

Rotec® AES A 707

Acrylonitrile Ethylene Styrene

ROMIRA GmbH

Message:

Rotec® AES A 707 is an acrylonitrile ethylene styrene (AES) material. This product is available in Europe and is processed by extrusion or injection molding. Rotec® The main characteristics of AES A 707 are: flame retardant/rated flame.

General Information			
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.02	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	6.0	g/10 min	ISO 1133
Molding Shrinkage	0.50 - 0.70	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	1200	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	18.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	42	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	1200	MPa	ISO 178
Flexural Stress ² (23°C)	33.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	32	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	91.0	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	< 80.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.050	%	
Suggested Max Regrind	5	%	
Rear Temperature	210 - 250	°C	
Middle Temperature	210 - 250	°C	
Front Temperature	210 - 250	°C	
Processing (Melt) Temp	< 260	°C	
Mold Temperature	40.0 - 80.0	°C	

Injection Rate	Fast	
Injection instructions		
Screw rotation speed: moderate to highBack pressure: low to moderatelnjection pressure: tool depending		
Extrusion	Nominal Value	Unit
Drying Temperature	< 80.0	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	< 0.050	%
Cylinder Zone 1 Temp.	190 - 210	°C
Cylinder Zone 2 Temp.	190 - 210	°C
Cylinder Zone 3 Temp.	190 - 210	°C
Cylinder Zone 4 Temp.	190 - 210	°C
Cylinder Zone 5 Temp.	190 - 210	°C
Melt Temperature	< 245	°C
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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