

Prime ABS Weather-X 100

Acrylonitrile Butadiene Styrene + Acrylic (PMMA)

Primex Plastics Corporation

Message:

Prime ABS Weather-X 100 is an ABS substrate with an Acrylic co-extruded cap. If requested a thin layer of Acrylic can be extruded on the back side for rigidizing. It offers good weatherability, chemical resistance, and high gloss with good DOI.

Applications:
This product is ideal for outdoor applications such as marine, ATV, RV, Tub & Shower Surrounds or anything where the above characteristics are required.

Processing:
Forming conditions for this product are:
Surface Temperature = 300-390° F
Mold Temperature = 110-185° F
Plug Temperature = 220-300° F
De-mold = 200° F
Mold Shrink = .005 - .008 in/in
Primary side of sheet should not be heated as much as the secondary side.

Finishing:
Parts from this product may be joined with machine screws, bolts, nuts, and washers, rivets and spring steel fasteners. Thread cutting or thread-forming screws are an economical means of securing separate parts. Press and snap techniques, sonic welding and chemical bonding may also be used. Please contact your Primex Plastics representative for more information on finishing, fabricating, or the thermoforming process.

Colors, Textures and Capabilities:
There are many colors available, however, please check with your Primex representative for specific colors. Typically this product is smooth, however, there are several patterns available, such as haircell, calfgain & levant.

General Information			
Features	Good Chemical Resistance		
	Good Colorability		
	Good Moldability		
	Good Weather Resistance		
	High Gloss		
	High Heat Resistance		
	High Impact Resistance		
	High Tensile Strength		
Uses	Automotive Applications		
	Marine Applications		
	Outdoor 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/10.0 kg)	6.5	g/10 min	ASTM D1238

Molding Shrinkage - Flow	0.30 to 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	41.0	MPa	ASTM D638
Tensile Elongation (Break)	29	%	ASTM D638
Flexural Modulus	2000	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (22°C, 3.18 mm)	300	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	94.4	°C	
1.8 MPa, Unannealed, 3.18 mm	85.0	°C	
Additional Information	Nominal Value	Unit	
De-mold Temperature	93	°C	
Mold Temperature (other)	43 to 85	°C	
Plug Temperature	104 to 149	°C	
Surface Temperature	149 to 199	°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

