

LNP™ COLORCOMP™ FR23C compound

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

COLORCOMP FR23C is an ABS (non-PBBE additives) resin containing Flame Retardant. Added features include: Good Properties/Toughness, Excellent Moldability.

General Information			
Additive	Flame retardancy		
Features	Good formability		
	Good toughness		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			
230°C/3.8 kg	6.8	g/10 min	ASTM D1238
220°C/5.0 kg	9.8	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)			
	37.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2410	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	42.7	MPa	ASTM D638
Fracture	35.2	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	2.1	%	ASTM D638
Fracture	11	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	2720	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	73.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	270	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	41.8	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	83.9	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	72.2	°C	ASTM D648
Vicat Softening Temperature	90.0	°C	ASTM D1525 ⁶

Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	7.9E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	7.9E-5	cm/cm/°C	ASTM E831
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI	60.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
2.3 mm	V-0		UL 94
2.5 mm	5VB		UL 94
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (200°C, 1000 sec ⁻¹)	310	Pa·s	ASTM D3835
Injection	Nominal Value	Unit	
Drying Temperature	82 - 88	°C	
Drying Time	2.0 - 4.0	hr	
Drying Time, Maximum	6.0	hr	
Suggested Max Moisture	0.10	%	
Suggested Shot Size	50 - 70	%	
Rear Temperature	171 - 182	°C	
Middle Temperature	193 - 204	°C	
Front Temperature	199 - 216	°C	
Nozzle Temperature	199 - 221	°C	
Processing (Melt) Temp	199 - 221	°C	
Mold Temperature	49 - 71	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	30 - 60	rpm	
Vent Depth	0.038 - 0.051	mm	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	1.3 mm/min		
5.	1.3 mm/min		
6.	标准 B (120°C/h), 载荷2 (50N)		

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