



MARPOL ABS EX4 Ethylene Vinyl Acetate

PRODUCT DATA SHEET

General

- Availability
- Global
- Processing Method
- Extrusion Molding
- Description
- Sheet extrusion grade ABS

| Physical | Nominal Value | Test Method |
|--------------------------|------------------------|-------------|
| Density/Specific Gravity | 1.03 g/cm ³ | ASTM D792 |
| Melt Mass-Flow Rate | 4 g/10 min | ASTM D1238 |
| Mechanical | Nominal Value | Test Method |
| Tensile Modulus | 2030 MPa | ASTM D638 |
| Tensile Stress | | ASTM D638 |
| Yield | 39 MPa | |
| Break | 28 MPa | |
| Tensile Elongation | | ASTM D638 |
| Yield | 3.1% | |
| Break | 31.6% | |
| Flexural Modulus | 2100 MPa | ASTM D790 |
| Flexural Strength | 63 MPa | ASTM D790 |
| Impact | Nominal Value | Test Method |
| Notched Izod Impact | 411 J/m | ASTM D256 |
| Dart Impact | 33 J | ASTM D3763 |

These suggestions and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee as conditions and methods of use are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.





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| Thermal | Nominal Value | Test Method |
|-----------------------------------|-----------------|-------------|
| Deflection Temperature Under Load | | D648 |
| .45 MPa, Unannealed, 3.2 mm | 93 C | ASTM D256 |
| 1.8 MPa, Unannealed, 3.2 mm | 80 C | ASTM D3763 |
| Vicat Softening Temperature | 106 C | ASTM D1525 |
| CLTE | | |
| Flow: -40 to 40 C | 1.01E-4 cm/cm/C | |
| Transverse: -40 to 40 C | 1.04E-4 cm/cm/C | |
| RTi | 60 C | UL 746 |

Flammability

Flame Rating (1.5mm) HB UL 94

| Sheet Extrusion | Nominal Value |
|------------------------|---------------|
| Drying Temperature | 80 to 95 C |
| Drying Time | 4 hours |
| Suggested Max Moisture | 0.02% |
| Barrel- Zone 1 Temp | 170 - 200 C |
| Barrel- Zone 2 Temp | 180 - 220 C |
| Barrel- Zone 3 Temp | 190 - 225 C |
| Barrel- Zone 4 Temp | 200 - 250 C |
| Adapter Temp | 205 - 250 C |

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| Sheet Extrusion | Nominal Value |
|-------------------------|---------------|
| Die Temp | 205 - 250 C |
| Roll Stack Temp- Top | 90 -95 C |
| Roll Stack Temp- Middle | 95 - 105 C |
| Roll Stack Temp- Bottom | 100 - 105 C |

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MARCO POLO
INTERNATIONAL, INC.
Worldwide Distributors of Plastic Resins

532 Broadhollow Road Suite 135 Melville, NY 11747 Tel: 631-629-4520 Fax: 631-629-4519