

Cevian®-V 680

Acrylonitrile Butadiene Styrene

PlastxWorld Inc.

Message:

Cevian®-V 680 is an acrylonitrile butadiene styrene (ABS) product. It can be processed by injection molding and is available in North America.

Features include:

flame retardant/rated flame

high liquidity

Impact resistance

General Information			
Features	Impact resistance, high		
	High liquidity		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	50	g/10 min	ISO 1133
Molding Shrinkage	0.50 - 0.70	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	40.0	MPa	ISO 527-2
Flexural Modulus	2200	MPa	ISO 178
Flexural Stress	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	25	kJ/m²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature			
--	101	°C	ISO 306/A50
--	91.0	°C	ISO 306/B50
--	93.0	°C	ISO 306/B120
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94

Additional Information

The value listed as Mold Shrinkage, ISO 294, was tested in accordance with ISO 2577.

Injection	Nominal Value	Unit
Drying Temperature	79.4 - 85.0	°C
Drying Time	2.0 - 4.0	hr
Rear Temperature	180 - 200	°C

Middle Temperature	200 - 220	°C
Front Temperature	220 - 240	°C
Processing (Melt) Temp	230 - 250	°C
Mold Temperature	48.9 - 60.0	°C
Injection Pressure	34.5 - 103	MPa
Injection Rate	Moderate-Fast	
Back Pressure	0.689 - 2.07	MPa
Screw Speed	60 - 80	rpm

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