



MARPOL
ABS HI15
 Ethylene Vinyl Acetate



PRODUCT DATA SHEET

General

- Availability
- Processing Method
- Description
- Global
- Injection Molding
- High Impact ABS

Physical	Nominal Value	Test Method
Density/Specific Gravity	1.04 g/cm ³	ASTM D792
Melt Mass-Flow Rate	3.7 g/10 min	ASTM D1238
Melt Volume-Flow Rate	15 cm ³ /10min	ISO 1133

Mechanical	Nominal Value	Test Method
Tensile Modulus	2100 MPa	ASTM D638
Tensile Stress		ASTM D638
Yield	41 MPa	
Break	31 MPa	
Tensile Elongation		ASTM D638
Yield	2%	
Break	26%	
Flexural Modulus	2200 MPa	ASTM D790
Flexural Strength	68 MPa	ASTM D790

Impact	Nominal Value	Test Method
Notched Izod Impact	347 J/m	ASTM D256
Dart Impact	31 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	97 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	8.82E-5 cm/cm/C	
Transverse: -40 to 40 C	8.64E-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

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MARCO POLO
 INTERNATIONAL, INC.
 Worldwide Distributors of Plastic Resins

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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

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