

PRL ABS-G25

Acrylonitrile Butadiene Styrene
Polymer Resources Ltd.

Message:

PRL ABS-G25 is an Acrylonitrile Butadiene Styrene (ABS) product filled with 25% glass fiber. It can be processed by injection molding and is available in North America. Primary characteristic: rohs compliant.

General Information			
Filler / Reinforcement	Glass Fiber,25% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.23	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	0.50 to 5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.10 to 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18 mm	93.1	MPa	
Break, 3.18 mm	93.1	MPa	
Tensile Elongation (Yield, 3.18 mm)	1.5	%	ASTM D638
Flexural Modulus (3.18 mm)	7580	MPa	ASTM D790
Flexural Strength (3.18 mm)	128	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	110	°C	
1.8 MPa, Unannealed, 3.18 mm	104	°C	
Injection	Nominal Value	Unit	
Drying Temperature	79.4 to 85.0	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Rear Temperature	193 to 210	°C	
Middle Temperature	210 to 221	°C	
Front Temperature	210 to 227	°C	
Processing (Melt) Temp	210 to 238	°C	
Mold Temperature	48.9 to 71.1	°C	

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