

ELIX 118HF

Very high flow ABS, high gloss surface with antistatic additive

Major Benefits

Very high flow ABS material. Excellent balance of impact strength and flowability. High gloss surface finish. Used as base resin for improved flowability Housing big parts. Thin-walled parts

Chemical composition

Acrylonitrile-Butadiene-Styrene Copolymer

Physical Form

Pellets

Typical properties*

Property	Test Condition	Standard	Unit	Value
			US Conventional	
Rheological properties				
Melt volume-flow rate	220 °C; 10 kg	ISO 1133	cm³/(10 min)	57
Melt flow rate	230 °C; 3,8 kg	ASTM D1238	g/10min	15
Molding shrinkage, normal	60x60x2 mm	ISO 294-4	%	0.5-0.7
Molding shrinkage, parallel	60x60x2 mm	ISO 294-4	%	0.5-0.7
Mechanical properties (23 °C/50 % r. h.)				
Yield stress	50 mm/min	ISO 527-1,-2	MPa	42
	5 mm/min	ASTM D 638	MPa	39
Tensile modulus	1 mm/min	ISO 527-1,-2	MPa	2300
	5 mm/min	ASTM D 638	psi	333500
Yield strain	50 mm/min	ISO 527-1,-2	%	3
Flexural strength	2 mm/min	ISO 178	MPa	66
Flexural modulus	2 mm/min	ISO 178	MPa	2350
	1,3 mm/min	ASTM D 790	psi	341000
Izod notched impact strength	23 °C (73 °F)	ISO 180-1A	kJ/m²	14
	-30 °C (-22 °F)	ISO 180-1A	kJ/m²	7
	73 °F (23 °C)	ASTM D 256 (6.4mm) 1/4"	J/m	135
	73 °F (23 °C)	ASTM D 256 (3.2mm) 1/8"	J/m	180
	-22 °F (-30 °C)	ASTM D 256 (3.2mm) 1/8"	J/m	95
Charpy unnotched impact strength	23 °C (73 °F)	ISO 179-1eU	kJ/m²	81

Property	Test Condition	Standard	Unit	Value
	-30 °C (-22 °F)	ISO 179-1eU	kJ/m ²	60
Charpy notched impact strength	23 °C (73 °F)	ISO 179-1eA	kJ/m ²	14
	-30 °C (-22 °F)	ISO 179-1eA	kJ/m ²	7
Ball indentation hardness		ISO 2039-1	N/mm ²	92
Thermal properties				
Temperature of deflection under load (annealed 4h/80°C; 4h/176°F)	1.80 MPa	ISO 75-1,-2	°C	94
	0.45 MPa	ISO 75-1,-2	°C	98
Vicat softening temperature	50 N; 50 °C/h	ISO 306	°C	98
	50 N; 50 °C/h	ASTM D 1525	°F	208
Burning behavior UL 94 (1.6 mm)	1.6 mm	UL 94	Class	HB
Coefficient of linear thermal expansion, parallel	23 to 55 °C	ISO 11359-1,-2	10-4/K	0,9
Coefficient of linear thermal expansion, transverse	23 to 55 °C	ISO 11359-1,-2	10-4/K	0,9
Burning rate (US-FMVSS)	200x105x2 mm	ISO 3795	mm/min	<80
Glow wire test (GWFI)	2.0 mm	IEC 60695-2-12	°C	675
Other properties (23 °C)				
Density		ISO 1183	g/cm ³	1,03
Processing conditions for test specimens				
Injection molding-Melt temperature		ISO 294	°C	240
Injection molding-Mold temperature		ISO 294	°C	70
Injection molding-Injection velocity		ISO 294	mm/s	240

*Control measurements in other places may issue different results due to influences of machinery, equipment, test method or storage conditions.

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Test values

Unless specified to the contrary, the values given have been established on standardised test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the colouring.

Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

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