Prime ABS Weather-X ML200

Acrylonitrile Butadiene Styrene

Primex Plastics Corporation

Message:

Offering one of the highest aesthetics, gloss and depth of image in the industry, our Weather-X ML200 may consist of 3-5 layers but is typically 3 consisting of clear acrylic, colored acrylic and ABS. Key properties are surface hardness, chemical resistance, weatherability, toughness and excellent formability.
Applications:
Include; RV, automotive, transportation and marine industries.
Processing:
Surface Temp = 325-350°F
Mold Temp = 150-175°F
De-mold @ 170°F
Mold shrink is .004-.008 in/in.
Oven heaters on gloss side should be somewhat lower than on the substrate side. The sheet must be fully saturated with heat before forming.
Finishing:
When drilling co-extruded sheet with an acrylic modified drill bit, be sure to exit from the acrylic side but when drilling with a standard bit, be sure to have the bit exit from the substrate side. For accuracy and safety, acrylic capped sheet should be clamped during drilling. For cutting/trimming Weather-X ML 200 sheet with CNC or air routers, a standard solid carbide fiberglass router -diamond-cut tool can be used. Routing parts in a CNC environment is best done with chip-breaker-type, solid carbide tools.
Please contact your Primex Plastics representative for more information on finishing, fabricating, or the thermoforming process.
Colors, Textures and Capabilities:
The surface is typically high gloss. Colors include Solids, Granite, Pearlescent, Swirl, Metallics, Soft White and Metamerism effects.

General Information	
Features	Good Chemical Resistance
	Good Moldability
	Good Toughness
	Good Weather Resistance
	High Gloss
	High Hardness
	High Heat Resistance
	High Impact Resistance
	High Tensile Strength
	Machinable
	Pleasing Surface Appearance
Uses	Automotive Applications
	Marine Applications
	Sporting Goods
Appearance	Colors Available
Forms	Sheet

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.40 to 0.80	%	

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	102		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	40.7	MPa	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Flexural Strength	65.5	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	220	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	87.8	°C	ASTM D648
Optical	**Nominal Value**		**Test Method**
Gardner Gloss (60°)	85		ASTM D523
Additional Information	**Nominal Value**	**Unit**	
De-mold Temperature	77	°C	
Mold Temperature (other)	66 to 79	°C	
Surface Temperature	163 to 177	°C	

Recommended distributors for this material

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