

Generic AES

Acrylonitrile Ethylene Styrene
Generic

Message:

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This information is provided for comparative purposes only.

General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.04 - 1.05	g/cm³	ASTM D792
23°C	1.04 - 1.07	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)			
220°C/10.0 kg	5.0 - 35	g/10 min	ASTM D1238
220°C/10.0 kg	5.0 - 18	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (220°C/2.16 kg)	8.13 - 51.9	cm³/10min	ISO 1133
Molding Shrinkage			
Flow: 23°C	0.55 - 0.70	%	ASTM D955
23°C	0.50 - 0.70	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
23°C	93 - 112		ASTM D785
23°C	100 - 108		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	1970 - 2360	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	48.8 - 53.9	MPa	ASTM D638
Yield, 23°C	38.0 - 51.6	MPa	ISO 527-2
23°C	37.0 - 50.0	MPa	ISO 527-2
Flexural Modulus			
23°C	2000 - 2450	MPa	ASTM D790
23°C	2000 - 2720	MPa	ISO 178
Flexural Strength			
23°C	55.0 - 90.2	MPa	ASTM D790
23°C	54.7 - 78.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0 - 32	kJ/m²	ISO 179
Notched Izod Impact (23°C)	110 - 210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

1.8 MPa, not annealed	84.6 - 90.6	°C	ASTM D648
1.8 MPa, not annealed	71.7 - 89.2	°C	ISO 75-2/A
CLTE - Flow	8.0E-5 - 9.0E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 88.3	°C	
Drying Time	3.0 - 3.5	hr	
Rear Temperature	188 - 250	°C	
Middle Temperature	214 - 250	°C	
Front Temperature	209 - 254	°C	
Nozzle Temperature	210 - 247	°C	
Processing (Melt) Temp	215 - 260	°C	
Mold Temperature	55.0 - 65.0	°C	
Back Pressure	0.776 - 10.0	MPa	
Screw Speed	45 - 75	rpm	
Injection instructions			

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