

Rotec® ABS SE 3

Acrylonitrile Butadiene Styrene

ROMIRA GmbH

Message:

Rotec® ABS SE 3 is an acrylonitrile butadiene styrene (ABS) material. This product is available in Europe and is processed by extrusion or injection molding. Rotec® The main characteristics of ABS SE 3 are: flame retardant/rated flame.

General Information			
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	13	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.50	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2400	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	46.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	15	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2450	MPa	ISO 178
Flexural Stress ² (23°C)	72.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	6.0	kJ/m ²	ISO 179/1eA
23°C	16	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	90	kJ/m ²	ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	99.0	°C	ISO 306/B50
CLTE - Flow (23 to 55°C)	9.0E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.18	W/m/K	DIN 52612
Flammability	Nominal Value	Test Method	
Flame Rating (1.50 mm)	HB	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	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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