

Rotec® ABS 1001 FR/E

Acrylonitrile Butadiene Styrene

ROMIRA GmbH

Message:

Rotec® ABS 1001 FR/E 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/E are:

flame retardant/rated flame

Flame Retardant

Impact resistance

General Information			
UL YellowCard	E148878-223638		
Features	Impact resistance, high		
	Flame retardancy		
UL File Number	E148878		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.17	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	20	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)	2450	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	40.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	18	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2300	MPa	ISO 178
Flexural Stress ² (23°C)	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	8.0	kJ/m ²	ISO 179/1eA
23°C	18	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature (1.8 MPa, Unannealed)	85.0	°C	ISO 75-2/A
Vicat Softening Temperature	97.0	°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: slowBack 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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