Jamplast JPHGABS

Acrylonitrile Butadiene Styrene

Jamplast, Inc.

Message:

Jamplast high gloss resins are thermoplastic materials which provide an excellent balance of processability, impact resistance and heat resistance as imparted by the various polymer compositions. Jamplast ABS resins are available in a wide range of melt flow rates, impact strength and heat resistance for both high and low gloss applications manufactured by injection molding, sheet or profile extrusion and thermoforming processes. Jamplast ABS resins are designed to offer a wide range of impact strengths and melt flow rates to meet the needs of the durables injection molding markets. This product offers typical lzod impact strength values from 4 to 7.5 ft-lb/in and melt flow rates ranging from 2.5 to 7.0 g/10 min. The gloss values are typically greater than 95% on the 60° Gardner scale for the highest gloss resins and greater than 90% for those products having a broader range of gloss.

Jamplast ABS resin offers a broader range of gloss while maintaining medium impact strength with a medium melt flow rate.

Pellets		
Extrusion		
Injection Molding		
Nominal Value	Unit	Test Method
1.04	g/cm³	ASTM D792
0.40 to 0.70	%	ASTM D955
Nominal Value	Unit	Test Method
2240	MPa	ASTM D638
		ASTM D638
44.8	MPa	
31.0	MPa	
40	%	ASTM D638
2550	MPa	ASTM D790
75.8	MPa	ASTM D790
Nominal Value	Unit	Test Method
		ASTM D256
130	J/m	
320	J/m	
		ASTM D3763
26.0	J	
31.6	J	
33.9	J	
55.4	J	
Nominal Value	Unit	Test Method
		ASTM D648
92.2	°C	
76.7	°C	
	Pellets Extrusion Injection Molding Nominal Value 1.04 0.40 to 0.70 Nominal Value 2240 44.8 31.0 40 2550 75.8 Nominal Value 130 320 26.0 31.6 33.9 55.4 Nominal Value	Pellets Extrusion Injection Molding Nominal Value Unit 1.04 g/cm³ 0.40 to 0.70 % Nominal Value Unit 2240 MPa 44.8 MPa 31.0 MPa 2550 MPa 75.8 MPa 75.8 MPa 130 J/m 320 J/m 131.6 J 320 J/m 31.6 J 33.9 J 33.9 J 33.9 J 92.2 °C 76.7 °C

Vicat Softening Temperature	106	°C	ASTM D1525
CLTE - Flow	7.9E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (1.47 mm)	НВ		UL 94
Optical	Nominal Value		Test Method
Gardner Gloss (60°)	90		ASTM D523
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 87.8	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.10	%	
Processing (Melt) Temp	218 to 274	°C	
Mold Temperature	26.7 to 60.0	°C	
Back Pressure	0.345 to 3.45	MPa	
Clamp Tonnage	2.8 to 6.9	kN/cm ²	
Screw L/D Ratio	20.0:1.0		
Screw Compression Ratio	1.5:1.0 to 3.5:1.0		
NOTE			
1.	Type I, 51 mm/min		
2.	Type I, 51 mm/min		
3.	Type I, 51 mm/min		
4.	Type I, 1.3 mm/min		
5.	Type I, 1.3 mm/min		
6.	0.25 mm Notch Depth		
7.	3.39 m/sec		

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