



MARPOL
ABS GP18
 Ethylene Vinyl Acetate



PRODUCT DATA SHEET

General

- Availability
- Processing Method
- Description
- Global
- Injection Molding
- General purpose injection molding ABS

Physical	Nominal Value	Test Method
Density/Specific Gravity	1.04 g/cm ³	ASTM D792
Melt Mass-Flow Rate	5.6 g/10 min	ASTM D1238
Melt Volume-Flow Rate	18 cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Test Method
Tensile Modulus	2130 MPa	ASTM D638
Tensile Stress		ASTM D638
Yield	40 MPa	
Break	31 MPa	
Tensile Elongation		ASTM D638
Yield	2%	
Break	20%	
Flexural Modulus	2200 MPa	ASTM D790
Flexural Strength	68 MPa	ASTM D790
Impact	Nominal Value	Test Method
Notched Izod Impact	290 J/m	ASTM D256
Dart Impact	30 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.



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



MARPOL
ABS GP18
 Ethylene Vinyl Acetate



PRODUCT DATA SHEET

Thermal	Nominal Value	Test Method
Deflection Temperature Under Load		D648
.45 MPa, Unannealed, 3.2 mm	96 C	ASTM D256
1.8 MPa, Unannealed, 3.2 mm	82 C	ASTM D3763
Vicat Softening Temperature	98 C	ASTM D1525
CLTE		
Flow: -40 to 40 C	8.85E-5 cm/cm/C	
Transverse: -40 to 40 C	8.85E-5 cm/cm/C	
RTi	60 C	UL 746

Flammability

Flame Rating (1.5mm)	HB	UL 94
----------------------	----	-------

Injection Processing	Nominal Value
Drying Temperature	80 to 95 C
Drying Time	2 to 4 hours
Suggested Max Moisture	0.10%
Suggested Shot Size	50 to 70%
Rear Temperature	190 to 210 C
Middle Temperature	205 to 225 C
Front Temperature	215 to 240 C
Nozzle Temperature	220 to 260 C

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.



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



MARPOL
ABS GP18
Ethylene Vinyl Acetate



PRODUCT DATA SHEET

Injection Processing	Nominal Value
Processing (melt) Temperature	220 to 260 C
Mold Temperature	50 to 70 C
Back Pressure	.3 to .7 MPa
Screw Speed	30 to 60 rpm
Vent Depth	.038 to .051 mm

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.



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