

TECHNICAL DATA SHEET

Shuman Compound:

ABS Flame Retardant SP791 Black and Custom Colors

Offers this combination of properties:

UL recognized, LTHA, Excellent flame retardancy, Good impact strength, Good chemical resistance, Self-extinguishing

TYPICAL PROPERTIES

MECHANICAL PROPERTIES

	<u>VALUE</u>	<u>UNITS</u>	<u>TEST METHODS</u>
Izod Impact Strength (Notched, 1/8" Thick Specimen)	4.0 (+/- 0.5)	FT-LBS/IN	ASTM D-256
Rockwell Hardness	105	R	ASTM D-785
Tensile Strength at Yield	6500	PSI	ASTM D-638

THERMAL PROPERTIES

Coefficient of Linear Thermal Expansion	9.3 x 10-5in/in	deg. C	ASTM D-696
Hot Wire Ignition (HWI) 0.101" Thick Specimen	33.4	SEC. TO IGNITE	UL 746A
High Current Arc Ignition (HAI) 0.100" Thick Specimen	199.4	ARCS	UL 746A
High Voltage Arc Tracking (HVTR) 0.100" Thick Specimen	5.873	IN./MIN	UL 746A
Comparative Track Index (CTI) 0.100" Thick Specimen	250	VOLTS	UL 746A

RELATIVE THERMAL

Electrical	80	deg. C	UL 746B
Mechanical with Impact	70	deg. C	UL 746B
Mechanical without Impact	80	deg. C	UL 746B

FLAME RETARDANT PROPERTIES

Flame Class Rating 0.100" (2.54 mm) Thick Specimen	V1		UL 94
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OTHER PROPERTIES

Specific Gravity	1.2		ASTM D-792
Melt Flow Rate	4 (+/-2)	GM/10 MIN.	ASTM D-1238

SUGGESTED PROCESSING CONDITIONS

DRYING CONDITIONS:

	<u>TEMPERATURE (deg. F)</u>		<u>TIME (HOURS)</u>	
	<u>MIN.</u>	<u>MAX.</u>	<u>MIN.</u>	<u>MAX.</u>
Dehumidifying Dryer	190	200	2	24
Tray Dryer	NOTE: Depth of granules in tray dryer should not exceed 1½ in. (38.1 mm)		4	24

TEMPERATURE CONDITIONS:

INJECTION:	400 - 440F
EXTRUSION:	350 - 420F

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