

EnCom F2 ABS 6030

Acrylonitrile Butadiene Styrene

EnCom, Inc.

Message:

Molding Grade FR ABS

General Information	
Features	Flame Retardant
Uses	Business Equipment
	Electrical/Electronic Applications
Appearance	Black
	Colors Available
	Natural Color
Forms	Pellets
Processing Method	Injection Molding
	Profile Extrusion

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.40 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2170	MPa	ASTM D638
Tensile Strength (Yield)	36.5	MPa	ASTM D638
Flexural Modulus	2240	MPa	ASTM D790
Flexural Strength (Yield)	64.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	150	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	75.6	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (1.57 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	76.7 to 87.8	°C	
Drying Time	2.0 to 4.0	hr	
Drying Time, Maximum	7.0	hr	
Suggested Max Moisture	0.15	%	

Rear Temperature	149 to 182	°C
Middle Temperature	177 to 204	°C
Front Temperature	191 to 232	°C
Nozzle Temperature	191 to 232	°C
Processing (Melt) Temp	191 to 232	°C
Mold Temperature	48.9 to 76.7	°C
Back Pressure	0.172 to 0.689	MPa
Screw Speed	25 to 75	rpm

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