

PROCESSING GUIDE

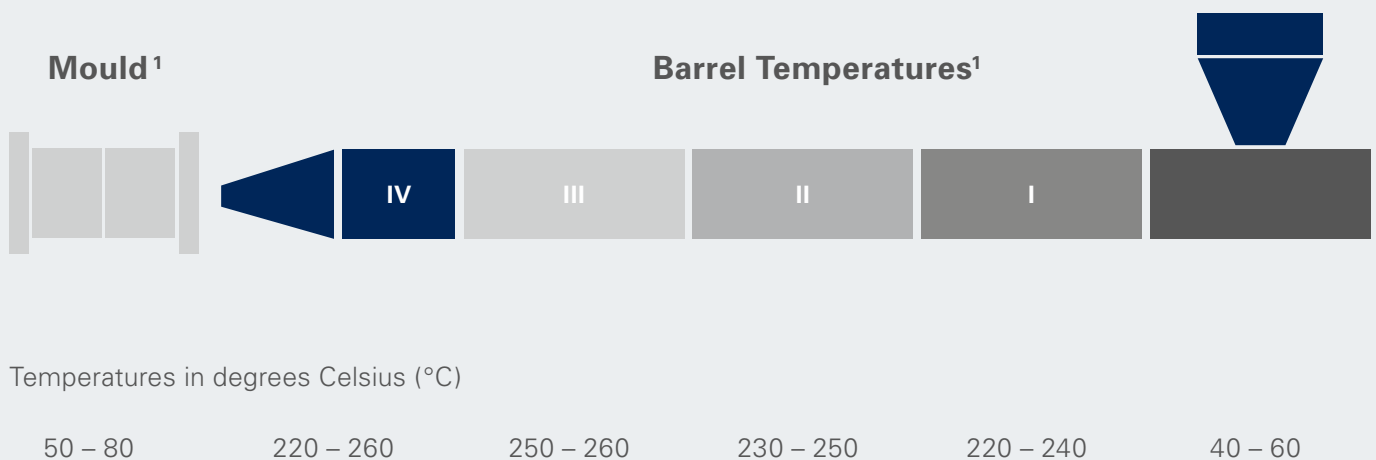
ALCOM[®] LB (AWL) ABS is an Acrylonitrile Butadiene Styrene, an amorphous thermoplastic, filled with special additives for an optimal light blocking and light reflecting.

PRE-TREATMENT

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

PROCESSING

ALCOM[®] LB 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 higher density products a rather higher temperature profile.

		Unit	Notes
Properties			
Polymer abbreviation		ABS	
Density (ISO 1183)	g/cm ³	1.10 – 1.36 (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	minutes	4 – 8	
Injection speed		Profile for constant flow front speed	
Shrinkage²			
		ABS LB	ABS LB + Glass fibre
Shrinkage range (ISO 294-4)	%	0.3 – 0.6	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.

HEAD OFFICE

ALBIS PLASTIC GmbH
 Mühlentzen 35 · 20539 Hamburg
 Telephone: +49 40 7 81 05-0
 Fax: +49 40 7 81 05-361
 info@albis.com · www.albis.com

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