

Shinko-Lac® ABS HF-3

Acrylonitrile Butadiene Styrene

Mitsubishi Rayon America Inc.

Message:

Shinko-Lac ABS HF-3 is a high flow grade of ABS that is suitable for large or thin products and is effective for the remedies of sink marks, weld lines and molding cycle savings. Other features of HF-3 include an excellent balance of rigidity, strength, processability and glossiness. Typical applications of HF-3 include communications equipment, household goods and appliances.

General Information			
Features	Good dimensional stability		
	Rigidity, high		
	Highlight		
	High strength		
	Impact resistance, good		
	Weldable		
	Workability, good		
	Sprayable		
	Machinable		
	Good liquidity		
	Good chemical resistance		
	Good toughness		
	Good appearance		
	Non-toxic		
	High hardness		
Uses	Electrical housing		
	Electrical appliances		
UL File Number	E54695		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Extrusion		
	Calendering		
	Vacuum forming		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	4.0	g/10 min	ASTM D1238

Molding Shrinkage - Flow	0.50	%	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2450	MPa	ASTM D638
Tensile Strength (Yield, 23°C)	41.2	MPa	ASTM D638
Flexural Modulus (23°C, 6.35 mm)	2450	MPa	ASTM D790
Flexural Strength (Yield, 23°C, 6.35 mm)	63.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 6.35 mm	69	J/m	ASTM D256
0°C, 6.35 mm	120	J/m	ASTM D256
23°C, 6.35 mm	160	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 12.7 mm)	89.0	°C	ASTM D648
CLTE - Flow	8.5E-5	cm/cm/°C	ASTM D696
Specific Heat	1670	J/kg/°C	ASTM C351
Thermal Conductivity	0.21	W/m/K	ASTM C177
Flammability	Nominal Value		Test Method
Flame Rating (NC)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 85.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	180 - 250	°C	
Middle Temperature	180 - 250	°C	
Front Temperature	180 - 250	°C	
Mold Temperature	40.0 - 80.0	°C	
Injection Pressure	58.8 - 108	MPa	
Injection instructions			

Higher mold temperature provides a product with excellent surface finish and less residual stress.

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