

Taitalac® 1250

Acrylonitrile Butadiene Styrene

Taita Chemical Company, Ltd.

Message:

Taitalac® 1250 is an acrylonitrile butadiene styrene (ABS) material. This product is available in North America or Asia Pacific region. The processing method is injection molding.

Taitalac®The main features of the 1250 are:

flame retardant/rated flame

high liquidity

Impact resistance

Taitalac®The typical application fields of 1250 are: electrical appliances

General Information			
Features	Impact resistance, high		
	Electroplateable		
	High liquidity		
Uses	Electrical appliances		
UL File Number	E50263		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 kg	2.0	g/10 min	ASTM D1238
220°C/10.0 kg	21	g/10 min	ASTM D1238
Molding Shrinkage - Flow	< 0.40	%	ASTM D955
Water Absorption (24 hr)	< 0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	105		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield, 23°C, 3.18mm	37.9	MPa	ASTM D638
Fracture, 23°C, 3.18mm	32.4	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C, 3.18 mm)	30	%	ASTM D638
Flexural Modulus ³ (23°C)	2480	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 23°C)	68.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.18 mm	230	J/m	ASTM D256
23°C, 6.35 mm	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed, 12.7 mm)	85.0	°C	ASTM D648
Vicat Softening Temperature	100	°C	ASTM D1525 ⁵
RTI Elec (1.57 mm)	60.0	°C	UL 746
RTI Imp (1.57 mm)	60.0	°C	UL 746
RTI (1.57 mm)	60.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
High Amp Arc Ignition (HAI) (1.57 mm)	200		UL 746
High Voltage Arc Tracking Rate (HVTR) (1.57 mm)	0.00	mm/min	UL 746
Hot-wire Ignition (HWI) (1.57 mm)	16	sec	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.59 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 85.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	185 - 215	°C	
Middle Temperature	195 - 225	°C	
Front Temperature	185 - 215	°C	
Nozzle Temperature	205 - 235	°C	
Processing (Melt) Temp	170 - 180	°C	
Mold Temperature	40.0 - 70.0	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.345 - 0.483	MPa	
Screw Speed	30 - 100	rpm	
Injection instructions			
Injection Pressure: Moderate to Moderately High			
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		
3.	2.8 mm/min		
4.	2.8 mm/min		
5.	压力1 (10N)		

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