

Properties

650

ABS resin

UV stability

Properties	Test methods	Test conditions	Units	
Melt mass-flow rate	ISO 1133	220 deg C/10kg	g/10min	20
Mold shrinkage	ASTM D955	-	%	0.4-0.6
Tensile strength	ISO 527	-	MPa	48
Flexural strength	ISO 178	-	MPa	75
Flexural modulus	ISO 178	-	MPa	2500
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	18
Notched Charpy impact strength	ISO 179/1eA	-30 deg C	kJ/m2	9
Notched Izod impact strength	ASTM D256	23 deg C/6.4mm	J/m	200
Notched Izod impact strength	ASTM D256	-30 deg C/6.4mm	J/m	90
Rockwell hardness	ISO 2039	-	-	R115
Deflection temperature under load	ISO 75	1.80MPa	deg C	80
Deflection temperature under load	ASTM D648	1.82MPa/12.7mm	deg C	91
Ball pressure temperature	-	-	deg C	90
Water absorption	ISO 62	-	%	0.3
Density	ISO 1183	-	g/cm3	1.05

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