

HIVAL® HG6 Natural

Acrylonitrile Butadiene Styrene

Nexeo Solutions, LLC.

Message:

HIVAL® HG6 Natural is an acrylonitrile butadiene styrene (ABS) material. This product is available in North America and is processed by injection molding.

HIVAL® The main features of HG6 Natural are:

ROHS certification

Impact resistance

Typical application areas include:

hat/cap/cork

home apps

container

Consumer goods

food contact applications

General Information			
Features	Impact resistance, high Good liquidity		
Uses	Thin wall container Shield Household goods Sporting goods Shell Toys		
Agency Ratings	FDA 21 CFR 181.32		
RoHS Compliance	RoHS compliance		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ASTM D1505
Melt Volume-Flow Rate (MVR)			
230°C/3.8 kg	4.80	cm ³ /10min	ASTM D1238
220°C/10.0 kg	19.0	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	103		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ASTM D638
Tensile Strength (Yield)	45.0	MPa	ASTM D638
Flexural Modulus	2300	MPa	ASTM D790
Flexural Strength	65.0	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	300	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	90.6	°C	ASTM D648
1.8 MPa, not annealed	77.8	°C	ASTM D648
Vicat Softening Temperature	95.6	°C	ASTM D1525 ¹
Injection	Nominal Value	Unit	
Drying Temperature	76.7 - 79.4	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	199 - 232	°C	
Middle Temperature	204 - 232	°C	
Front Temperature	218 - 260	°C	
Nozzle Temperature	218 - 260	°C	
Processing (Melt) Temp	218 - 274	°C	
Mold Temperature	71.1 - 82.2	°C	
Injection Pressure	2.76 - 10.3	MPa	
Back Pressure	1.03 - 3.45	MPa	
Injection instructions			
Screw Speed: Slow Injection Speed: Slow - Fast Avoid excessive melt temperatures and long residence times as this could lead to thermal degradation.			
NOTE			

1. 速率 A (50°C/h), 载荷2 (50N)

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