

PROCESSING GUIDE

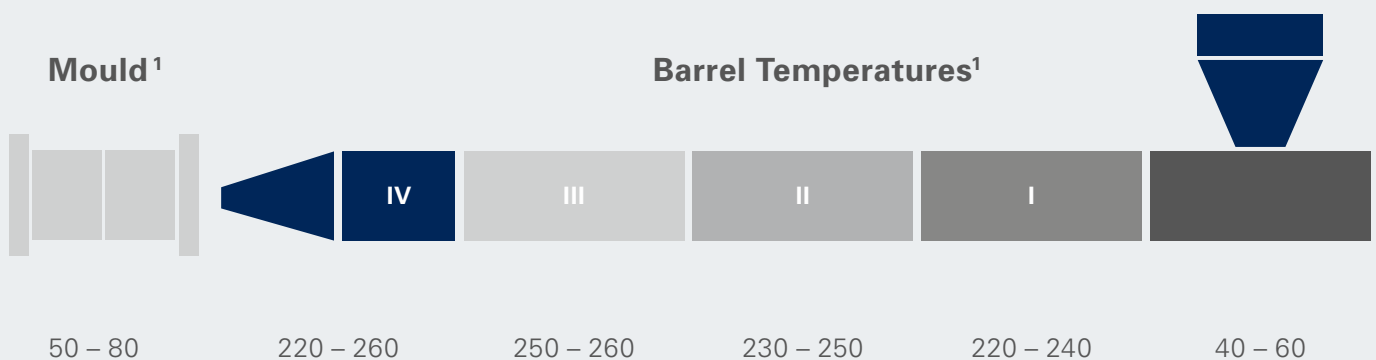
ALTECH[®] ABS is an amorphous thermoplastic, unfilled or reinforced with glass fibre.

PRE-TREATMENT

ALTECH[®] ABS is a hygroscopic polymer. Due to external conditions, such as climate or storage, humidity may be absorbed and then pre-drying is recommended in order to avoid surface defects. For specific filled products see corresponding Technical Data Sheet.

PROCESSING

ALTECH[®] ABS may be processed on all standard injection moulding machines.



Temperatures in degrees Celsius (°C)

¹ Guide values. Standard starting profile might be in the middle, for filled or high heat ABS a rather higher, for standard ABS a rather lower temperature profile.

		Unit	Notes
Properties			
Polymer abbreviation		ABS	
Density (ISO 1183)	g/cm ³	1.02 – 1.3 (see Technical Data Sheet)	
Injection Machinery			
Screw stroke	Metering stroke between 1 x D and 3 x D		
Screw type	Three zone screw with L/D ratio 18:1 to 22:1		
Nozzle type	Open or shut-off possible		
Hopper type	Standard		
Pre-processing			
Storage	Dry, protected from heat and light		
Dryer type		Air circulating	Dry air
Drying time	h	3 – 6	2 – 4
Drying temperature	°C	80	
Permissible moisture content	%	< 0.2	
Processing Conditions			
Melt temperature range	°C	220 – 260	
Mould temperature range	°C	50 – 80	
Coolant	Water		
Throughput coolant	To ensure turbulent flow		
Peripheral screw speed	mm/s	50 – 300, e.g. screw speed of 35rpm with a screw diameter of 50 mm	
Back pressure (specific)	bar	50 – 100	
Residence time	min	4 – 8	
Injection speed	Profile for constant flow front speed		
Shrinkage²			
		ABS Unfilled	ABS + Glass fibre
Shrinkage range (ISO 294-4)	%	0.3 – 0.7	0.2 – 0.4

² Shrinkage is influenced by the part geometry, the wall thickness of the moulding, the position and size of the gate and the processing parameters.

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