

Technical Data Sheet

Product Description

FM ABS07

ABS07 is a general purpose ABS resin with super high impact resistance. Application includes automobile parts (radiator grills), helmets, toys, suitcases, profiles released extruded products, bobbin sleeves, boats, pipes and bath tubs.

<i>Characteristic</i>	<i>Typical Value</i>	<i>Unit</i>	<i>ABS-70 specification</i>	<i>Test Method (ASTM)</i>	<i>Test Condition</i>
<i>Izod impact</i>	26	Kj/m ²	Min 23	D-256	6.4 mm, notched
<i>Melt flow index</i>	14	gr/10 min	8-16	D-1238	220°C, 10 kg
<i>Rock well hardness</i>	113	R-scale	100-120	D-785	-
<i>HDT</i>	90	°C	Min 85	D-648	1.82 m pa
<i>Vicat softening temp</i>	100	°C	Min 96	D-1525	5kg/50°C
<i>Tensile strength</i>	470	Kg/cm ²	Min 440	D-638	23°C, 50 mm/min
<i>Tensile elongation</i>	25	%	Min 18	D-638	23°C, 50 mm/min
<i>Flexural strength</i>	670	Kg/cm ²	Min 650	D-790	23°C, 2.8 mm/min
<i>Flexural modulus</i>	23000	Kg/cm ²	Min 20000	D-790	23°C, 2.8 mm/min
<i>Specific gravity</i>	1.04	-	1.04	D-792	23°C
<i>Molding shrinkage</i>	0.4-0.7	%	0.4-0.7	D-955	-
<i>Flammability</i>	HB	-	HB	UI94	1/8inch (3.2mm)

Notes: Values shown are averages and are not to be considered as product specification. These values may shift slightly as additional data is accumulated. - ISO test methods are the latest under the society's current procedures.

Health & Safety

Ensure proper ventilation of the work environment to minimize health and safety hazards from fine particles. Ensure machinery and equipment is properly grounded to prevent sparks that can ignite dust. Molten polymers will cause thermal injuries to organic matter please ensure safety glasses and appropriate safety apparel is worn.

Typical ABS processing conditions

Drying: it is recommended that FM Plastics ABS Resins be dried at (80-85°C) for 3 hours. Extruder with one-stage or two-stage venting are recommended for extrusion of sheet. Compression ratios should be between 2.5/1 and 3.0/1 for a single stage screw, L/D ratio 20/1 is typical.

Zone 1 (°C)	190-200	Zone 6 (°C)	210-220
Zone 2 (°C)	190-200	Zone 7 (°C)	210-220
Zone 3 (°C)	200-210	Adapter (°C)	210-220
Zone 4 (°C)	200-210	Die zone (°C)	225-235
Zone 5 (°C)	210-220	Screen pack mesh (2layer)	#60-80

Injection Moldin

Rear Temp (°C)	190-200	Nozzle Temp (°C)	225-235
Center Temp (°C)	200-210	Melt Temp (°C)	240
Center Temp (°C)	210-220	Mold Temp (°C)	60-80
Front Temp (°C)	215-225	Filling Speed	Slow-med

Packaging

ABS resins are supplied in pellet form packed in 25kg bags on 1.375 kg pallets or in 1.100 kg big bags.



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