

# Abstron HI-40

Acrylonitrile Butadiene Styrene  
Bhansali Engineering Polymers Limited

Message:

Abstron HI-40 is an acrylonitrile butadiene styrene (ABS) product. It can be processed by injection molding and is available in the Asia-Pacific region. Typical application areas are: automotive industry.  
Features include:  
flame retardant/rated flame  
Impact resistance

| General Information                                   |                                 |                   |                         |
|---|---------------------------------|-------------------|-------------------------|
| Features  | Impact resistance, high         |                   |                         |
|   | Sprayable                       |                   |                         |
| Uses  | Application in Automobile Field |                   |                         |
| Forms   | Particle                        |                   |                         |
| Processing Method                                     | Injection molding               |                   |                         |
| Physical  | Nominal Value                   | Unit              | Test Method             |
| Specific Gravity                                      | 1.04                            | g/cm <sup>3</sup> | ASTM D792               |
| Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)             | 18                              | g/10 min          | ASTM D1238              |
| Molding Shrinkage - Flow                              | 0.40                            | %                 | ASTM D955               |
| Hardness  | Nominal Value                   | Unit              | Test Method             |
| Rockwell Hardness (R-Scale)                           | 108                             |                   | ASTM D785               |
| Mechanical  | Nominal Value                   | Unit              | Test Method             |
| Tensile Strength <sup>1</sup> (Yield, 3.20 mm)        | 40.2                            | MPa               | ASTM D638               |
| Flexural Modulus (6.40 mm)                            | 1860                            | MPa               | ASTM D790               |
| Flexural Strength (Yield, 6.40 mm)                    | 57.9                            | MPa               | ASTM D790               |
| Impact  | Nominal Value                   | Unit              | Test Method             |
| Notched Izod Impact                                   |                                 |                   | ASTM D256               |
| 3.20 mm   | 490                             | J/m               | ASTM D256               |
| 6.40 mm   | 390                             | J/m               | ASTM D256               |
| Thermal   | Nominal Value                   | Unit              | Test Method             |
| Deflection Temperature Under Load (1.8 MPa, Annealed) | 94.0                            | °C                | ASTM D648               |
| Vicat Softening Temperature                           | 104                             | °C                | ASTM D1525 <sup>2</sup> |
| Flammability  | Nominal Value                   |                   | Test Method             |
| Flame Rating (3.20 mm)                                | HB                              |                   | UL 94                   |
| Injection   | Nominal Value                   | Unit              |                         |
| Drying Temperature                                    | 85.0 - 90.0                     | °C                |                         |
| Drying Time   | 3.0 - 3.5                       | hr                |                         |
| Suggested Max Moisture                                | 0.15                            | %                 |                         |

|                        |               |    |
|------------------------|---------------|----|
| Processing (Melt) Temp | 210 - 240     | °C |
| Mold Temperature       | 60.0 - 80.0   | °C |
| Injection Rate         | Moderate-Fast |    |

Injection instructions

Drying Time (Tray Oven): 3 to 3.5 hrDrying Time (Hopper Dryers): 2.5 to 3 hrDrying Time (Dry Air Ovens): 2 to 2.5 hrInjection Pressure: Medium to HighBack Pressure: Low to Medium

NOTE

|    |                    |
|----|--------------------|
| 1. | Type 1, 5.0 mm/min |
| 2. | 标准 B (120°C/h)     |

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