

Rotec® ABS 1001 FR V0/5

Acrylonitrile Butadiene Styrene

ROMIRA GmbH

Message:

Rotec® ABS 1001 FR V0/5 is an acrylonitrile butadiene styrene (ABS) material. This product is available in Europe and is processed by extrusion or injection molding.

Rotec® The main features of ABS 1001 FR V0/5 are:

flame retardant/rated flame

Flame Retardant

General Information			
UL YellowCard	E148878-223637	E148878-223635	
Features	Flame retardancy		
UL File Number	E148878		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	47	g/10 min	ISO 1133
Molding Shrinkage	0.30 - 0.60	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2200	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	40.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	15	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2300	MPa	ISO 178
Flexural Stress ² (23°C)	55.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	11	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	81.0	°C	ISO 75-2/A
Vicat Softening Temperature	91.0	°C	ISO 306/B50
Flammability	Nominal Value	Test Method	
Flame Rating (1.50 mm)	V-0	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	< 80.0	°C	
Drying Time	2.0 - 4.0	hr	

Suggested Max Moisture	0.050	%
Suggested Max Regrind	5	%
Rear Temperature	200 - 230	°C
Middle Temperature	200 - 230	°C
Front Temperature	200 - 230	°C
Processing (Melt) Temp	< 235	°C
Mold Temperature	40.0 - 60.0	°C
Injection Rate	Slow	

Injection instructions

Screw rotation speed: slow Back pressure: 10% Injection pressure: high

Extrusion	Nominal Value	Unit
Drying Temperature	< 80.0	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	< 0.050	%
Cylinder Zone 1 Temp.	170 - 200	°C
Cylinder Zone 2 Temp.	170 - 200	°C
Cylinder Zone 3 Temp.	170 - 200	°C
Cylinder Zone 4 Temp.	170 - 200	°C
Cylinder Zone 5 Temp.	170 - 200	°C
Melt Temperature	< 200	°C

NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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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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