ABS (Acrylonitrile Butadiene Styrene)

Use the following configuration:

1. Clean brass 0.4 mm nozzle (dddrop’s standard);
2. Original spring for extruder;
3. Filamentreel of dddrop ABS;
4. FFF profile ABS ([https://www.dddrop.com/dddrop-support/](https://www.dddrop.com/dddrop-support/));
5. Dimafix (use spray or pen, it depends on which machine you have. [https://www.dddrop.com/products/parts/](https://www.dddrop.com/products/parts/)).

Important notes:

1. Always use Dimafix. When using Dimafix, never use the Ammonia heatbed cleaner. The combination of Dimafix and Ammonia will damage your glassplate.

2. Keep the cover of the dddrop 3D printer always closed while printing a product. Don’t open the cover for any reason. This will cause bigger warping problems.

3. ABS is a material which warp a lot. The amount of warping depends on the type of product you print. Massive products will warp more than thin products.

4. Keep your filament dry. If you experience:
   - A lot of stringing or oozing;
   - Poor layer adhesion;
   - Uneven extrusion lines,
   It could be that your filament has to be dried. Use the PrintDry filamentdryer or an air-circulated oven. 70-80 degrees for 6-8 hours.
Tips:

1. After drying the filament, but not using it immediately, use a filament (vacuum) storage container to keep your filament dry for a longer time.

2. When printing large parts, use the Polybox filament container to put your filament in. While printing your filament is conditioned and free of moisture.

For any questions, don’t hesitate to contact our Customer Service. (cs@dddrop.com / +31 (0)314 – 377050).