

Properties

466MD

ABS resin

Heat resistance

| Properties | Test methods | Test conditions | Units | |
|---|--------------|-----------------|-------------|---------|
| Melt mass-flow rate | ISO 1133 | 220 deg C/10kg | g/10min | 4 |
| Mold shrinkage | ASTM D955 | - | % | 0.5-0.8 |
| Tensile strength | ISO 527 | - | MPa | 43 |
| Flexural strength | ISO 178 | - | MPa | 69 |
| Flexural modulus | ISO 178 | - | MPa | 2300 |
| Notched Charpy impact strength | ISO 179/1eA | 23 deg C | kJ/m2 | 10 |
| Notched Izod impact strength | ASTM D256 | 23 deg C/6.4mm | J/m | 100 |
| Deflection temperature under load | ISO 75 | 1.80MPa | deg C | 101 |
| Coefficient of linear thermal expansion | ISO 11359 | MD | X1E-5/deg C | 8 |
| Coefficient of linear thermal expansion | ISO 11359 | TD | X1E-5/deg C | - |
| Water absorption | ISO 62 | - | % | 0.3 |
| Density | ISO 1183 | - | g/cm3 | 1.07 |

Note

•Values are typical, not quality assured.

Typical settings for processing

| Preliminary drying | Barrel temperature(deg C) | | | | Screw rotation (rpm) | Back pressure (MPa) | Mold temperature (deg C) |
|----------------------|---------------------------|---------|---------|---------|----------------------|---------------------|--------------------------|
| | Nozzle | Front | Middle | Back | | | |
| 3-5hrs 80-90deg C | 240-260 | 240-260 | 220-240 | 200-230 | 50-100 | 10-20 | 40-60 |