

# Clariant ABS ABS4590

Acrylonitrile Butadiene Styrene

Clariant Corporation

Message:

The Notched Izod Impact Strength was tested on a colored specimen.

General Information			
Features	Good dimensional stability		
	Highlight		
	Impact resistance, high		
	Electroplateable		
	Good chemical resistance		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.60	%	ASTM D955
Water Absorption (24 hr)	0.35	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	102		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	41.4	MPa	ASTM D638
Tensile Elongation (Yield)	30	%	ASTM D638
Flexural Modulus	2210	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	190	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	87.8	°C	ASTM D648
1.8 MPa, not annealed	82.2	°C	ASTM D648
CLTE - Flow	8.6E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	85.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	204 - 249	°C	
Middle Temperature	204 - 249	°C	

Front Temperature	204 - 249	°C
Processing (Melt) Temp	204 - 246	°C
Melt Temperature (Aim)	227	°C
Mold Temperature	23.9 - 79.4	°C
Injection Rate	Slow	
Back Pressure	0.345 - 2.07	MPa
Screw Speed	20 - 100	rpm
Cushion	3.18 - 6.35	mm

#### Injection instructions

The minimum injection pressure to achieve 95% fill of the part during the boost injection pressure phase should be used. The hold pressure should be between 30% and 75% of the initial injection pressure.

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#### Recommended distributors for this material

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