



Prime ABS 860 FR is an ignition resistant ABS with excellent process stability, high practical toughness and heat distortion temperature.



Property	Test Method	Value	Unit
Specific Gravity	D-792	1.18	g/cc
Melt Flow, 220°C/10kg	D-1238	12	g/10min
Tensile Strength	D-638	5,973	psi
Flexural Strength	D-790	7,964	psi
Flexural Modulus	D-790	298,683	psi
Notched Izod @ 73°F	D-256	3.75	ft-lb/in
Rockwell Hardness	D-785	98	R Scale
Mold Shrinkage	D-955	0.3-0.6	%
HDT @ 264 psi, Un-annealed	D-648	181	°F
Vicat Softening Point	ISO R 306	199	°F

Complies with UL 94-VO at thickness' greater than .059"  
Complies with UL 94-5VB at thickness' greater than .098"

Prime ABS 860FR	High	Avg.
Impact Strength	*	
Low Temperature Impact Strength		*
Tensile Strength	*	
Flexural Modulus	*	
Heat Deflection Temperature	*	

### Applications:

Prime ABS 860FR may be used for interior applications such as appliance parts, transportation and electronics.

### Finishing:

Prime ABS 860FR can be screwed, drilled, routed, punched and die-cut with conventional tooling. Parts made with Prime ABS 860FR may be joined with machine screws, bolts, nuts, rivets, and spring steel fasteners. Thread- cutting or thread-forming screws are an economical means for securing separate joints. Formed parts may be joined with Methylene Chloride if maximum impact strength is not required. Press and snap techniques and sonic welding may also be used for the bonding of Prime ABS 860FR.

### Processing:

Prime ABS 860FR has excellent thermoforming characteristics. It is extremely versatile in nearly all thermoforming operations from high volume, multi-station rotary machines to single station and shuttle presses. Pressure forming techniques have also been highly successful. It can be formed on wood, epoxy, ceramic and/or aluminum tools. The forming temperature has a range of 300 - 350°F. For best results the mold temperature should be 150-190°F. In some cases it is necessary to dry the sheet before forming.

### Colors, Textures and Capabilities:

Prime ABS 860FR can be color matched to meet your specific requirements. Prime ABS 860FR is available in thicknesses from .060 - .400. Textures include Calf Grain, HC, RM, Seville, Levant II, FL/HC and Diamond Plate.

Please contact your Piedmont Plastics representative for more information on finishing, fabricating, or the thermoforming process.

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small enough to handle YOUR needs.**

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