

General

Availability

- Global
- Processing Method
- Injection Molding

Description

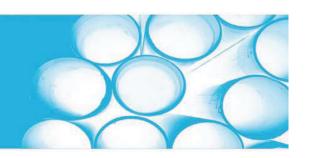
General purpose injection molding ABS

Physical	Nominal Value	Test Method
Density/Specific Gravity	1.04 g/cm3	ASTM D792
Melt Mass-Flow Rate	5.6 g/10 min	ASTM D1238
Melt Volume-Flow Rate	18 cm3/10min	ISO 1133
Mechanical	Nominal Value	Test Method
Tensile Modulus	2130 MPa	ASTM D638
Tensile Stress		ASTM D638
Yield	40 MPa	
Break	31 MPa	
Tensile Elongation		ASTM D638
Yield	2%	
Break	20%	
Flexural Modulus	2200 MPa	ASTM D790
Flexural Strength	68 MPa	ASTM D790
Impact	Nominal Value	Test Method
Notched Izod Impact	290 J/m	ASTM D256
Dart Impact	30 J	ASTM D3763

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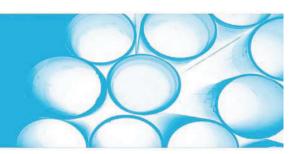
Thermal	Nominal Value	Test Method	
Deflection Temperature Under Load		D648	
.45 MPa, Unannealed, 3.2 mm	96 C	ASTM D256	
1.8 MPa, Unannealed, 3.2 mm	82 C	ASTM D3763	
Vicat Softening Temperature	98 C	ASTM D1525	
CLTE			
Flow: -40 to 40 C	8.85E-5 cm/cm/C		
Transverse: -40 to 40 C	8.85E-5 cm/cm/C		
RTi	60 C	UL 746	
Flammability			

Flame Rating (1.5mm)	НВ	UL 94
Injection Processing		Nominal Value
Drying Temperature		80 to 95 C
Drying Time		2 to 4 hours
Suggested Max Moisture		0.10%
Suggested Shot Size		50 to 70%
Rear Temperature		190 to 210 C
Middle Temperature		205 to 225 C
Front Temperature		215 to 240 C
Nozzle Temperature		220 to 260 C

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Injection ProcessingNominal ValueProcessing (melt) Temperature220 to 260 CMold Temperature50 to 70 CBack Pressure.3 to .7 MPaScrew Speed30 to 60 rpmVent Depth.038 to .051 mm

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