PRIMEX
PLASTICS CORPORATION
A Subsidiary of ICC Industries, Inc.

Prime ABS 105FR

Prime ABS 105FR

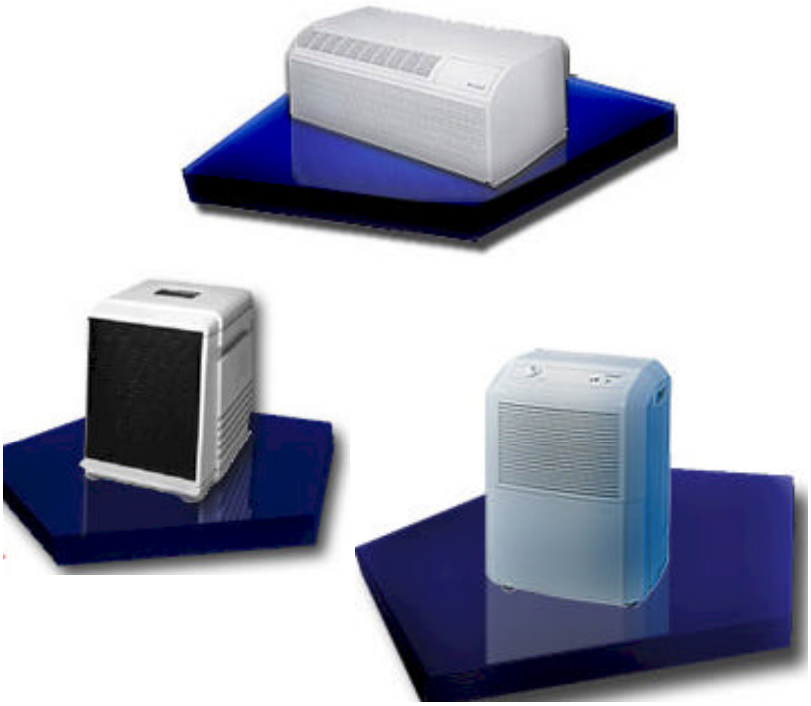
Is an ignition resistant ABS with excellent process stability, high practical toughness and heat distortion temperature.

Applications:

Prime ABS 105FR may be used for interior applications such as appliance parts, transportation and electronics.

Processing:

Prime ABS 105FR has excellent thermoforming characteristics. It is extremely versatile in nearly all thermoforming operations from high volume, multi-station rotary machines to single station and shuttle presses. Pressure forming techniques have also been highly successful. It can be formed on wood, epoxy, ceramic and/or aluminum tools. The forming temperature has a range of 300 - 350ºF. For best results the mold temperature should be 150-190ºF. In some cases it is necessary to dry the sheet before forming.



Prime ABS 105FR	High	Average
Impact Strength	*	
Low Temperature Impact Strength		*
Tensile Strength	*	
Flexural Modulus	*	
Heat Deflection Temperature	*	

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Finishing:

Prime ABS 105FR can be screwed, drilled, routed, punched and die-cut with conventional tooling. Parts made with Prime ABS 105FR may be joined with machine screws, bolts, nuts, rivets, and spring steel fasteners. Thread-cutting or thread-forming screws are an economical means for securing separate joints. Formed parts may be joined with Methylene Chloride if maximum impact strength is not required. Press and snap techniques and sonic welding may also be used for the bonding of Prime ABS 105FR.

Please contact your Primex Plastics representative for more information on finishing, fabricating, or the thermoforming process.

Colors, Textures and Capabilities:

Prime ABS 105FR can be color matched to meet your specific requirements. Prime ABS 105FR is available in thicknesses from .060 - .400. Textures include Calf Grain, HC, RM, Seville, Levant I, FL/HC and Diamond Plate.

Property	Test Method	Value	Unit
Specific Gravity	D-792	1.20	
Melt Flow	D-1238	54.6	g/10min
Gloss, 60º Angle	D-523	87	%
Elongation @ Yield	D-638	5	%
Tensile Modulus	D-638	144,000	psi
Tensile @ Yield	D-638	5,200	psi
Gardner Impact	D-5420	168	In-lbs
Flexural Modulus	D-790	329,000	psi
Notched Izod @ 73ºF	D-256	6.3	ft-lb/in
Notched Izod @ - 40ºF	D-256	2.2	ft-lb/in
Rockwell Hardness	D-785	102	R Scale
HDT @ 66psi, Un-annealed	D-648	198	ºF
HDT @ 264 psi, Un-annealed	D-648	183	ºF
Vicat Softening Point	D-1525	219	ºF

Property values above are based on .125” extruded sheet
Complies with UL 94-VO at thickness’ greater than .062”
Complies with UL 94-5VB at thickness’ greater than .062”

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