

## General

Availability

Global

Processing Method

Injection Molding

Description

· High flow general purpose ABS

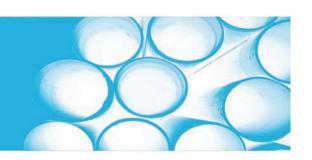
Physical	Nominal Value	Test Method
Density/Specific Gravity	1.04 g/cm3	ASTM D792
Melt Mass-Flow Rate	35 g/10 min	ASTM D1238
Mechanical	Nominal Value	Test Method
Tensile Modulus	2480 MPa	ASTM D638
Tensile Stress		ASTM D638
Yield	46 MPa	
Break	35 MPa	
Tensile Elongation		ASTM D638
Yield	2%	
Break	18%	
Flexural Modulus	2620 MPa	ASTM D790
Flexural Strength	79 MPa	ASTM D790
Impact	Nominal Value	Test Method
Notched Izod Impact	240 J/m	ASTM D256
Dart Impact	21 J	ASTM D3763

These suggestions and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee as conditions and methods of use are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.





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Thermal	Nominal Value	Test Method
Deflection Temperature Under Load		D648
.45 MPa, Unannealed, 3.2 mm	95 C	ASTM D256
1.8 MPa, Unannealed, 3.2 mm	82 C	<b>ASTM D3763</b>
Vicat Softening Temperature	99 C	ASTM D1525
CLTE		
Flow: -40 to 40 C	8.8E-5 cm/cm/C	
Transverse: -40 to 40 C	8.55E-5 cm/cm/C	
RTi	60 C	UL 746
Flammability		

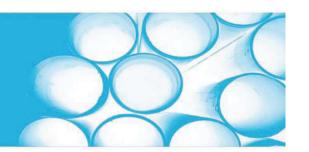
Flame Rating (1.5mm)	НВ	UL 94
Injection Processing		Nominal Value
Drying Temperature		80 to 95 C
Drying Time		2 to 4 hours
Suggested Max Moisture		0.10%
Suggested Shot Size		50 to 70%
Rear Temperature		190 to 200 C
Middle Temperature		200 to 210 C
Front Temperature		205 to 225 C
Nozzle Temperature		205 to 245 C

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Injection Processing	Nominal Value
Processing (melt) Temperature	205 to 245 C
Mold Temperature	50 to 70 C
Back Pressure	.3 to .7 MPa
Screw Speed	30 to 60 rpm
Vent Depth	.038 to .051 mm

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