

EnCom ABS 5035

Acrylonitrile Butadiene Styrene

EnCom, Inc.

Message:

Molding Grade ABS

General Information			
Uses	Automotive Applications		
	Business Equipment		
	General Purpose		
	Thin-walled Parts		
Appearance	Black		
	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
	Profile Extrusion		
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)	5.0	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	2000	MPa	ASTM D638
Tensile Strength (Yield)	40.0	MPa	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Flexural Strength (Yield)	58.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	190	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	76.7	°C	ASTM D648
Flammability	Nominal Value	Test Method	
Flame Rating (3.18 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 93.3	°C	
Drying Time	2.0 to 4.0	hr	
Drying Time, Maximum	7.0	hr	

Suggested Max Moisture	0.15	%
Rear Temperature	188 to 218	°C
Middle Temperature	204 to 232	°C
Front Temperature	218 to 246	°C
Nozzle Temperature	218 to 274	°C
Processing (Melt) Temp	218 to 274	°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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