

ABS

Product Description					
High Heat ABS					
General Properties					
Appearance	Black, Natural or Opaque Colors				
Processing Methods	Injection Molding, Profile Extrusion				
Applications	Automotive, Business Equipment General Purpose				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	6,500	psi	45	MPa
Flexural Modulus	ASTM D790	350,000	psi	2,414	MPa
Flexural Strength	ASTM D790	11,500	psi	79	MPa
Notched Izod Impact (73°F)	ASTM D256	4.0	ft-lb/in	214	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.06	sp gr	1.06	sp gr
Melt Flow 230°C/3.8 kg	ASTM D1238	5.0	g/10min	5.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	.005 - .007	in/in	.005 - .007	mm
Flame Rating 0.125	UL 94	HB		HB	
Flame Rating 0.062	UL 94	HB		HB	
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	220	°F	104	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	195	°F	91	°C
Injection Molding		Value			
Drying Temperature		180 - 200	°F		
Drying Time		2.0 - 4.0	hrs		
Maximum Drying Time		7.0	hrs		
Suggested Maximum Moisture		0.10	%		
Rear Barrel Temperatures		370 - 450	°F		
Middle Barrel Temperatures		400 - 475	°F		
Front Barrel Temperatures		425 - 500	°F		
Nozzle Temperature		425 - 525	°F		
Melt (processing) Temperatures		425 - 525	°F		
Mold Temperatures		120 - 170	°F		
Back Pressure		25 - 100	psi		
Screw speed		25 - 75	rpm		

These Data Sheet Values are Typical Values and are not intended for specification purposes. These values should only be used as a guide and no assurances by EnCom, Inc. can be granted that all molded articles will exhibit duplicate properties as those listed above. Each material user should perform their own testing for suitability.

EnCom Polymers, Inc.

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