

# Prime ABS Film-X 100

Acrylonitrile Butadiene Styrene

Primex Plastics Corporation

## Message:

Prime ABS Film-X is a Prime ABS substrate with a UV and chemical resistant film. It is available in high gloss with a good DOI or low gloss.

### Applications:

Prime ABS Film-X has a wide variety of possible exterior applications from side pillars, spoilers, side molding. It is ideal for any exterior application requiring a very high gloss or dull finish with UV and chemical resistance.

### Processing:

Thermoforming temperatures, mold temperatures, de-molding and mold shrink are about the same as ABS. However, the film side of the sheet should be exposed to a minimum amount of heat in the oven of the former.

### Finishing:

Cutting or machining of this product may be done by sawing, drilling, grinding, sanding, punching and die cutting. High pressure water and laser cutting will also work.

This product may be bonded by chemicals, mechanical screws and other type of fasteners as well as sonic welding. Minor surface repairs may be made with Dupont 7 or 3M glazing compound.

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

### Colors, Textures and Capabilities:

Colors can be matched to any solid color, metallic, pearlescents, and tinted clears. Patterns include brushed metals, organics and geometrics.

General Information			
Additive	UV Stabilizer		
Features	Bondability		
	Good Chemical Resistance		
	Good UV Resistance		
	High Gloss		
	Machinable		
	Medium Impact Resistance		
Uses	Ultrasonic Weldable		
	Automotive Exterior Parts		
	Automotive Exterior Trim		
Appearance	Outdoor Applications		
	Colors Available		
	Film		
Forms	Thermoforming		
Processing Method			
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	6.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1390	MPa	ASTM D638
Flexural Modulus (3.18 mm)	1890	MPa	ASTM D790
Films	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D882


MD : Yield	37.9	MPa	
TD : Yield	36.5	MPa	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	93.3	°C	
1.8 MPa, Unannealed	81.7	°C	
CLTE - Flow	8.8E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating <sup>1</sup> (2.70 mm)	HB		UL 94
Flammability (> 2.70 mm)	Pass		FMVSS 302
NOTE			
1.	>2.7mm		

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