

# Abstron HCR-15 M

Acrylonitrile Butadiene Styrene

Bhansali Engineering Polymers Limited

## Message:

Abstron HCR-15 M is an acrylonitrile butadiene styrene (ABS) product. It is available in the Asia-Pacific region.

Features include:

flame retardant/rated flame

chemical resistance

Heat resistance

General Information			
Features	Good chemical resistance Heat resistance, high		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	30	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup> (Yield, 3.20 mm)	41.2	MPa	ASTM D638
Flexural Modulus (6.40 mm)	2160	MPa	ASTM D790
Flexural Strength (Yield, 6.40 mm)	60.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
3.20 mm	410	J/m	ASTM D256
6.40 mm	290	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Annealed)	96.0	°C	ASTM D648
Vicat Softening Temperature	105	°C	ASTM D1525 <sup>2</sup>
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.20 mm)	HB		UL 94
Injection	Nominal Value	Unit	Test Method
Drying Temperature	85.0 - 90.0	°C	
Drying Time	3.0 - 3.5	hr	
Suggested Max Moisture	0.15	%	
Processing (Melt) Temp	220 - 260	°C	
Mold Temperature	65.0 - 85.0	°C	

Injection Rate	Moderate-Fast
Injection instructions	
Drying Time (Tray Oven): 3 to 3.5 hrDrying Time (Hopper Dryers): 2.5 to 3 hrDrying Time (Dry Air Ovens): 2 to 2.5 hrInjection Pressure: Medium to HighBack Pressure: Medium to High	
NOTE	
1.	Type 1, 5.0 mm/min
2.	标准 B (120°C/h)

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