

ABS (Acrylonitrile Butadiene Styrene)

Use the following configuration:

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

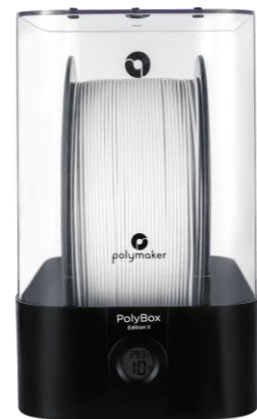
1. After drying the filament, but not using it immediately, use a filament (vacuum) storage container to keep your filament dry for a longer time.
2. When printing large parts, use the Polybox filament container to put your filament in. While printing your filament is conditioned and free of moisture.



PrintDry



Filament storage container



Polybox

*For any questions, don't hesitate to contact our Customer Service.
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