

4LAC® 10H13300 H

Acrylonitrile Butadiene Styrene
4Plas

Message:

4LAC 10H13300 H is a Low Flow FR-V2 Heat Stabilised ABS

General Information			
Additive	heat stabilizer		
Features	Low liquidity		
	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	10	g/10 min	ISO 1133
Molding Shrinkage - Across Flow	0.50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2400	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	49.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	15	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	20	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	106	°C	ISO 75-2/B
Vicat Softening Temperature	105	°C	ISO 306/B
Melting Temperature ¹	110	°C	ISO 11357
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-2		UL 94
Glow Wire Flammability Index (2.00 mm)	700	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Processing (Melt) Temp	190 - 230	°C	
Mold Temperature	50.0 - 60.0	°C	
Injection Rate	Moderate-Fast		
Holding Pressure	50.0 - 100	MPa	
Screw Speed	200	rpm	
Injection instructions			

Feed Throat Temperature: 30 - 50 °C Back Pressure: Low

NOTE

1. 10 K/min

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