

NEXUS ABS ABS9020

Acrylonitrile Butadiene Styrene

Nexus Resin Group, LLC.

Message:

Molding Grade ABS

General Information			
UL File Number	E205256		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	9.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2280	MPa	ASTM D638
Tensile Strength (Yield)	41.4	MPa	ASTM D638
Flexural Modulus	2410	MPa	ASTM D790
Flexural Strength (Yield)	68.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	82.2	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 93.3	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.15	%	
Rear Temperature	188 to 218	°C	
Middle Temperature	204 to 232	°C	
Front Temperature	218 to 246	°C	
Nozzle Temperature	218 to 274	°C	
Processing (Melt) Temp	218 to 274	°C	
Mold Temperature	48.9 to 76.7	°C	
Back Pressure	0.172 to 0.689	MPa	
Screw Speed	25 to 75	rpm	

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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