PRODUCT INFORMATION

TARODUR 100 G2

ABS 13% glass fibres reinforced, good dimensional stability.

ISO short ISO 1043: ABS-GF10
Form Pellets

Key Features

- Good impact - stiffness balance
- Designed for injection moulding applications
- Glass fibres reinforced
- Good flowability

Availability

- LP: laser printable
- L: UV stabilized
- H: heat stabilized
- AS: antistatic
- all colors

Process

- INJECTION MOULDING

Application

- General purpose applications
- Electronic
- Electrical
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	10exp(15)		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,13-1,15		
Filler content	ISO 3451	%	13	750°C - 1 h	
Water Absorption (24h / +23°C)	ISO 62	%	0,10		
Water Absorption at Saturation	ISO 62	%	0,2		
Mould Shrinkage (Parallel)	Internal method	%	0,15-0,35		
Mould Shrinkage (Normal)	Internal method	%	0,35-0,85		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	10	220°C - 10 kg	
MECHANICAL					

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Tensile Modulus	ISO 527-1,2	MPa	5000	Speed 1 mm/min
Elongation at Break	ISO 527-1,2	%	2,5	Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	MPa	68	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	4800	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	70	+23°C
THERMAL				
Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	105	50°C / h
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	102	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	92	Unannealed, 120°C / h
Continuous service temperature (20.000 h)	UL746 B	°C	75	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	4,5x10exp(-5)	-30°C /+30°C
FLAMMABILITY				
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	550	

INJECTION MOULDING	**Value**
Drying Temperature (Circulating Air Oven)	70 - 80°C
Drying Temperature (Desiccant Dryer)	70 - 80°C
Drying Time (Circulating Air Oven)	2 - 4 h
Drying Time (Desiccant Dryer)	1 - 2 h
Suggested Max Regrind	< 15%
Melt Temperature	220 - 250°C
Feed Temperature	180°C
Rear Temperature	210°C
Middle Temperature	220°C
Front Temperature	230°C
Nozzle Temperature	240°C
Mould Temperature	50 - 80°C
Injection Rate	Medium to fast
Back Pressure	0,2 - 0,5 Mpa
Screw Revolving Speed	As low as possible
Cushion	3 - 6 mm

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Screw Compression Ratio	2:1 - 3:1

Notes During processing, a dehumidifying hopper dryer is recommended at a temperature of 60 to 80°C.