Prime ABS 750

Acrylonitrile Butadiene Styrene

Primex Plastics Corporation

Message:

Prime ABS 750 Is a general purpose ABS product that has good impact strength, and good hot strength for thermoforming. It is an amorphous thermoplastic material and therefore, processes easier than some other thermoplastic materials.

Applications:

Prime ABS 750 may be used for interior applications such as appliance parts, tub and shower wall surrounds, and interior automotive trim. With the addition of a weatherable cap it may also be used in many outdoor applications.

Processing:

Prime ABS 750 is rather easy to thermoform due to its exceptional hot strength. It can be formed on wood, epoxy, ceramic and or aluminum tools. The forming temperature has a range of 300 -350°F. For best results the mold temperature should be 150-190°F. In some cases it is necessary to dry the sheet before forming.

Finishing:

Parts made with Prime ABS 750 may be joined with machine screws, bolts, nuts, rivets, and spring steel fasteners. Thread cutting or thread-forming screws is an economical means of securing separate joints. Formed parts may be joined with Methylene Chloride if maximum impact strength is not required. Press and snap techniques and sonic welding may also be used for the bonding of Prime ABS 750.

Please contact your Primex Plastics representative for more information on finishing, fabricating, or the thermoforming process. Colors, Textures, Capabilities:

Prime ABS 750 can be color matched to meet your specific requirements. Prime ABS 750 is available in Thicknesses from .030 - .400. Textures include; Calf Grain, HC, RM, Seville, Levant I, FL/HC and Diamond Plate.

General Information				
Features	Amorphous			
	Bondability			
	High Heat Resistance			
	High Impact Resistance			
	High Tensile Strength			
	Low Temperature Impact Resistance			
	Machinable			
	Ultrasonic Weldable			
Uses	Appliance Components			
	Automotive Interior Trim			
	Bathroom Accessories			
Agency Ratings	FDA 21 CFR 181.32			
Appearance	Colors Available			
Forms	Sheet			
Processing Method	Thermoforming			
Physical	Nominal Value	Unit	Test Method	
Specific Gravity	1.04	g/cm³	ASTM D792	
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	1.7	g/10 min	ASTM D1238	
Hardness	Nominal Value	Unit	Test Method	
Rockwell Hardness (R-Scale)	102		ASTM D785	

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	35.2	MPa	ASTM D638
Flexural Modulus	1860	MPa	ASTM D790
Flexural Strength	55.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	120	J/m	
23°C	340	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45	02.2	۰c	
MPa, Annealed)	92.2		ASTIVI D648
Vicat Softening Temperature	107	°C	ASTM D1525
Flammability	Nominal Value		Test Method
Flame Rating ¹ (0.762 mm)	НВ		UL 94
Flammability (> 1.27 mm)	Pass		FMVSS 302
Thermoforming Molding Temperature			
Forming Temperature	149 to 177	°C	
Mold Temperature	66 to 88	°C	
Optical	Nominal Value		Test Method
Gardner Gloss (60°)	90		ASTM D523
NOTE			
1.	>0.03 in		

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