



4LAC[®] is the registered trade name for Acrylonitrile-Butadiene-Styrene (ABS) compounds produced by 4PLAS.

PROCESSING

ABS should be stored in a dry, well ventilated area away from sources of heat.

Pre-drying is not usually necessary if using a vented barrel. Otherwise 2 to 4 hours drying at 80°C is recommended. However flame retardant grades should be dried at 80°C for 3 to 4 hours in dehumidified driers prior to processing. Guide recommendations for processing parameters are detailed below:

Detailed processing instructions specific for each type of product are available upon request.

RECYCLING

Regrind levels up to 25% can be used depending upon the application and requirements. However for flame retardant grades a maximum 10% addition rate is recommended. Regrind should be clean, free of contamination and not thermally degraded and must be dry as moulded, or be dried prior to reuse.

SAFETY

Under normal working conditions **4LAC[®]** is not a toxic or hazardous material. During processing preventative actions should be taken to avoid direct contact with the polymer melt or inhalation of any gases produced. Detailed safety information can be found in our material safety data sheets (MSDS).

	Barrel Temperature (°C)	Mould Temperature (°C)	Melt Temperature (°C)	Back Pressure	Injection Speed	Injection Pressure
4LAC [®] (ABS-GP)	190 - 230	50 - 60	200	High	Fast	High
4LAC [®] (ABS-FR)	180 - 210	50 - 70	195	High	Fast	High
4LAC [®] (ABS-GF)	210 - 250	50 - 80	205	High	Fast	High