

ABS AF360S

Extrusion Molding

Description

TBBA-free Flame Retardant, Low Flow

Application

Electric/Electronic Applications(TV, Monitor Housing)
IT/OA device

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.19
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.7
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	6
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	430
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	5
@ Break	50mm/min		%	20
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²	22,000
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm ²	680
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm ²	24,000
IZOD Impact Strength, 6.4mm		ASTM D256		
(Notched)	23℃		kg-cm/cm	18
	-30℃		kg-cm/cm	7
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg-cm/cm	25
	-30℃		kg-cm/cm	8
Rockwell Hardness	R-Scale	ASTM D785	-	99
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	85
	4.6kg		℃	95
Vicat Softening Temperature		ASTM D1525		
	5kg, 50℃/h		℃	94
Flammability		UL94		
1.5mm			class	V-0
2.0mm			class	V-0,5VA
2.5mm			class	
3.0mm			class	V-0,5VA
Relative Temperature Index		UL 746B		
Electrical			℃	60
Mechanical with Impact			℃	60
Mechanical without Impact			℃	60

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23℃, 50% relative humidity.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要更多物性资料请查阅 www.kedisujiao.com

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Processing Guide (Extrusion Molding)

Processing Parameters	Unit	Value	
Drying Temperature	℃	70 ~ 80	
Drying Time	hrs	2 ~ 4	
Minimum Moisture Content	%	0.01	
Melt Temperature	℃	200 ~ 230	
Barrel Temperature	Zone 1	℃	170 ~ 190
	Zone 2	℃	180 ~ 200
	Zone 3	℃	200 ~ 220
	Zone 4	℃	200 ~ 220
Adapter Temperature	℃	200 ~ 230	
Die Temperature	℃	200 ~ 230	
Roll Stack Temperature	Top	℃	70 ~ 100
	Middle	℃	70 ~ 90
	Bottom	℃	60 ~ 90

Note) Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.

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