

Technical Data Sheet



ALTECH ABS A 1000/667

Base Polymer	Acrylonitrile/Butadiene/Styrene/Copolymer
Colour	black
Special Features	improved surface,low gloss,heat stabilised
Market Segment	Automotive
Application Area	injection moulded parts,clothing / fasteners

Pre-Drying Conditions	80 °C in a dry air (dessiccant) dryer for 2-4 h 80 °C in an air circulating dryer for 3-6 h dependant on moisture content max. moisture content <0,20 %
-----------------------	--

Processing Injection Moulding	melt temperature 200-240 °C mould temperature 50-80 °C
-------------------------------	---

Storage	dry, protected from light
---------	---------------------------

Properties	Value	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	2300	MPa	ISO 178
Flexural Stress (3.5% Strain)	63	MPa	ISO 178
Tensile Modulus	2100	MPa	ISO 527
Tensile Stress at Yield	43	MPa	ISO 527
Tensile Elongation at Yield	2.7	%	ISO 527
Tensile Elongation at Break	20	%	ISO 527
Impact Strength (Charpy, 23°C)	150	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	80	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	14	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	8.5	kJ/m ²	ISO 179/1eA
Ball Indentation Hardness H358/30	92	MPa	ISO 2039-1
Thermal Properties			
Vicat B50	100	°C	ISO 306
HDT / A (1,8 MPa)	82	°C	ISO 75-1/-2
Rheological Properties			
Melt Index (MVR)	12	cm ³ /10min	ISO 1133
MVR temperature	220	°C	-
MVR load	10	kg	-
Shrinkage (24h)	0.4 - 0.7	%	ISO 294-4
Physical Properties			
Density	1050	kg/m ³	ISO 1183