Properties

SER91X

Flame-retardant ABS resin (UL94 V-0)
Superior UV stability

Properties	Test methods	Test conditions	Units	
Melt mass-flow rate	ISO 1133	220 deg C/10kg	g/10min	22
Mold shrinkage	ASTM D955	-	%	0.4-0.6
Tensile strength	ISO 527	-	MPa	46
Flexural strength	ISO 178	-	MPa	66
Flexural modulus	ISO 178	-	MPa	2200
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	9
Notched Izod impact strength	ASTM D256	23 deg C/6.4mm	J/m	90
Rockwell hardness	ISO 2039	-	-	R111
Deflection temperature under load	ISO 75	1.80MPa	deg C	78
Deflection temperature under load	ASTM D648	1.82MPa/12.7mm	deg C	90
Vicat softening temperature	ISO 306/B50	50N X 50deg C/h	deg C	92
Ball pressure temperature	-	-	deg C	85
Coefficient of linear thermal expansion	ISO 11359	MD	X1E-5/deg C	8
Coefficient of linear thermal expansion	ISO 11359	TD	X1E-5/deg C	-
Flammability	UL94	-	-	V-2/0.75mm V-0/1.5mm 5VA/2.5mm
Dielectric strength	ASTM D149	1.5mm	MV/m	25
Arc resistance	ASTM D495	3.0mm	sec(PLC)	36(7)
Water absorption	ISO 62	-	%	0.3
Density	ISO 1183	-	g/cm3	1.23

Note
・Values are typical, not quality assured.
・UL recognition File No. of Daicel Polymer is E47773.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
3-4hrs 70-80deg C	220-230	220-230	200-210	180-190	40-60	5-15	40-60