

Cevian®-V 680, 680SF

Acrylonitrile Butadiene Styrene

Daicel Polymer Ltd.

Message:

Cevian®-V 680, 680SF is an Acrylonitrile Butadiene Styrene (ABS) material. It is available in Asia Pacific. Primary attribute of Cevian®-V 680, 680SF: Flame Rated.

General Information			
UL YellowCard	E47773-239448		
Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	55	g/10 min	ISO 1133
Molding Shrinkage - Flow	0.40 to 0.60	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	42.0	MPa	ISO 527-2
Flexural Modulus	2300	MPa	ISO 178
Flexural Stress	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	10	kJ/m ²	
23°C	25	kJ/m ²	
Notched Izod Impact			ASTM D256
-30°C, 6.40 mm	130	J/m	
23°C, 6.40 mm	250	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 12.7 mm	86.0	°C	ASTM D648
1.8 MPa, Unannealed	76.0	°C	ISO 75-2/A
Vicat Softening Temperature	92.0	°C	ISO 306/B50
CLTE - Flow	8.0E-5	cm/cm/°C	ISO 11359-2
Ball Pressure Test	90	°C	
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	Test Method
Drying Temperature	80.0 to 85.0	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	170 to 190	°C	

Middle Temperature	190 to 210	°C
Front Temperature	210 to 230	°C
Nozzle Temperature	210 to 230	°C
Mold Temperature	40.0 to 60.0	°C
Back Pressure	10.0 to 20.0	MPa
Screw Speed	70 to 90	rpm

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