

PRIMEX PLASTICS CORPORATION

A subsidiary of ICC Industries Inc.



Prime ABS Weather-X 200 is an acrylic capped co-extruded ABS sheet, which can be produced as a two or three multilayer composite. The acrylic cap imparts a very high gloss, vibrant colors with superior depth of image, excellent UV protection, chemical resistance, toughness and excellent formability.



Prime ABS Weather-X 200

Prime ABS Weather-X 200	High	Avg.
Impact Strength	*	
Low Temperature Impact Strength		*
Tensile Strength	*	
Flexural Modulus	*	
Heat Deflection Temperature	*	

Property	Test Method	Value	Unit
Specific Gravity	D-792	1.05	g/cc
Melt Flow	D-1238	8.9	g/10min
Gloss, 60° Angle	D-523	87	%
Ultimate Tensile	D-638	5,220	psi
Ultimate Elongation	D-638	22	%
Flexural Modulus	D-790	280,000	psi
Impact Strength, notched Izod .125" @ 72°F	D-256	5.6	ft-lb/in
Impact Strength, notched Izod .125" @ 32°F	D-785	4.4	Ft-lb/in
HDT .125" @ 264 psi, (annealed)	D-648	208	°F
Mold Shrinkage	D-955	.003-.005	In/in

Applications:

The performance features of Prime ABS Weather-X 200 make it The material of choice for applications, including marine, personal watercraft, recreational vehicles, lawn/garden, building/construction and automotive accessories.

Finishing:

Prime ABS Weather-X 200 can be joined using mechanical methods such as bolts, screws or clamps, or chemical methods such as cementing. When drilling co-extruded sheet with an acrylic modified drill bit, be sure to exit from the acrylic side but when drilling with a standard bit, be sure to have the bit exit from the substrate side. For accuracy and safety, Prime ABS Weather-X 200 should be clamped during drilling.

Processing:

Surface Temp = 325-360°F

Mold Temp = 150-175°F

De-mold @ 170°F

Mold shrink is .004-.008 in/in.

ABS may absorb greater amounts of radiant energy than acrylic; thus, surface temperatures may increase more rapidly. Care should be taken to maintain the surface temperature at 325°F-360°F to avoid blistering, burning and color/gloss shift of the acrylic cap.

Colors, Textures and Capabilities:

Prime ABS Weather-X 200 can be color matched to meet your specific requirements. The surface is typically high gloss but textures such as calf grain, H/C, F/L H/C, Levant I and Seville are available.