

EnCom ABS 5060

Acrylonitrile Butadiene Styrene

EnCom, Inc.

Message:

Molding Grade ABS

General Information	
Uses	Automotive Applications
	Business Equipment
	Thin-walled Parts
Appearance	Black
	Colors Available
	Natural Color
Forms	Pellets
Processing Method	Injection Molding
	Profile Extrusion

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.40 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	44.8	MPa	ASTM D638
Flexural Modulus	2380	MPa	ASTM D790
Flexural Strength (Yield)	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	320	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	83.9	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.57 mm	HB		
3.18 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 93.3	°C	
Drying Time	2.0 to 4.0	hr	
Drying Time, Maximum	7.0	hr	

Suggested Max Moisture	0.15	%
Rear Temperature	188 to 232	°C
Middle Temperature	204 to 246	°C
Front Temperature	218 to 260	°C
Nozzle Temperature	218 to 274	°C
Processing (Melt) Temp	218 to 274	°C
Mold Temperature	48.9 to 76.7	°C
Back Pressure	0.172 to 0.689	MPa
Screw Speed	25 to 75	rpm

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