

Rotec® ABS HF 4

Acrylonitrile Butadiene Styrene

ROMIRA GmbH

Message:

Rotec® ABS HF 4 is an acrylonitrile butadiene styrene (ABS) material. This product is available in Europe and is processed by extrusion or injection molding.

Rotec® The main characteristics of ABS HF 4 are:

flame retardant/rated flame

high liquidity

General Information	
UL YellowCard	E148878-223643
Features	High liquidity
UL File Number	E148878
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	57	g/10 min	ISO 1133
Molding Shrinkage	0.40 - 0.60	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2400	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	44.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	14	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2300	MPa	ISO 178
Flexural Stress ² (23°C)	72.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	13	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	98.0	°C	ISO 306/B50
CLTE - Flow (23 to 55°C)	8.5E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.18	W/m/K	ISO 8302

Flammability	Nominal Value	Test Method
Flame Rating (1.50 mm)	HB	UL 94

Additional Information

The value listed as Thermal Conductivity ISO 8302, was tested in accordance with DIN 52612.

Injection	Nominal Value	Unit
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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 high Back pressure: low to moderate Injection 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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