

POLYFLAM® RABS 90000 UV7 5V

Acrylonitrile Butadiene Styrene

A. Schulman Europe

Message:

Flame retardant ABS-Compound without PBDE, good flow and higher thermal stability, UL 94 5VA rated

General Information			
Features	Workability, good		
	Good liquidity		
	Thermal stability, good		
	Flame retardancy		
UL File Number	E86615		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	28.0	cm³/10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2000	MPa	ISO 527-2/1A/1
Tensile Stress			ISO 527-2/1A/50
Yield	35.0	MPa	ISO 527-2/1A/50
Fracture	27.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	2.8	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	11	%	ISO 527-2/1A/50
Flexural Modulus ¹	2100	MPa	ISO 178
Flexural Stress ²			ISO 178
9.5% strain ³	54.0	MPa	ISO 178
4.6% strain	60.0	MPa	ISO 178
3.5% strain	58.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	2.0	kJ/m²	ISO 179/1eA
23°C	7.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	35	kJ/m²	ISO 179/1eU
23°C	80	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	82.0	°C	ISO 75-2/Bf

1.8 MPa, not annealed	66.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	106	°C	ISO 306/A50
--	92.0	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	175	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94, IEC 60695-11-10, -20
0.800 mm	V-0		UL 94, IEC 60695-11-10, -20
1.60 mm	V-0		UL 94, IEC 60695-11-10, -20
3.20 mm	V-0		UL 94, IEC 60695-11-10, -20
1.50 mm	5VB		UL 94, IEC 60695-11-10, -20
2.00 mm	5VA		UL 94, IEC 60695-11-10, -20
Glow Wire Flammability Index			IEC 60695-2-12
0.750 mm	960	°C	IEC 60695-2-12
1.50 mm	960	°C	IEC 60695-2-12
2.00 mm	960	°C	IEC 60695-2-12
3.00 mm	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
0.750 mm	750	°C	IEC 60695-2-13
1.50 mm	750	°C	IEC 60695-2-13
2.00 mm	750	°C	IEC 60695-2-13
3.00 mm	750	°C	IEC 60695-2-13

Additional Information

1.)
Not for use in food contact applications2.)
Not for use in medical or pharmaceutical applications

Injection	Nominal Value	Unit
Drying Temperature	70.0 - 80.0	°C
Drying Time	2.0 - 4.0	hr
Rear Temperature	220	°C
Middle Temperature	230	°C
Front Temperature	240	°C
Nozzle Temperature	240	°C
Processing (Melt) Temp	220 - 240	°C
Mold Temperature	30.0 - 80.0	°C
Injection Pressure	80.0 - 120	MPa
Injection Rate	Slow-Moderate	
Holding Pressure	40.0 - 90.0	MPa

Back Pressure	5.00 - 10.0	MPa
Cushion	< 5.00	mm
Screw Speed		mm/sec

Injection instructions

PredryingPredrying at 70°C for 2-4 hours is recommended as a precaution.ReprocessingAddition of regrind is normally possible, but it must be tested in each case regarding the percentage and requirements of the article. Thermal damage during first processing depends on processing parameters and the geometry of flow path and article.Shut downAvoid long melt residence time. Purge with base polymer or with polyolefines.FinishingMachining is usually possible.

NOTE

1.	2.0 mm/min
2.	2.0 mm/min
3.	at Break

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