

General

ROTEC® ABS can generally be processed using all techniques convenient for thermoplastic resins. In particular they can be easily extruded on different extrusion lines.

Due to the balanced processing properties and their excellent thermal stability, the production of profiles and extrusion sheets can be expected without any problems.

Storage

ROTEC® ABS should be stored dry in closed rooms and protected from direct sun light. When stored on open areas, the package may be damaged thereby the physical and optical properties may be affected.

Drying

ROTEC® ABS leaves the production facility with a residual moisture content level of < 0.2 %. This value is controlled using the moisture analyzer (Aquatrac). We recommend to dry the material up to a moisture content < 0.05 %.

Under adverse transport and storage conditions all ROTEK® ABS can absorb moisture so that surface defects such as streaks can appear. Before processing we strongly recommend to pre-dry ROTEK® ABS for 2 – 4 hours at a temperature of 80 °C (± 5 °C) in a dry air dryer. These dry the materials with high reliability even at high outside humidity.

To exclude temperature-dependent color changes in case of bright colors it is recommended to limit the pre-drying time up to 2 h.

The above processing guidelines should advise without commitment. The statements given are based on our experience and are correct to the best of the knowledge at the time of printing, but the actual applications and processes are beyond our sphere of influence. No liability should be assumed as a result of this information.

Processing

The processing conditions should be selected depending on the extrusion machine and the size or shape of the finished parts. Following conditions are recommended for processing:

ROTEC® ABS	Standard	Flame retardant (antistatic)
Drying temperature	80 ± 5 °C	80 ± 5 °C
Drying time	2 – 4 h	2 – 4 h
Barrel temperature*	210 – 250 °C	190 – 210 °C
Melt temperature	< 260 °C	< 230 °C

* a rising temperature profile is preferred

The above mentioned processing parameters are only approximants and depend on the machine used. It should be considered that flame retardant material is shear and temperature sensitive.

Recycling

Previous tests before recycling of rejected parts from ROTEC® ABS are recommended. It should be considered that the regrind is free of dust. Due to reprocessing conditions the small dust particles from grinding process can burn, thus can influence the technical and optical values and lead to "black specs".

For special requirements in the finished parts, only original material should be used.

The use of regrind from **flame retardant** materials is not recommended; it can be reused only to a limited content as regrind. Therefore, previous tests are necessary.

The above processing guidelines should advise without commitment. The statements given are based on our experience and are correct to the best of the knowledge at the time of printing, but the actual applications and processes are beyond our sphere of influence. No liability should be assumed as a result of this information.