

# Shinko-Lac® ABS VL-1

Acrylonitrile Butadiene Styrene

Mitsubishi Rayon America Inc.

## Message:

Shinko-Lac ABS VL-1 is a flame retardant grade that offers excellent flame retardant characteristics to products along with good thermal stability. Good flow property offers easy processing especially for large and thin products. Typical applications of VL-1 include electrical/electronic applications.

General Information			
Additive	Flame retardancy		
Features	Good dimensional stability		
	Rigidity, high		
	Highlight		
	High strength		
	Impact resistance, good		
	Weldable		
	Workability, good		
	Sprayable		
	Machinable		
	Good chemical resistance		
	Thermal stability, good		
	Good toughness		
	Good appearance		
	Non-toxic		
	High hardness		
	Flame retardancy		
UL File Number	E54695		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Extrusion		
	Calendering		
	Vacuum forming		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50	%	ASTM D955

Water Absorption (24 hr)	0.22	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2450	MPa	ASTM D638
Tensile Strength (Yield, 23°C)	39.2	MPa	ASTM D638
Flexural Modulus (23°C, 6.35 mm)	2500	MPa	ASTM D790
Flexural Strength (Yield, 23°C, 6.35 mm)	63.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.35 mm)	88	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 12.7 mm)	79.0	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.59 mm, NC	V-2		UL 94
3.18 mm, NC	V-2		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	200 - 250	°C	
Middle Temperature	200 - 250	°C	
Front Temperature	200 - 250	°C	
Mold Temperature	40.0 - 80.0	°C	
Injection Pressure	68.6 - 108	MPa	
Injection instructions			

Higher mold temperature provides a product with excellent surface finish and less residual stress.

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