

PRL ABS-G20

Acrylonitrile Butadiene Styrene
Polymer Resources Ltd.

Message:

PRL ABS-G20 is an Acrylonitrile Butadiene Styrene (ABS) product filled with 20% glass fiber. It can be processed by injection molding and is available in North America. Primary characteristic: rohs compliant.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	0.10 to 5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.10 to 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (3.18 mm)	6210	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield, 3.18 mm	86.2	MPa	
Break, 3.18 mm	86.2	MPa	
Tensile Elongation (Yield, 3.18 mm)	1.5	%	ASTM D638
Flexural Modulus (3.18 mm)	6240	MPa	ASTM D790
Flexural Strength (3.18 mm)	117	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Unnotched Izod Impact (23°C, 3.18 mm)	270	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	107	°C	
1.8 MPa, Unannealed, 3.18 mm	101	°C	
Injection	Nominal Value	Unit	
Drying Temperature	79.4 to 85.0	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Rear Temperature	191 to 199	°C	
Middle Temperature	210 to 221	°C	
Front Temperature	210 to 227	°C	
Processing (Melt) Temp	210 to 238	°C	
Mold Temperature	48.9 to 60.0	°C	

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