

# Abstron IM-14 S

Acrylonitrile Butadiene Styrene  
Bhansali Engineering Polymers Limited

Message:

Abstron IM-14 S is an acrylonitrile butadiene styrene (ABS) product. It can be processed by injection molding and is available in the Asia-Pacific region. Features include:  
flame retardant/rated flame  
high gloss  
Hard  
Impact resistance

General Information			
Features	Rigidity, high		
	Highlight		
	Medium impact resistance		
Forms	Particle		
Processing Method	Injection molding		
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)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	113		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup> (Yield, 3.20 mm)	47.1	MPa	ASTM D638
Flexural Modulus (6.40 mm)	2300	MPa	ASTM D790
Flexural Strength (Yield, 6.40 mm)	68.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
3.20 mm	160	J/m	ASTM D256
6.40 mm	130	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Annealed)	94.0	°C	ASTM D648
Vicat Softening Temperature	105	°C	ASTM D1525 <sup>2</sup>
Flammability	Nominal Value		Test Method
Flame Rating (3.20 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	85.0 - 90.0	°C	
Drying Time	3.0 - 3.5	hr	

Suggested Max Moisture	0.15	%
Processing (Melt) Temp	210 - 250	°C
Mold Temperature	60.0 - 80.0	°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: Low to MediumBack Pressure: Low to Medium

NOTE

- |    |                |
|----|----------------|
| 1. | Type 1         |
| 2. | 标准 B (120°C/h) |

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