

# TECHNO ABS F1350

Acrylonitrile Butadiene Styrene

Techno Polymer Co, Ltd.

## Technical Data

### Product Description

TECHNO ABS F1350 is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by injection molding and is available in Asia Pacific or North America.

Characteristics include:

- Flame Rated
- Flame Retardant
- Good UV Resistance
- Heat Resistant

### General

Additive	• Flame Retardant		
Features	• Flame Retardant	• Good Thermal Stability	• Good UV Resistance
UL File Number	• E54297		
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.09 g/cm <sup>3</sup>	1.09 g/cm <sup>3</sup>	ISO 1183 ASTM D1505
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	35 g/10 min	35 g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.60 %	0.40 to 0.60 %	ISO 294-4

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength			
Yield	7540 psi	52.0 MPa	ASTM D638
Yield	7400 psi	51.0 MPa	ISO 527-2
Flexural Modulus			
--	419000 psi	2890 MPa	ASTM D790
--	352000 psi	2430 MPa	ISO 178
Flexural Strength			
--	12000 psi	82.4 MPa	ASTM D790
--	10600 psi	73.0 MPa	ISO 178

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength	5.2 ft·lb/in <sup>2</sup>	11 kJ/m <sup>2</sup>	ISO 179
Notched Izod Impact	2.2 ft·lb/in	120 J/m	ASTM D256

Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness			
R-Scale	111	111	ASTM D785
R-Scale	110	110	ISO 2039-2

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			
66 psi (0.45 MPa), Unannealed	199 °F	93.0 °C	ASTM D648
66 psi (0.45 MPa), Unannealed	174 °F	79.0 °C	ISO 75-2/B

Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.0433 in (1.10 mm), ALL)	V-2	V-2	UL 94

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	167 to 185 °F	75.0 to 85.0 °C

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Time	2.0 to 5.0 hr	2.0 to 5.0 hr
Rear Temperature	356 to 446 °F	180 to 230 °C
Middle Temperature	356 to 446 °F	180 to 230 °C
Front Temperature	356 to 446 °F	180 to 230 °C
Mold Temperature	104 to 176 °F	40.0 to 80.0 °C