

Properties

VF790D

Flame-retardant ABS resin

Heat resistance

Properties	Test methods	Test conditions	Units	
Melt mass-flow rate	ISO 1133	220 deg C/10kg	g/10min	26
Mold shrinkage	Daicel method	-	%	0.4-0.6
Tensile strength	ISO 527	-	MPa	50
Flexural strength	ISO 178	-	MPa	80
Flexural modulus	ISO 178	-	MPa	2500
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	13
Deflection temperature under load	ISO 75	1.80MPa	deg C	78
Flammability	UL94	-	-	V-2/1.7mm
Density	ISO 1183	-	g/cm3	1.09

Note

- Test methods such as ISO standards are fully or almost compliant with the standards.
- Values are typical, not quality assured.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
3-4hrs 70-80deg C	195-205	195-205	185-195	170-180	40-60	5-15	40-60