PRODUCT INFORMATION

TARODUR 100

ABS for general purpose applications, good flow and gloss.

ISO short	ISO 1043: ABS
Form	Pellets
UL file	E143048

Key Features

- Suitable for under vacum metallization process
- Designed for injection moulding applications
- Good flowability

Availability

- M: low gloss allowing paint-less visible applications
- LP: laser printable
- L: UV stabilized
- H: heat stabilized
- All colours
- AS: antistatic

Compliance

- UL94 HB approved all colours at 1,5 mm - UL746 B approved.

Process

- INJECTION MOULDING

Application

- Power tools
- Household
- Furniture
- Electronic
- Electrical
- Consumer
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	10E(15)		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,04		
Water Absorption (24h / +23°C)	ISO 62	%	0,15		
Mould Shrinkage (Parallel)	Internal method	%	0,6 - 0,7		

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Mould Shrinkage (Normal)	Internal method	%	0,6 - 0,7	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	20	220°C - 10 kg
MECHANICAL				
Tensile Modulus	ISO 527-1,2	MPa	2600	Speed 1 mm/min
Tensile Yield Strength	ISO 527-1,2	MPa	48	Speed 50 mm/min
Elongation at Break	ISO 527-1,2	%	25	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	2500	Speed 1 mm/min
Flexural Max Strength	ISO 178	MPa	66	Speed 1 mm/min
IZOD Notched Impact (+23°C)	ASTM D256	J/m	180	
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	15	
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	97	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	85	Unannealed, 120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	75	
Continuous service temperature	UL746 B	°C	60	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	8x10E(-5)	-30°C /+30°C
FLAMMABILITY				
Flame Behaviour (1,5 mm)	UL94	Class	HB	UL approved
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	650	
Oxigen index	ASTM D2863	%	<21	

INJECTION MOULDING	**Value**
Drying Temperature (Circulating Air Oven)	70 - 80℃
Drying Temperature (Desiccant Dryer)	70 - 80℃
Drying Time (Circulating Air Oven)	2 - 4 h
Drying Time (Desiccant Dryer)	1 - 2 h
Suggested Max Regrind	< 15%
Melt Temperature	220 - 250℃

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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
Screw Compression Ratio	2:1 - 3:1

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