

POLYFLAM® RABS 90000 UV5

Acrylonitrile Butadiene Styrene

A. Schulman Europe

Message:

Flame retardant ABS standard grade without PBDE and higher thermal stability

General Information			
UL YellowCard	E86615-297093	E86615-457133	
Features	No frost		
	Good UV resistance		
	Workability, good		
	Thermal stability, good		
	Flame retardancy		
UL File Number	E86615		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	30.0	cm³/10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness	113	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2200	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	42.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	3.0	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.0	kJ/m²	ISO 179/1eA
23°C	10	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	45	kJ/m²	ISO 179/1eU
23°C	80	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	92.0	°C	ISO 75-2/Bf
1.8 MPa, not annealed	80.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	105	°C	ISO 306/A50
--	96.0	°C	ISO 306/B50

Ball Pressure Test (90°C)	Pass		IEC 60695-10-2
RTI Elec			UL 746
1.50 mm	60.0	°C	UL 746
3.00 mm	60.0	°C	UL 746
RTI Imp			UL 746
1.50 mm	60.0	°C	UL 746
3.00 mm	60.0	°C	UL 746
RTI			UL 746
1.50 mm	60.0	°C	UL 746
3.00 mm	60.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	475	V	IEC 60112
High Amp Arc Ignition (HAI)			UL 746
1.50 mm	PLC 3		UL 746
3.00 mm	PLC 3		UL 746
Hot-wire Ignition (HWI)			UL 746
1.50 mm	PLC 3		UL 746
3.00 mm	PLC 0		UL 746
Flammability	Nominal Value	Unit	Test Method
Burning Rate (3.00mm, automatic fire extinguishing)	0.0	mm/min	ISO 3795
Flame Rating			
1.50 mm	V-0		UL 94, IEC 60695-11-10, -20
3.00 mm	V-0		UL 94, IEC 60695-11-10, -20
0.800 mm	V-0		IEC 60695-11-10, -20
4.00 mm	5VA		IEC 60695-11-10, -20
Glow Wire Flammability Index			IEC 60695-2-12
1.50 mm	960	°C	IEC 60695-2-12
3.00 mm	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
1.50 mm	725	°C	IEC 60695-2-13
3.00 mm	725	°C	IEC 60695-2-13
Oxygen Index	28	%	ISO 4589-2
Additional Information			
1.) Not for use in food contact applications2.) Not for use in medical or pharmaceutical applications			
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 80.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	220	°C	
Middle Temperature	230	°C	

Front Temperature	240	°C
Nozzle Temperature	240	°C
Processing (Melt) Temp	220 - 240	°C
Mold Temperature	40.0 - 60.0	°C
Injection Pressure	80.0 - 120	MPa
Injection Rate	Slow-Moderate	
Holding Pressure	40.0 - 90.0	MPa
Back Pressure	5.00 - 10.0	MPa
Cushion	< 5.00	mm
Screw Speed		mm/sec

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