



MARPOL
ABS HF35
 Ethylene Vinyl Acetate



PRODUCT DATA SHEET

General

- Availability
- Processing Method
- Description
- Global
- Injection Molding
- High flow general purpose ABS

Physical	Nominal Value	Test Method
Density/Specific Gravity	1.04 g/cm ³	ASTM D792
Melt Mass-Flow Rate	35 g/10 min	ASTM D1238
Mechanical	Nominal Value	Test Method
Tensile Modulus	2480 MPa	ASTM D638
Tensile Stress		ASTM D638
Yield	46 MPa	
Break	35 MPa	
Tensile Elongation		ASTM D638
Yield	2%	
Break	18%	
Flexural Modulus	2620 MPa	ASTM D790
Flexural Strength	79 MPa	ASTM D790
Impact	Nominal Value	Test Method
Notched Izod Impact	240 J/m	ASTM D256
Dart Impact	21 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



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Thermal	Nominal Value	Test Method
Deflection Temperature Under Load		D648
.45 MPa, Unannealed, 3.2 mm	95 C	ASTM D256
1.8 MPa, Unannealed, 3.2 mm	82 C	ASTM D3763
Vicat Softening Temperature	99 C	ASTM D1525
CLTE		
Flow: -40 to 40 C	8.8E-5 cm/cm/C	
Transverse: -40 to 40 C	8.55E-5 cm/cm/C	
RTi	60 C	UL 746

Flammability

Flame Rating (1.5mm)	HB	UL 94
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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 200 C
Middle Temperature	200 to 210 C
Front Temperature	205 to 225 C
Nozzle Temperature	205 to 245 C

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Injection Processing

Nominal Value

Processing (melt) Temperature

205 to 245 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

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