

DATASHEET

Product: Formacrom ABS Naturale/Nero

Description: ABS

(Formacrom ABS Naturale/BK, is a easy flow injection moulding product with good ductility)

Properties			
Density	kg/m ³	ISO 1183	1,04
Water absorption, Saturated at 23°C	%	ISO 62	0,95
Moisture absorption, Equilibrium at 23°C 50% r.U	%	ISO 62	0,24
Melt Volume Rate 220°C 10 kg	cm ³ /10 min	ISO 1133	34
Phisical properties			
Linear Mold shrinkage	%	ISO 294-4	0,40 - 0,7
Mechanical properties			
Tensile Strain at Yield, 23°C	%	ISO 527	2,4
Tensile Stress at Yield, 23°C	MPa	ISO 527	44
Tensile Modulus	MPa	ISO 527	2300
Nominal Strain at break, 23°C	%	ISO 527	12
Flexural modulus	MPa	ISO 178	2500
Flexural strength	MPa	ISO 178	65
IZOD notched impact strength +23°C	KJ/m ²	ISO 180/1eA	22
IZOD notched impact strength -30°C	KJ/m ²	ISO 180/1eA	7
Thermal properties			
Heat distortion temperature under 1,8 Mpa load (HDT A)	°C	ISO 75	92
Heat distortion temperature under 0,45 MPa load (HDT B)	°C	ISO 75	95
Vicat softening point under 9,8 N load (Vicat A)	°C	ISO 306	95
Vicat softening point under 0,49 N load (Vicat B)	°C	ISO 306	102
Electical properties			
Volume resistivity	Ω*m	IEC 60093	1,00E+013
Surface resistivity	Ω	IEC 60093	1,00E+014
Comparative Tracking Index CTI, Test solution A		IEC 112	-
Comparative Tracking Index CTI, Test solution B		IEC 112	-
Electric Strength	kV/mm	IEC 60243 -	41
Flammability			
Flammability rate at 0,8 mm thickness		UL94	HB
Flammability rate at 1,6 mm thickness		UL94	HB
Flammability rate at 3,2 mm thickness		UL94	HB
Processing Parameters			
Melt temperature range	°C	ISO 294	220 - 260
Mold Temperature Range	°C	ISO 294	30 - 60
Drying Temperature	°C		80
Drying Time	h		2 - 4

**Processing conditions listed are for typical start-up conditions for comparison purposes. Most applications are part dependent and will require process adjustment after start-up.*