

## Faralloy ABS105C (9320362)

Flame-retardant (UL 94 V-0) ABS compound for injection molding and extrusion applications.

### Preliminary Material Properties

<b>Typical Properties (1 )</b>			
<b>MECHANICAL</b>	<b>Value</b>	<b>Unit</b>	<b>Method</b>
Tensile Stress, break (2.0 in./min.)	5,770	psi	ASTM D638
Tensile Stress, yield (2.0 in./min.)	4,290	psi	ASTM D638
Elongation at break (2.0 in./min.)	25	%	ASTM D638
Flexural Modulus (0.05 in./min., 2 in. span)	316,000 min	psi	ASTM D790
Flexural Strength (0.05 in./min., 2 in. span)	9,100	psi	ASTM D790
<b>IMPACT</b>	<b>Value</b>	<b>Unit</b>	<b>Method</b>
Izod Impact, notched 73°F	4.0	ft-lb/in.	ASTM D256
Unnotched Izod, 73°F	29	ft-lb/in.	ASTM D256
<b>THERMAL</b>	<b>Value</b>	<b>Unit</b>	<b>Method</b>
HDT, 264 psi, unannealed	168	°F	ASTM D648
HDT, 66 psi, unannealed	190	°F	ASTM D648
<b>PHYSICAL/RHEOLOGICAL</b>	<b>Value</b>	<b>Unit</b>	<b>Method</b>
Specific Gravity	1.22	-	ASTM D792
Melt Flow Rate, 230°C, 3.80kgf	3.0	g/10 min.	ASTM D1238
<b>FLAMMABILITY (3 )</b>	<b>Value</b>	<b>Unit</b>	<b>Method</b>
UL-94 @ .0625"	V-0	N/A	UL-94

## Processing Data

Processing Parameter		
<b>INJECTION MOLDING</b>	<b>Value</b>	<b>Unit</b>
Drying Temperature	160	°F
Drying Time	Not usually required	Hrs
Melt Temperature	380-420	°F
Rear- Zone 1 Temperature	350-380	°F
Middle-Zone 2 Temperature	360-390	°F
Front- Zone 3 Temperature	370-400	°F
Nozzle Temperature	375-410	°F
Mold Temperature	90-120	°F
Backpressure	15-50	Psi
Screw Speed	50-80	rpm
Shot to Cylinder Size	50-80	%
<b>EXTRUSION</b>	<b>Value</b>	<b>Unit</b>
Drying Temperature	160	°F
Drying Time	2-4	Hrs
Melt Temperature	340-380	°F
Rear Zone 1 Temperature	340 – 360	°F
Middle Zone 2 Temperature	360 – 380	°F
Front Zone 3 Temperature	380 – 400	°F
Clamp		°F
Head		°F
Die		°F

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### THESE VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES

- (1) Typical values only. Variations within normal tolerances are possible for various colors.
- (2) Only typical data for selection purposes. Not to be used for part or tool design.
- (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

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