

PPR ABS02

Acrylonitrile Butadiene Styrene
Premier Plastic Resins, Inc.

Message:

PPR ABS02 is an acrylonitrile butadiene styrene (ABS) product. It can be processed by injection molding and is available in North America.

General Information			
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	41.4	MPa	ASTM D638
Tensile Elongation (Break)	35	%	ASTM D638
Flexural Modulus - Tangent	2410	MPa	ASTM D790
Flexural Strength	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	270	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	91.0	°C	ASTM D648
1.8 MPa, not annealed	85.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	77.0 - 82.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	227 - 254	°C	
Middle Temperature	232 - 260	°C	
Front Temperature	232 - 260	°C	
Nozzle Temperature	243 - 254	°C	
Processing (Melt) Temp	227 - 260	°C	
Mold Temperature	49.0 - 77.0	°C	
Injection Pressure	5.00 - 55.0	MPa	
Injection Rate	Moderate-Fast		
Holding Pressure	3.00 - 45.0	MPa	
Back Pressure	0.00 - 1.00	MPa	
Cushion	6.35 - 12.7	mm	

Injection instructions

Screw Speed: Moderate-FastDecompression: 3.81 to 7.6 mm

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