

# REPRO ABS RE6

Acrylonitrile Butadiene Styrene  
Rondo Plast AB

Message:  
Injection moulding, high impact

| General Information                      |                        |                   |                |
|------------------------------------------|------------------------|-------------------|----------------|
| Recycled Content                         | Yes                    |                   |                |
| Features                                 | High Impact Resistance |                   |                |
| Processing Method                        | Injection Molding      |                   |                |
| Physical                                 | Nominal Value          | Unit              | Test Method    |
| Density                                  | 1.05                   | g/cm <sup>3</sup> | ISO 1183       |
| Melt Mass-Flow Rate (MFR)                |                        |                   | ISO 1133       |
| 220°C/10.0 kg                            | 16                     | g/10 min          |                |
| 230°C/5.0 kg                             | 8.0                    | g/10 min          |                |
| Molding Shrinkage                        |                        |                   | ISO 2577       |
| Across Flow                              | 0.60 to 0.80           | %                 |                |
| Flow                                     | 0.60 to 0.80           | %                 |                |
| Mechanical                               | Nominal Value          | Unit              | Test Method    |
| Tensile Stress                           | 35.0                   | MPa               | ISO 527-2      |
| Tensile Strain (Break)                   | 30                     | %                 | ISO 527-2      |
| Flexural Modulus (23°C)                  | 2100                   | MPa               | ISO 178        |
| Flexural Stress                          | 65.0                   | MPa               | ISO 178        |
| Impact                                   | Nominal Value          | Unit              | Test Method    |
| Charpy Notched Impact Strength           |                        |                   | ISO 179        |
| -20°C                                    | 8.0                    | kJ/m <sup>2</sup> |                |
| 23°C                                     | 14                     | kJ/m <sup>2</sup> |                |
| Thermal                                  | Nominal Value          | Unit              | Test Method    |
| Vicat Softening Temperature              | 92.0                   | °C                | ISO 306/B50    |
| Flammability                             | Nominal Value          | Unit              | Test Method    |
| Flame Rating (1.60 mm)                   | HB                     |                   | UL 94          |
| Glow Wire Ignition Temperature (2.00 mm) | 650                    | °C                | IEC 60695-2-13 |
| Injection                                | Nominal Value          | Unit              |                |
| Drying Temperature                       | 80.0                   | °C                |                |
| Drying Time                              | 2.0 to 4.0             | hr                |                |
| Processing (Melt) Temp                   | 190 to 230             | °C                |                |
| Mold Temperature                         | 60.0 to 80.0           | °C                |                |
| Injection Pressure                       | 90.0 to 150            | MPa               |                |
| Injection Rate                           | Fast                   |                   |                |
| Back Pressure                            | 1.00 to 1.50           | MPa               |                |

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