

UMG ABS® VW804

Acrylonitrile Butadiene Styrene

UMG ABS, Ltd.

Message:

UMG ABS® VW804 is an Acrylonitrile Butadiene Styrene (ABS) material. It is available in Asia Pacific or North America for injection molding.

Important attributes of UMG ABS® VW804 are:

Flame Rated

RoHS Compliant

General Information			
RoHS Compliance	RoHS Compliant		
UL File Number	E47016		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.20	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (23°C)	0.50 to 0.70	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	100		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2050	MPa	ISO 527-2
Tensile Stress (23°C)	42.0	MPa	ISO 527-2
Flexural Modulus ¹ (23°C)	2100	MPa	ISO 178
Flexural Stress ² (23°C)	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	4.0	kJ/m ²	
23°C	12	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	85.0	°C	ISO 75-2/Af
CLTE - Flow	9.0E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	V-0		
2.00 mm	5VA		
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 4.0	hr	
Rear Temperature	150 to 190	°C	

Middle Temperature	170 to 210	°C
Front Temperature	180 to 220	°C
Nozzle Temperature	170 to 210	°C
Processing (Melt) Temp	200 to 230	°C
Mold Temperature	50.0 to 60.0	°C
Injection Pressure	70.0 to 130	MPa
Injection Rate	Moderate	
Back Pressure	5.00 to 10.0	MPa
Screw Speed	30 to 70	rpm
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

