

Rotec® AES U 400

Acrylonitrile Ethylene Styrene

ROMIRA GmbH

Message:

Rotec® AES U 400 is an acrylonitrile ethylene styrene (AES) material. This product is available in Europe and is processed by extrusion or injection molding.

General Information	
Appearance	Clear/transparent
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.0	g/10 min	ISO 1133
Molding Shrinkage	0.40 - 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)	2150	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	49.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	20	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2300	MPa	ISO 178
Flexural Stress ² (23°C)	63.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m ²	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)	78.0	°C	ISO 75-2/A
Vicat Softening Temperature	96.0	°C	ISO 306/B50
CLTE - Flow (23 to 55°C)	9.0E-5	cm/cm/°C	ISO 11359-2

Additional Information

The value listed as Thermal Conductivity ISO 8302, was tested in accordance with DIN 52612.

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	210 - 250	°C
Middle Temperature	210 - 250	°C

Front Temperature	210 - 250	°C
Processing (Melt) Temp	< 260	°C
Mold Temperature	40.0 - 80.0	°C
Injection Rate	Fast	

Injection instructions

Screw rotation speed: moderate to high Back pressure: low to moderate Injection pressure: tool depending

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.	190 - 210	°C
Cylinder Zone 2 Temp.	190 - 210	°C
Cylinder Zone 3 Temp.	190 - 210	°C
Cylinder Zone 4 Temp.	190 - 210	°C
Cylinder Zone 5 Temp.	190 - 210	°C
Melt Temperature	< 245	°C

NOTE

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

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