

Jamplast Inj-03 ABS

Acrylonitrile Butadiene Styrene

Jamplast, Inc.

Message:

Jamplast Inj-03 ABS is a general injection molding grade of ABS (Acrylonitrile Butadiene Styrene). It is a high-impact, high-gloss ABS, available only in natural and black. Typical applications include housings, toys, small appliances, and cusumer goods.

General Information			
Features	Highlight		
	Impact resistance, high		
	General		
Uses	Electrical appliances		
	Shell		
	Toys		
	Consumer goods application field		
Appearance	Black		
	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	12	g/10 min	ASTM D1238
230°C/3.8 kg	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness	109		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2550	MPa	ASTM D638
Tensile Strength (Yield)	42.0	MPa	ASTM D638
Tensile Elongation (Break)	> 30	%	ASTM D638
Flexural Modulus	2600	MPa	ASTM D790
Flexural Strength (Yield)	72.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 3.20 mm	64	J/m	ASTM D256
23°C, 3.20 mm	380	J/m	ASTM D256
23°C, 12.7 mm	210	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 12.7mm	92.0	°C	ASTM D648
0.45 MPa, annealed, 12.7mm	99.0	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	85.0	°C	ASTM D648
1.8 MPa, annealed, 12.7mm, molded	102	°C	ASTM D648
1.8 MPa, annealed, 12.7mm	94.0	°C	ASTM D648
Vicat Softening Temperature	106	°C	ASTM D1525
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	HB		UL 94
3.00 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	71.0 - 77.0	°C	
Drying Time	4.0	hr	
Dew Point	29.0	°C	
Suggested Max Moisture	0.10	%	
Rear Temperature	235 - 249	°C	
Middle Temperature	241 - 254	°C	
Front Temperature	246 - 260	°C	
Nozzle Temperature	246 - 260	°C	
Processing (Melt) Temp	246 - 274	°C	
Mold Temperature	43.0 - 66.0	°C	
Injection Pressure	68.9 - 110	MPa	
Back Pressure	0.00 - 0.172	MPa	
Clamp Tonnage	3.1 - 6.2	kN/cm ²	
Cushion	< 6.35	mm	
Injection instructions			

Alternative Drying Recommendations 82.0 - 88.0 °C @ 7200 sec.

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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