

Technical Data Sheet

Polyflam ABS860V0UVLB15680 GREY



Acrylonitrile Butadiene Styrene

Product Description

Polyflam ABS860V0UVLB15680 GREY is a Acrylonitrile Butadiene Styrene material.

Forms Pellets

Additive Flame Retardant

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (200 °C/5.0 kg)	5.0	g/10 min	ASTM D1238
Density - Specific Gravity	1.2	g/cm ³	ASTM D792
Mechanical			
Tensile Elongation at Yield	4	%	ASTM D638
Tensile Strength at Yield	41	MPa	ASTM D638
Tensile Strength at Break	27	MPa	ASTM D638
Flexural Modulus	2400	MPa	ASTM D790
Tensile Elongation at Break	25	%	ASTM D638
Tensile Modulus	1700	MPa	ASTM D638
Flexural Strength	57	MPa	ASTM D790
Impact			
Notched Izod Impact	360	J/m	ASTM D256
Hardness			
Rockwell Hardness, (R-Scale)	92		ASTM D785
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	66	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	77	°C	ASTM D648
UL Information			
Flame Rating			
(1.6 mm)	V-0		UL 94
(2.5 mm)	5VA		UL 94
UL File Number	E51193		

Injection Parameters	Nominal Value	Units
Drying Time, (Desiccant Dryer)	4.0	hr
Drying Temperature, (Desiccant Dryer)	82	°C
Suggested Max Moisture	0.02	%
Screw Speed	50 to 150	rpm
Processing (Melt) Temp	199 to 227	°C
Front Temperature	193 to 227	°C
Middle Temperature	193 to 227	°C
Rear Temperature	193 to 227	°C
Injection Rate	Moderate	
Back Pressure	0.483 to 1.38	MPa
Mold Temperature	41 to 80	°C
Cushion	6.35 to 12.7	mm