

# Color-in™ ABS-M

Acrylonitrile Butadiene Styrene  
Shanghai KumhoSunny Plastics Co., Ltd.

Message:

ABS-M is injection a molding aesthetic resin.ABS-M has high gloss,high flow and bright appearance.ABS-M is mainly used in appearance items of household appliance,etc.

General Information			
Features	High Flow		
	High Gloss		
	Pleasing Surface Appearance		
Uses	Appliances		
UL File Number	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	40	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Pencil Hardness - 500g	HB		
CSA File No.	LS 66457		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	48.0	MPa	ASTM D638
Flexural Modulus	2200	MPa	ASTM D790
Flexural Strength	64.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	180	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	84.0	°C	ASTM D648
Vicat Softening Temperature	95.0	°C	ASTM D1525 <sup>1</sup>
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Optical	Nominal Value		Test Method

Gardner Gloss	> 90	ASTM D523
Injection	Nominal Value	Unit
Drying Temperature	80.0 to 85.0	°C
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	190 to 210	°C
Middle Temperature	210 to 220	°C
Front Temperature	230 to 240	°C
Nozzle Temperature	230 to 235	°C
Processing (Melt) Temp	220 to 240	°C
Mold Temperature	60.0 to 80.0	°C
Back Pressure	1.00 to 5.00	MPa
Screw Speed	30 to 60	rpm
NOTE		
1.	Rate B (120°C/h)	

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