

# PRL ABS-G5

Acrylonitrile Butadiene Styrene  
Polymer Resources Ltd.

Message:

PRL ABS-G5 is an Acrylonitrile Butadiene Styrene (ABS) product filled with 5.0% 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,5.0% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	0.50 to 5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.30 to 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18 mm	45.5	MPa	
Break, 3.18 mm	42.7	MPa	
Flexural Modulus (3.18 mm)	2900	MPa	ASTM D790
Flexural Strength (Break, 3.18 mm)	65.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	80	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	93.3	°C	
1.8 MPa, Unannealed, 3.18 mm	87.8	°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	227 to 238	°C	
Mold Temperature	48.9 to 60.0	°C	

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