



Bilby 3D

MATERIAL DATA SAFETY SHEET

Issued in Australia by Bilby 3D Pty Ltd.

The attached Material Data Safety Sheet has been prepared by the manufacturer outside Australia.

In accordance with Australia WHS regulations the following Australian contact details apply

Section 1: AUSTRALIAN COMPANY DETAILS

In Australia the product is imported and distributed by:
Bilby 3D Pty Ltd

Mailing Address :

Kingsgrove Business Centre, 7/192 Kingsgrove Rd, Kingsgrove NSW 2208

Head Office Address :

Kingsgrove Business Centre, 7/192 Kingsgrove Rd, Kingsgrove NSW 2208

Contact Phone: 1800 847 333

Section 2: AUSTRALIAN EMERGENCY CONTACT

Emergency Contact

In the event of an emergency please contact:

Poisons Information Centre 24 hour Telephone Advice Line on 13 11 26

Section 3: AUSTRALIAN ISSUE DATA

Date of Issue : 1 March 2020

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

Preparation date: 08-09-2019

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