used to create jigs and fixtures for the assembly of electronic components, but it is also useful for building functional prototypes of fuel storage and delivery products, as well as cases, enclosures and packaging.

MECHANICAL PROPERTIES <sup>1</sup>	TEST METHOD	ENGLISH	METRIC
Tensile Strength (Type 1, 0.125", 0.2"/min)	ASTM D638	5,200 psi	36 MPa
Tensile Modulus (Type 1, 0.125", 0.2"/min)	ASTM D638	350,000 psi	2,400 MPa
Tensile Elongation (Type 1, 0.125", 0.2"/min)	ASTM D638	3%	3%
Flexural Strength (Method 1, 0.05"/min)	ASTM D790	8,800 psi	61 MPa
Flexural Modulus (Method 1, 0.05"/min)	ASTM D790	350,000 psi	2,400 MPa
IZOD Impact, notched (Method A, 23°C)	ASTM D256	0.5 ft-lb/in	28 J/m
IZOD Impact, un-notched (Method A, 23°C)	ASTM D256	1.1 ft-lb/in	55 J/m

THERMAL PROPERTIES <sup>2</sup>	TEST METHOD	ENGLISH	METRIC
Heat Deflection (HDT) @ 66 psi, 0.125" unannealed	ASTM D648	204°F	96°C
Heat Deflection (HDT) @ 264 psi, 0.125" unannealed	ASTM D648	180°F	82°C
Vicat Softening Temperature (Rate B/50)	ASTM D1525	210°F	99°C
Glass Transition (T <sub>g</sub> )	DSC (SSYS)	226°F	108°C
Coefficient of Thermal Expansion (flow)	ASTM E831	4.9 <sup>5</sup> in/in/°F	8.82 <sup>5</sup> mm/mm/°C
Coefficient of Thermal Expansion (xflow)	ASTM E831	4.7 <sup>5</sup> in/in/°F	8.46 <sup>5</sup> mm/mm/°C
Melting Point	-----	Not Applicable <sup>3</sup>	Not Applicable <sup>3</sup>

ELECTRICAL PROPERTIES <sup>4</sup>	TEST METHOD	VALUE RANGE
Volume Resistivity	ASTM D257	3.0x10 <sup>9</sup> - 4.0x10 <sup>10</sup> ohm-cm
Surface Resistance	ASTM D257	10 <sup>9</sup> - 10 <sup>9</sup> ohms



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OTHER <sup>2</sup>	TEST METHOD	VALUE
Specific Gravity	ASTM D792	1.04
Flame Classification	UL94	HB (0.06", 1.5 mm)
Rockwell Hardness	ASTM D785	109.5

SYSTEM AVAILABILITY	LAYER THICKNESS CAPABILITY	SUPPORT STRUCTURE	AVAILABLE COLORS
Fortus <sup>®</sup> 380mc <sup>™</sup>	0.010 inch (0.254 mm)	Soluble Supports	■ Black
Fortus 400mc <sup>™</sup>	0.007 inch (0.178 mm)		
Fortus 450mc <sup>™</sup>			
Fortus 900mc <sup>™</sup>			

The information presented are typical values intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. End-use material performance can be impacted (+/-) by, but not limited to, part design, end-use conditions, test conditions, etc. Actual values will vary with build conditions. Tested parts were built on Fortus 400mc @ 0.010" (0.254 mm) slice. Product specifications are subject to change without notice.

The performance characteristics of these materials may vary according to application, operating conditions, or end use. Each user is responsible for determining that the Stratasys material is safe, lawful, and technically suitable for the intended application, as well as for identifying the proper disposal (or recycling) method consistent with applicable environmental laws and regulations. Stratasys makes no warranties of any kind, express or implied, including, but not limited to, the warranties of merchantability, fitness for a particular use, or warranty against patent infringement.

<sup>1</sup>Build orientation is on side long edge.

<sup>2</sup>Literature value unless otherwise noted.

<sup>3</sup>Due to amorphous nature, material does not display a melting point.

<sup>4</sup>All electrical property values were generated from the average of test plaques built with default part density (solid). Test plaques were 4.0 x 4.0 x 0.1 inches (102 x 102 x 2.5 mm) and were built both in the flat and vertical orientation. The range of values is mostly the result of the difference in properties of test plaques built in the flat vs. vertical orientation.