



novalca

NOVAKRAL® ABS FV10

**ABS compound,
glass reinforced grade**

FV10: 10% glass fiber reinforced grade.

Color: available in standard natural and black. Available on demand in grey and special colors - For injection molding parts with improved stiffness

RECOMMENDED PROCESSING PARAMETERS FOR INJECTION MOLDING		
DRYING CONDITIONS	BARREL TEMPERATURE	MOULD TEMPERATURE
80 °C x 3 ÷ 4 hours Recommended moisture level after drying ≤0.05%	220 ÷ 260 °C	50 ÷ 80 °C
PACKAGING		
25 Kg Bags, 1000 Kg Octabins, 750 Kg Boxes		
SHRINKAGE: Shrinkage is affected by the geometry and the wall thickness of the molded part by the position and size of the gate and by the processing parameters. In addition, glass-fiber reinforced products show a significant difference in the shrinkage perpendicular and parallel to the flow direction. For this reason it's difficult to predict it, the value in the table is indicative.		
PACKAGING		
25 Kg Bags, 1000 Kg Octabins, 750 Kg Boxes		

PROPERTIES	METHOD		UNIT	TYPICAL VALUES
PHYSICAL				
Density	ASTM D792	ISO 1183	gr/cm ³	1.12
Melt Flow Index MFI (220 °C - 10 Kg)	ASTM D1238	ISO 1133	g/10'	5
Humidity Absorption – (Equilibrium value, in air, 23°C, 50% RH)	INTERNAL METHOD		%	0.25
Mould Shrinkage	INTERNAL METHOD		%	0.2 ÷ 0.5
Reinforcing filler	INTERNAL METHOD		%	10
MECHANICAL				
Tensile strength: stress at yield	ASTM D638	ISO 527-1,-2	MPa	55
strain at break	ASTM D638	ISO 527-1,-2	%	2.5
Flexural modulus	ASTM D790	ISO 178	MPa	3900
IZOD notched impact strength, at 23 °C Specimen dimensions 62.5 mm x 12.7 mm x 3.2 mm	ASTM D256	-	J/m	60
THERMAL				
VICAT softening temperature at 49 N-120 °C/h	ASTM D1525/B	ISO 306/B	°C	102
ELECTRICAL				
Surface resistivity	ASTM D257	IEC 60093	Ohm	1E14
Dielectric strenght	ASTM D149	IEC 60243-1	KV/mm	32
Dielectric constant at 10 ⁶ Hz	ASTM D150	IEC 60250	-	3.1
Dissipation factor -10 ⁶ Hz	ASTM D150	IEC 60250	-	0.01
Comparative tracking index (solution A, CTI)	VDE 0303-P1	IEC 60112	V	550
FLAMMABILITY				
Flammability UL94 (thickness 3.2 mm)	UL 94		Class	HB
Flammability UL94 (thickness 1.6 mm)	UL 94		Class	HB
Burning rate FMVSS302 (thickness 2.2/ 3.2 mm)	ISO 3795		mm/min	Passed

Our technical data are provided for guidance purpose only for natural color compound and are based on average values. The data are not meant to be used for specification or warranted purposes. Values may be affected by the design of the mold/die, the processing conditions and coloring/pigmentation of the product. Unless specified to the contrary, the data have been established on standardized test specimens at room temperature. All technical information is subject to continuous update, so the customer shall always ensure that the latest release of technical information is at his own disposal. It is the customer's responsibility to inspect and test our products in order to determine to his own satisfaction whether they are suitable for his intended uses and applications or used in conjunction with third-party materials. Unless specifically stated with reference to the specific color code, the products mentioned herein are not suitable for applications in the pharmaceutical, medical, dental and toys sectors, in contact with foodstuff or for potable water transportation.

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