

ISOTER® – ABS

Structure	Amorphous
Density	1.04 g/cm ³ (unfilled)
General properties	Hard, tenacious down to –40°C. Resistant to temperature variations. Low hygroscopicity. Low chemical resistance.
Barrel temperature	(decrease 15°C for flame retardant grades)
Feed zone:	40 – 60 °C
Zone 1:	160 – 180 °C
Zone 2:	180 – 230 °C
Zone 3:	210 – 250 °C
Zone 4:	210 – 250 °C
Zone 5:	210 – 250 °C
Nozzle:	210 – 250 °C
Melt temperature	220 – 250 °C
Mould temperature	40 – 80 °C
Injection temperature	1000 – 1500 bar
Post-pressure	Between 30 and 60% of injection pressure, low post-pressure time
Counterpressure	50 – 150 bar
Injection speed	Suggested profile: medium-high.
Screw speed	Equal to peripheric speed of 0.6 m/s
Metering	0.5 – 4.0 diameters
Cushion	2 – 8 mm, depends on metering and screw diameter
Drying	3 hours at 80°C
Recycle	Maximum 30% of regrinded material. This percentage decreases for technical and aesthetic parts.
Shrinkage	0.4 – 0.7% (for unfilled product)
Barrel equipment	Standard screw, non-return valve, free-flow nozzle
Quenching	Not necessary to purge with other materials. Purge with natural product suggested after flame retardant processing.