

Sinkral® M 4 Modena

Acrylonitrile Butadiene Styrene

Versalis S.p.A.

Message:

Extrusion and co-extrusion grade with an high mattness and a very low roughness

Designation: Thermoplastic ISO 2580-ABS 1,EGN,105-08-09-15

Applications

Sinkral M 4 Modena is used in extrusion and co-extrusion of sheets and profiles that need, at the same time, high mattness and a smooth surface.

General Information	
Features	Excellent appearance
Uses	Sheet
Appearance	Natural color
Forms	Particle
Processing Method	Co-extrusion molding
	Extrusion
	Sheet extrusion 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)	8.0	g/10 min	ISO 1133
Molding Shrinkage	0.40 - 0.60	%	Internal method
Water Absorption (23°C, 24 hr)	0.30	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	97		ISO 2039-2

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	27.0	MPa	ASTM D638
Tensile Elongation ² (Break)	100	%	ASTM D638
Flexural Modulus ³	1550	MPa	ASTM D790
Flexural Strength ⁴	40.0	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.0	kJ/m ²	DIN 53453
Charpy Unnotched Impact Strength			DIN 53453
-40°C	No Break		DIN 53453
23°C	No Break		DIN 53453
Notched Izod Impact			
-40°C, 3.20 mm	75	J/m	ISO 180/4A
-20°C, 3.20 mm	80	J/m	ISO 180/4A
0°C, 3.20 mm	90	J/m	ISO 180/4A
23°C, 3.20 mm	110	J/m	ISO 180/4A

-40°C ⁵	7.0	kJ/m ²	ISO 180/1A
23°C ⁶	9.5	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Annealed)	101	°C	ASTM D648
Vicat Softening Temperature			
--	106	°C	ISO 306/A120
--	101	°C	ISO 306/B120
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
Thermal Conductivity	0.17	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Dielectric Strength	30	kV/mm	IEC 60243-1
Dielectric Constant (1 kHz)	3.10		IEC 60250
Dissipation Factor (1 kHz)	0.015		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.5 mm)	HB		UL 94
Glow Wire Ignition Temperature (3.0 mm)	650	°C	IEC 60695-2-13
Additional Information	Nominal Value		
Designation	Thermoplastic ISO 2580-ABS 1,EGN,105-08-09-15		
Extrusion	Nominal Value	Unit	
Drying Temperature	80	°C	
Drying Time	2.0 - 4.0	hr	
Melt Temperature	180 - 220	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	2.0 mm/min		
4.	2.0 mm/min		
5.	4 mm		
6.	4 mm		

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