

TRILAC® ABS-FR1

ABS

Amco Polymers

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	8	g/10min	ASTM D 1238
Temperature	230	°C	-
Load	3.8	kg	-
Mold Shrinkage, MD	0.0065	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Modulus	2172	MPa	ASTM D 638
Tensile Strength at Yield	36.5	MPa	ASTM D 638
Flexural Modulus	2241	MPa	ASTM D 790
Flexural Strength	64.1	MPa	ASTM D 790
Izod Impact notched, 1/8 in	149	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	1.52	mm	-
DTUL @ 264 psi	76.7	°C	ASTM D 648
Other Standards^[5]			
Burning behav. 5V at thickness h	5VA	class	UL 94
Thickness tested	3.0	mm	-

S: These properties are reported by the producer according standards that are different to our defaults.

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.3	%	ASTM D 570
Density	1200	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	87.8 - 93.3	°C	-
Pre-drying - Time	2 - 24	h	-
Melt temperature	232 - 249	°C	-
Mold temperature	54.4 - 71.1	°C	-
Zone 1	177	°C	-
Zone 2	204	°C	-
Zone 3	216	°C	-
Screw speed	50 - 60	rpm	-
Injection pressure	55.2 - 82.7	MPa	-
Back pressure	0.689	MPa	-

Characteristics**Processing**

Injection Molding

Special Characteristics

Flame retardant

Delivery form

Pellets

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa