

4LAC® 25H23100

Acrylonitrile Butadiene Styrene
4Plas

Message:

4LAC 25H23100 is a MFI 20 to 22 FR-V0 ABS

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (270°C/2.16 kg)	22	g/10 min	ISO 1133
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	102		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2300	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	44.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	40	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	118	°C	ISO 75-2/B
1.8 MPa, not annealed	104	°C	ISO 75-2/A
Vicat Softening Temperature	124	°C	ISO 306/B
Electrical	Nominal Value	Unit	Test Method
High Amp Arc Ignition (HAI) (1.57 mm)	10.0		UL 746
Hot-wire Ignition (HWI) (1.57 mm)	57	sec	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		UL 94
Glow Wire Flammability Index (2.00 mm)	960	°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 °CBack Pressure: Low		
NOTE		
1.	24 Hrs	

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