

Properties

520, 520SF

ABS resin (UL94 HB)

Properties	Test methods	Test conditions	Units	
Melt mass-flow rate	ISO 1133	220 deg C/10kg	g/10min	22
Mold shrinkage	ASTM D955	-	%	0.4-0.6
Tensile strength	ISO 527	-	MPa	55
Flexural strength	ISO 178	-	MPa	95
Flexural modulus	ISO 178	-	MPa	3000
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	5
Notched Charpy impact strength	ISO 179/1eA	-30 deg C	kJ/m2	3
Notched Izod impact strength	ASTM D256	23 deg C/6.4mm	J/m	50
Notched Izod impact strength	ASTM D256	-30 deg C/6.4mm	J/m	30
Rockwell hardness	ISO 2039	-	-	R115
Deflection temperature under load	ISO 75	1.80MPa	deg C	81
Deflection temperature under load	ASTM D648	1.82MPa/12.7mm	deg C	92
Vicat softening temperature	ISO 306/B50	50N X 50deg C/h	deg C	98
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	-
Flammability	UL94	-	-	HB
Water absorption	ISO 62	-	%	0.3
Density	ISO 1183	-	g/cm3	1.06

Note

- Values are typical, not quality assured.
- UL recognition File No. of Daicel Polymer is E47773.

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 80-85deg C	210-230	210-230	190-210	170-190	70-90	10-20	40-60