

Prime ABS Weather-X 200

Acrylonitrile Butadiene Styrene + Acrylic (PMMA)

Primex Plastics Corporation

Message:

Is an acrylic capped co-extruded ABS sheet, which can be produced as a two or three multilayer composite. The acrylic cap imparts a very high gloss, vibrant colors with superior depth of image, excellent UV protection, chemical resistance, toughness and excellent formability.

Applications:
The performance features of Prime ABS Weather-X 200 make it the material of choice for applications, including marine, personal watercraft, recreational vehicles, lawn/garden, building/construction and automotive accessories.

Processing:
Surface Temp = 325-360°F
Mold Temp = 150-175°F
De-mold @ 170°F
Mold shrink is .004-.008 in/in.

ABS may absorb greater amounts of radiant energy than acrylic; thus, surface temperatures may increase more rapidly. Care should be taken to maintain the surface temperature at 325°F-360°F to avoid blistering, burning and color/gloss shift of the acrylic cap.

Finishing:
Prime ABS Weather-X 200 can be joined using mechanical methods such as bolts, screws or clamps, or chemical methods such as cementing. When drilling coextruded sheet with an acrylic modified drill bit, be sure to exit from the acrylic side but when drilling with a standard bit, be sure to have the bit exit from the substrate side. For accuracy and safety, Prime ABS Weather-X 200 should be clamped during drilling.
Please contact your Primex Plastics representative for more information on finishing, fabricating, or the thermoforming process.

Colors, Textures and Capabilities:
Prime ABS Weather-X 200 can be color matched to meet your specific requirements. The surface is typically high gloss but textures such as calf grain, H/C, F/L H/C, Levant 1 and Seville are available.

General Information	
Additive	UV Stabilizer
Features	Good Chemical Resistance
	Good Color Stability
	Good Moldability
	Good UV Resistance
	High Gloss
	High Heat Resistance
	High Impact Resistance
	High Tensile Strength
Uses	Automotive Applications
	Building Materials
	Construction Applications
	Lawn and Garden Equipment
	Marine Applications
	Sporting Goods
	Water Sports Equipment
Appearance	Colors Available
Forms	Sheet

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	8.9	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	36.0	MPa	ASTM D638
Tensile Elongation (Break)	22	%	ASTM D638
Flexural Modulus	1930	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
0°C, 3.18 mm	230	J/m	
22°C, 3.18 mm	300	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	97.8	°C	ASTM D648
Optical	Nominal Value		Test Method
Gardner Gloss (60°)	87		ASTM D523
Additional Information	Nominal Value	Unit	
De-mold Temperature	77	°C	
Mold Temperature (other)	66 to 79	°C	
Surface Temperature	163 to 182	°C	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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