

# 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
<b>MECHANICAL</b>		
Tensile Strength, Yield MPa	39	ISO-527
Flexural Strength, MPa	48	ISO-178
Flexural Modulus, MPa	2000	ISO-178
Charpy Impact, notched kJ/m <sup>2</sup>	8.50	ISO-179
Specific Gravity	1.17	D-792
<b>THERMAL</b>		
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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