

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 strenght , 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/m ²	42
Izod Impact Strength at 23°C	ISO 180/1A	notched	KJ/m ²	11
Vicat Softening Point	ISO 306	50 N	°C	92
Flammability	UL 94(in house method)	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

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Application data

Description	ABS Compound with recycle content with good flow
Application	Injection Moulding
Drying conditions	80 °C , 4 - 6 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

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