

## Product Texts

Symbol according to ISO 1043-1: ABS

Designation: Thermoplastics ISO 2580-ABS 1,EGN,105-04-16-20

Sinkral B 4 Milano is a special grade for extrusion/thermoforming.

Thanks to its low gel content together an optimum balance of stiffness and impact resistance, ensures high aesthetic quality of surfaces, particularly suitable for co-extrusion.

Optimal thermal stability and rheological properties also permit the sheet production of large dimensions.

Applications:

Extruded and co-extruded sheets, including thick sheet where high hot draw ratios are required.

Its excellent surface appearance permit the use in a wide range of applications such as furniture, refrigerator, sanitary, automotive and packaging for foodstuff and industrial items.

Also ideal for the extrusion of profiles for furniture industry.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	4	cm <sup>3</sup> /10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
<sup>[C]</sup> Density of melt	960	kg/m <sup>3</sup>	-
<sup>[C]</sup> Spec. heat capacity of melt	2150	J/(kg K)	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	2300	MPa	ISO 527
<sup>[C]</sup> Yield stress	45	MPa	ISO 527
<sup>[C]</sup> Yield strain	3	%	ISO 527
<sup>[C]</sup> Nominal strain at break	30	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	140	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	18	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	8	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Glass transition temperature, 10°C/min	109	°C	ISO 11357-1/-2
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	83	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	104	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	90	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Relative permittivity, 1MHz	3.1	-	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 1MHz	150	E-4	IEC 62631-2-1
<sup>[C]</sup> Volume resistivity	1E13	Ohm*m	IEC 62631-3-1

**SINKRAL® B4 Milano**

ABS

Versalis S.p.A

[C] Surface resistivity	<b>1E14</b>	Ohm	IEC 62631-3-2
[C] Electric strength	<b>30</b>	kV/mm	IEC 60243-1
[C] Comparative tracking index	<b>600</b>	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
[C] Water absorption	<b>0.6</b>	%	Sim. to ISO 62
[C] Humidity absorption	<b>0.2</b>	%	Sim. to ISO 62
[C] Density	<b>1040</b>	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
[C] Processing conditions acc. ISO	<b>2580</b>	-	ISO ....-2
[C] Injection Molding, melt temperature	<b>250</b>	°C	ISO 294
Injection Molding, mold temperature	<b>60</b>	°C	ISO 294
Injection Molding, injection velocity	<b>200</b>	mm/s	ISO 294
Injection Molding, pressure at hold	<b>70</b>	MPa	ISO 294

[C]: CAMPUS

**Characteristics****Processing**

Film Extrusion, Profile Extrusion, Sheet Extrusion, Other Extrusion, Blow Molding, Thermoforming

**Delivery form**

Pellets

**Special Characteristics**

Heat stabilized or stable to heat

**Regional Availability**

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

**Other text information****Film extrusion**

## PREPROCESSING

Drying conditions if no venting:

Drying temperature 80 °C

Drying time 2- 4 h

Maximum water content 0.2 %

## PROCESSING

Typical processing temperature range:

Melt temperature 190 - 230 °C

**Other extrusion**

## Other extrusion

## PREPROCESSING

Drying conditions if no venting:

Drying temperature 80 °C

Drying time 2- 4 h

Maximum water content 0.2%

## PROCESSING

Typical processing temperature range:

Melt temperature 190 - 230 °C

**Profile extrusion**

## PREPROCESSING

Drying conditions if no venting:

Drying temperature 80 °C

Drying time 2- 4 h

Maximum water content 0.2 %

## PROCESSING

Typical processing temperature range:

Melt temperature 190 - 230 °C

**Sheet extrusion**

## PREPROCESSING

Drying conditions if no venting:

Drying temperature 80 °C

Drying time 2- 4 h

Maximum water content 0.2 %

## PROCESSING

Typical processing temperature range:

Melt temperature 190 - 230 °C