

DUROMER

DURALAC A65ABK804

DESCRIPTION

Duralac A65ABK804 is a flame retarded ABS injection moulding compound coloured black.

PROCESSING CONDITIONS

TEMPERATURES

| | |
|-------------------|--------------|
| Drying | 82°C 2 hours |
| Rear zone | 180 – 200°C |
| Middle zone | 190 – 210°C |
| Front zone | 190 – 220°C |
| Melt temperature | 190 – 230°C |
| Mould temperature | 40 – 70°C |

PRESSURES

| | |
|--------------------|---------------|
| Injection pressure | 70 – 100 MPa |
| Hold pressure | 35 – 70 MPa |
| Back pressure | 0.3 – 0.7 MPa |

SPEEDS

| | |
|-------------|--------------|
| Fill speed | 25 – 50 mm/s |
| Screw speed | 60 – 90 RPM |

DRYING

80°C for 2-3 hours.

* Do not leave this material in the barrel for extended periods.

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TYPICAL PROPERTIES

| | DAM | Test Method |
|--|------|-------------|
| MECHANICAL | | |
| Tensile Strength, Yield MPa | 39 | ISO-527 |
| Flexural Strength, MPa | 48 | ISO-178 |
| Flexural Modulus, MPa | 2000 | ISO-178 |
| Charpy Impact, notched kJ/m ² | 8.50 | ISO-179 |
| Specific Gravity | 1.17 | D-792 |
| THERMAL | | |
| Flammability* UL94 2.2mm | V-0 | UL94 |

These values are for natural colour resins only. The data listed here fall within the normal range of product properties, but they should not be used to establish specification limits nor used alone as the basis of design.

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