

Product Description

Injection molding ABS

General Considerations

Resin ID (ISO 1043)	· ABS
Processing	· Injection Molding
Color	· Natural

- The information below is for informational purposes only and should not be adopted as specification limits.

Physical	Value	Unit	Method
Density / Specific Gravity	1,05	g/cm ³	ASTM D 792
Water Absorption	0,3	%	ASTM D 570
Mold Shrinkage	0.4 to 0.6	%	ASTM D 955
Melt Flow Rate 220°C/10kg	20 to 30	g/10min	ASTM D 1238

Mechanical	Value	Unit	Method
Tensile Stress at yield (at 5mm/min)	49	MPa	ASTM D 638
Tensile Strain at break (at 5mm/min)	35	%	ASTM D 638
Flexural Stress (at 3mm/min)	76	MPa	ASTM D 790
Flexural Modulus (at 3 mm/min)	2450	MPa	ASTM D 790
Notched Izod Impact 23°C	196	J/m	ASTM D 256
Rockwell Hardness	116	Scale R	ASTM D 785

Thermal	Value	Unit	Method
Flammability	HB	--	UL 94
Heat Deflection Temperature 1,82 MPa	92	°C	ASTM D 648
Vicat Softening Temperature	100	°C	ASTM D 1525
Thermal Conductivity	0.15	W/K.m	ASTM C 177
Coefficient of Linear Thermal Expansion	7.1 10 ⁵	mm/mm°C	ASTM D 696

Process	Value	Unit	Method
Injection Temperature	190 to 230	°C	--
Mold Temperature	50 to 70	°C	--
Drying	85/3	°C/Hours	--
Black pressure	<100	psi	--
Injection pressure	<12000	psi	--

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