



TECHNICAL DATASHEET

DIJLAC ABS MF 30 UV

ABS Compound injection molding type UV - Stabilized | Colour: RAL 9004 & RAL 7016

Property	Method	Measurement condition	Unit	Values
Melt flow rate	ISO 1133	230°/ 5 kg	gr/10 min	8
Melt flow rate	ISO 1133	220°/10 kg	gr/10 min	18
Density	ISO 1183	-	g/cm ³	1,07
Tensile strength , Yield	ISO 527-2	-	MPa	42
Tensile modulus	ISO 527-2	mm/min	MPa	2480
Izod Impact Strength at 23 °C	ISO 180/1A	unnotched	KJ/m2	42
Izod Impact Strength at 23 °C	ISO 180/1A	notched	KJ/m2	11
Vicat Softening Point	ISO 306	50 N	°C	92
Flammability	UL 94(in house met)	1,6	mm	HB

Processing

Melt Temperature range	ISO 294		°C	230-260
Mold Temperature range	ISO 294		°C	60-80
Injection Velocity	ISO 294		mm/s	240
Drying Temperature			°C	80
Drying Time			h	4

Application data

Description	ABS Compound with recycle content with good flow
Application	Injection Moulding
Drying conditions	80 °C , 6 - 8 hours moisture content < 0,02%
Moulding temperature - Nozzle	220 - 260 °C
Moulding temperature - Barrel	220 - 250 °C
Mold Temperature	30 - 80 °C
Compression ratio	2:1 - 2,5:1
Injection Pressure	Low to medium
Injection Speed	Fast ram speed
Hold pressure	Low to medium
Screw speed	0,05 - 0,2 m/s
Cushion	4 - 6 mm
Back pressure	0 - 1,0 MPa

This information contained in this document is based on testing carried out by our laboratory. To the best of our knowledge and at the time of publication, this information is true and accurate. It shall however, in no event be held to constitute or imply warranty, undertaking express or implied commitment from the part of supplier. No liability whatsoever can be accepted by supplier with regard to the handling, processing or use of the product concerned which must in all cases be used in accordance with all applicable laws and regulations. Material is conform RoHS and Reach regulations and without heavy metals rev.date 28 03 2017.

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