

# TRILAC® ABS-HS4000

Acrylonitrile Butadiene Styrene  
Polymer Technology and Services, LLC

Message:

TRILAC® ABS-HS4000 is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by injection molding and is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.

General Information			
Features	General Purpose		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	4.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	44.8	MPa	ASTM D638
Tensile Elongation (Break)	15	%	ASTM D638
Flexural Modulus	2590	MPa	ASTM D790
Flexural Strength (Yield)	69.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.17 mm)	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	88.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	87.8 to 93.3	°C	
Drying Time	2.0 to 24	hr	
Rear Temperature	193	°C	
Middle Temperature	216	°C	
Front Temperature	227	°C	
Processing (Melt) Temp	232 to 260	°C	
Mold Temperature	48.9 to 65.6	°C	
Injection Pressure	68.9 to 82.7	MPa	
Injection Rate	Slow-Moderate		
Back Pressure	0.689	MPa	
Screw Speed	50 to 60	rpm	

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