



# Prime ABS Weather-X ML500

## Prime ABS

### Weather-X ML500:

*A multi-layer sheet structure of up to 5 layers but is typically 3 consisting of Acrylic, ASA and ABS. An acrylic clear coat finish provides a hard, stain resistant surface that has excellent gloss, depth of image, chemical resistance and surface hardness. This layering technique provides superior UV protection, color stability and ease of formability.*

### Applications:

*Includes agriculture, spa, automotive, transportation and marine industry applications.*

### Processing:

*Surface Temp = 325-350°F, Mold Temp = 150 - 175°F, De-mold @ 170°F and 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 ML500	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/profile 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 ML500 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. The colors are Solids, Granite, Pearlescent, Swirl, Metallics, Soft White and Metamerism Effects.*

Property	Test Method	Value	Unit
Specific Gravity	D-792	1.06	g/cc
Gloss, 60° Angle	D-523	90	%
Tensile @ Yield	D-638	5,800	psi
Flexural Strength	D-790	10,600	psi
Flexural Modulus	D-790	350,000	psi
Notched Izod	D-256	3.6	ft-lb/in
Rockwell Hardness	D-785	102	R Scale
HDT @ 264 psi	D-648	198	° F

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