



PRODUCT INFORMATION

TARODUR 100 X0 HF

ABS self extinguishing UL94 V0, high flow.

ISO short Form ISO 1043: ABS-FR(17)
UL file Pellets
E143048

Key Features

- High flow

Compliance

- UL94 V0 approved at 1,60 mm. UL746 B approved.

Process

- INJECTION MOULDING

Application

- Electrical

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	10E15		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>400	IEC 60112	
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,19	23°C	
Water Absorption (24h / +23°C)	ISO 62	%	0,3	23°C	
Water Absorption at Saturation	ISO 62	%	0,7	23°C	
Mould Shrinkage (Parallel)	Internal method	%	0,5-0,7	23°C - 3,2 mm	
Mould Shrinkage (Normal)	Internal method	%	0,5-0,7	23°C - 3,2 mm	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	50	220°C - 10 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	2300	+23°C / Speed 1 mm/min	
Elongation at Yield	ISO 527-1,2	%	5	+23°C / Speed 50 mm/min	
Tensile Yield Strength	ISO 527-1,2	MPa	45	+23°C / Speed 50 mm/min	
IZOD Notched Impact (+23°C)	ASTM D256	J/m	220		
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	21		

The listed data are in the normal range of product properties, they should not be used to establish specification nor as the basis of design.

Unless specified to the contrary, the given values have been established on standardized test specimens at room temperature. These values are for natural colour only. The figures should be regarded as guide values only and not as binding minimum values. Please note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions, pigments and any other additives.

All information, recommendation or technical advice provided by TARO PLAST S.p.A. are given in good faith but without warranty, to the best of its knowledge and based on current procedures in effect. Our advice does not release you from the obligation to check its validity and to test our products as to their suitability for the intended processes and uses. The application, use and processing methods and conditions of our products and the products manufactured by you on the basis of our technical advice are beyond our control and, therefore, entirely under your own responsibility.

PRODUCT INFORMATION

TARODUR 100 X0 HF

THERMAL

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	90	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	80	Unannealed, 120°C / h
RTI-Electrical Strenght (>0,97mm)	UL746B	°C	60	UL approved
RTI-Electrical Strenght (>0,97mm)	UL746B	°C	60	UL approved
RTI-Electrical Strenght (>0,97mm)	UL746B	°C	60	UL approved

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	V0	UL approved
Flame Behaviour (2 mm)	UL94	Class	V0	
Flame Behaviour (3,0 mm)	UL94	Class	V0	
Needle flame test (1,6 mm)	IEC 60695-11-5	-	PASSED	

INJECTION MOULDING

	Value
Drying Temperature (Circulating Air Oven)	70 - 80°C
Drying Temperature (Desiccant Dryer)	70 - 80°C
Drying Time (Circulating Air Oven)	2 - 4 h
Drying Time (Desiccant Dryer)	1 - 2 h
Suggested Max Regrind	< 15%
Melt Temperature	220 - 250°C
Feed Temperature	180°C
Rear Temperature	210°C
Middle Temperature	220°C
Front Temperature	230°C
Nozzle Temperature	240°C
Mould Temperature	50 - 80°C
Injection Rate	Medium to fast
Back Pressure	0,2 - 0,5 Mpa
Screw Revolving Speed	As low as possible
Cushion	3 - 6 mm
Screw Compression Ratio	2:1 - 3:1

The listed data are in the normal range of product properties, they should not be used to establish specification nor as the basis of design.

Unless specified to the contrary, the given values have been established on standardized test specimens at room temperature. These values are for natural colour only. The figures should be regarded as guide values only and not as binding minimum values. Please note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions, pigments and any other additives.

All information, recommendation or technical advice provided by TARO PLAST S.p.A. are given in good faith but without warranty, to the best of its knowledge and based on current procedures in effect. Our advice does not release you from the obligation to check its validity and to test our products as to their suitability for the intended processes and uses. The application, use and processing methods and conditions of our products and the products manufactured by you on the basis of our technical advice are beyond our control and, therefore, entirely under your own responsibility.



PRODUCT INFORMATION

TARODUR 100 X0 HF

Notes During processing, a dehumidifying hopper dryer is recommended at a temperature of 60 to 80°C. The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine or extruder size, part geometry and design.

The listed data are in the normal range of product properties, they should not be used to establish specification nor as the basis of design.

Unless specified to the contrary, the given values have been established on standardized test specimens at room temperature. These values are for natural colour only. The figures should be regarded as guide values only and not as binding minimum values. Please note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions, pigments and any other additives.

All information, recommendation or technical advice provided by TARO PLAST S.p.A. are given in good faith but without warranty, to the best of its knowledge and based on current procedures in effect. Our advice does not release you from the obligation to check its validity and to test our products as to their suitability for the intended processes and uses. The application, use and processing methods and conditions of our products and the products manufactured by you on the basis of our technical advice are beyond our control and, therefore, entirely under your own responsibility.