



# Prime ABS Weather-X ML200

## Prime ABS Weather-X ML200:

*Offering one of the highest aesthetics, gloss and depth of image in the industry, our Weather-X ML 200 may consist of 3-5 layers but is typically 3 consisting of clear acrylic, colored acrylic and ABS. Key properties are surface hardness, chemical resistance, weatherability, toughness and excellent formability.*



## Applications:

*Include; RV, automotive, transportation and marine industries.*

## Processing:

*Surface Temp = 325-350°F  
 Mold Temp = 150-175°F  
 De-mold @ 170°F  
 Mold shrink is .004-.008 in/in.  
 Oven heaters on gloss side should be somewhat lower than on the substrate side. The sheet must be fully saturated with heat before forming.*

Prime Weather-X ML200	High	Average
Impact Strength	*	
Low Temperature Impact Strength		*
Tensile Strength	*	
Flexural Modulus	*	
Heat Deflection Temperature	*	



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## Finishing:

*When drilling co-extruded sheet with an acrylic modified drill bit, be sure to exit from the acrylic side but when drilling with a standard bit, be sure to have the bit exit from the substrate side. For accuracy and safety, acrylic capped sheet should be clamped during drilling. For cutting/trimming Weather-X ML 200 sheet with CNC or air routers, a standard solid carbide fiberglass router – diamond-cut tool can be used. Routing parts in a CNC environment is best done with chip-breaker-type, solid carbide tools.*

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

## Colors, Textures and Capabilities:

*The surface is typically high gloss. Colors include Solids, Granite, Pearlescent, Swirl, Metallics, Soft White and Metamerism effects.*

Property	Test Method	Value	Unit
Specific Gravity	D-792	1.06	
Gloss, 60° Angle	D-523	85	%
Tensile @ Yield	D-638	5,900	psi
Flexural Strength	D-790	9,500	psi
Flexural Modulus	D-790	300,000	psi
Notched Izod	D-256	4.2	ft-lb/in
Rockwell Hardness	D-785	102	R Scale
HDT @ 264 psi	D-648	190	°F

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