Rotec® ABS TS 12

Acrylonitrile Butadiene Styrene

ROMIRA GmbH

Message:

Rotec®ABS TS 12 is an acrylonitrile butadiene styrene (ABS) material. This product is available in Europe and is processed by extrusion or injection molding.
Rotec®The main features of ABS TS 12 are:
flame retardant/rated flame
Heat resistance

General Information	
Features	Heat resistance, high
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	21	g/10 min	ISO 1133
Molding Shrinkage	0.30 - 0.70	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (23°C)	2600	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	50.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	10	%	ISO 527-2/50
Flexural Modulus [1] (23°C)	2700	MPa	ISO 178
Flexural Stress [2] (23°C)	78.0	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	13	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Vicat Softening Temperature	101	°C	ISO 306/B50
CLTE - Flow (23 to 55°C)	8.5E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.18	W/m/K	DIN 52612
Flammability	**Nominal Value**		**Test Method**
Flame Rating (1.50 mm)	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature	< 85.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.050	%	
Suggested Max Regrind	5	%	

Rear Temperature	230 - 250	°C
Middle Temperature	230 - 250	°C
Front Temperature	230 - 250	°C
Processing (Melt) Temp	< 260	°C
Mold Temperature	60.0 - 80.0	°C
Injection Rate	Fast	

Injection instructions
Screw rotation speed: moderate to highBack pressure: low to moderateInjection pressure: tool depending

Extrusion	Nominal Value	Unit
Drying Temperature	< 80.0	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	< 0.050	%
Cylinder Zone 1 Temp.	190 - 210	°C
Cylinder Zone 2 Temp.	190 - 210	°C
Cylinder Zone 3 Temp.	190 - 210	°C
Cylinder Zone 4 Temp.	190 - 210	°C
Cylinder Zone 5 Temp.	190 - 210	°C
Melt Temperature	< 245	°C

NOTE	
1.	2.0 mm/min
2.	2.0 mm/min

Recommended distributors for this material

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