

Kingplate™ 710

Acrylonitrile Butadiene Styrene
Shanghai KumhoSunny Plastics Co., Ltd.

Message:

ABS710 is a plating grade ABS resin, offering high rigidity, high flow and high impact. ABS710 is recommended for automobile parts, cosmetics cases, refrigerator knobs, etc.

General Information			
Features	High Flow		
	High Impact Resistance		
	High Rigidity		
	Platable		
Uses	Automotive Applications		
	Consumer Applications		
	Cosmetics		
	Protective Coverings		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	20	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	42.0	MPa	ISO 527-2/50
Tensile Strain (Break)	67	%	ISO 527-2/50
Flexural Modulus ¹ (64.0 mm)	2190	MPa	ISO 178
Flexural Stress ² (64.0 mm)	62.0	MPa	ISO 178
Poisson's Ratio	0.39		ISO 527
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	15	kJ/m ²	
23°C	30	kJ/m ²	
Charpy Unnotched Impact Strength ⁴			ISO 179
-30°C	No Break		
23°C	No Break		

Notched Izod Impact Strength ⁵			ISO 180
-30°C	13	kJ/m ²	
23°C	27	kJ/m ²	
Unnotched Izod Impact Strength ⁶			ISO 180
-30°C	No Break		
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁷			
0.45 MPa, Unannealed	85.0	°C	ISO 75-2/B
1.8 MPa, Unannealed	75.0	°C	ISO 75-2/A
Vicat Softening Temperature	95.0	°C	ISO 306/B50
CLTE			ISO 11359-2
Flow : -40 to 40°C	7.7E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.6E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	190 to 210	°C	
Middle Temperature	210 to 220	°C	
Front Temperature	225 to 235	°C	
Nozzle Temperature	220 to 230	°C	
Processing (Melt) Temp	220 to 230	°C	
Mold Temperature	50.0 to 80.0	°C	
Back Pressure	1.00 to 5.00	MPa	
Screw Speed	30 to 70	rpm	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	Condition: 4 J		
4.	Condition: 4 J		
5.	Condition: 5.5 J		
6.	Condition: 5.5 J		
7.	120°C/h		

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