

ABS-M

ABS-M is injection a molding aesthetic resin.ABS-M has high gloss,high flow and bright appearance.ABS-M is mainly used in appearance items of household appliance,etc.

Properties	Standard	Unit	Condition	Typical Value
Physical				
Density	ASTM D792	g/cm3		1.05
Melt Index	ASTM D1238	g/10min	220℃×10kg	40
Mold Shrinkage	ASTM D955	%		0.3~0.6
Gloss	ASTM D523	%		>90
Mechanical				
Tensile Strength	ASTM D638	MPa		48
Flexural Strength	ASTM D790	MPa		64
Flexural Modulus	ASTM D790	MPa		2200
Notched Izod Impact,3.2mm	ASTM D256	J/m	3.2mm,Notched	175
Rockwell Hardness	ASTM D785	R		110
Pencil Hardness	ASTM D2179	/	500g	HB
Thermal				
Heat Deflection Temp. 1.82MPa Unannealed	ASTM D648	℃	1.82MPa	84
VICAT	ASTM D1525	℃	B	95
Flammability				
Flammability	UL-94	Class	1.6mm	HB
Electrical Properties				
Volume Resistivity	IEC 60093	Ohm-cm	/	> 1.0E+15
Surface Resistivity	IEC 60093	Ohm	/	> 1.0E+15

Note: 1) These are typical property values, not specifications.

2) In case of colored products, the values could vary slightly by color.

3) Values are measured at 23℃ and in RH of 50% on injection molded specimens.

4) UL File No. E65424(CSA File No. LS 66457)

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Processing Parameters	Typical Value	Unit
Drying Temperature	80~85	℃
Drying Time	3~4	hour
Maximum moisture content	0.05	%
Barrel Temperature		
Rear	190~210	℃
Middle	210~220	℃
Front	230~240	℃
Nozzle	230~235	℃
Melt Temperature	220~240	℃
Mold Temperature	60~80	℃
Back Pressure	1~5	MPa
Screw Speed	30~60	rpm

Note:

1)The above data is only for reference. Exact settings have to follow the product,injection machine and mold.

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