

Clariant ABS ABS4500G10

Acrylonitrile Butadiene Styrene

Clariant Corporation

Message:

The Notched Izod Impact Strength was tested on a natural colored specimen.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Features	Good dimensional stability		
	Rigid, good		
	Highlight		
	Impact resistance, good		
	Good chemical resistance		
	General ductility		
Uses	General		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.30	%	ASTM D955
Water Absorption (24 hr)	0.20	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	60		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	68.9	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	4480	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	80	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	104	°C	ASTM D648
1.8 MPa, not annealed	98.9	°C	ASTM D648
CLTE - Flow	6.8E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength	17	kV/mm	ASTM D149

Injection	Nominal Value	Unit
Drying Temperature	85.0	°C
Drying Time	2.0 - 4.0	hr
Rear Temperature	204 - 249	°C
Middle Temperature	204 - 249	°C
Front Temperature	204 - 249	°C
Processing (Melt) Temp	204 - 246	°C
Melt Temperature (Aim)	227	°C
Mold Temperature	23.9 - 79.4	°C
Injection Rate	Moderate-Fast	
Back Pressure	0.345 - 2.07	MPa
Screw Speed	20 - 100	rpm
Cushion	3.18 - 6.35	mm

Injection instructions

The minimum injection pressure to achieve 95% fill of the part during the boost injection pressure phase should be used. The hold pressure should be between 30% and 75% of the initial injection pressure.

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