SICOFLEX® ABS MZ341

ABS — Ravago Group

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**16**	g/10min	ISO 1133
Temperature	**220**	°C	-
Load	**10**	kg	-
Molding shrinkage, parallel	**0.6**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	**40**	MPa	ISO 527
Stress at break	**32**	MPa	ISO 527
Strain at break	**25**	%	ISO 527
Flexural modulus, 23°C	**2600**	MPa	ISO 178
Izod notched impact strength, +23°C	**11**	kJ/m²	ISO 180/1A
Izod notched impact strength	**5**	kJ/m²	ISO 180/1A
Temperature	**-30**	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**91**	°C	ISO 75-1/-2
Vicat softening temperature, B	**97**	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	**HB**	class	IEC 60695-11-10
Thickness tested	**1.6**	mm	-
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10
Thickness tested	**3.2**	mm	-
Glow Wire Flammability Index (GWFI)	**650**	°C	IEC 60695-2-12
GWFI - thickness tested (1)	**2**	mm	-

Other properties	Value	Unit	Test Standard
Density	**1050**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80 - 90**	°C	-
Pre-drying - Time	**2 - 3**	h	-
Processing humidity	**≤0.1**	%	-
Melt temperature	**210 - 240**	°C	-
Mold temperature	**40 - 60**	°C	-
Zone 1	**205 - 215**	°C	-
Zone 2	**220 - 230**	°C	-
Zone 3	**230 - 240**	°C	-
Nozzle temperature	**230 - 235**	°C	-
Screw speed	**40 - 70**	rpm	-
Back pressure	**0.3 - 1.5**	MPa	-
Holding pressure	**3 - 6**	MPa	-

Characteristics

Processing
Injection Molding

Regional Availability
Europe

Applications
General Purpose