

ABS ER468

Injection Molding Grade

Description

High flow, Medium heat resistance

Application

Electric/electronic products

Properties	Test Condition	Test Method	Unit	Typical Value	
Physical					
Specific Gravity		ASTM D792	-	1.04	
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.7	
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	35	
Mechanical					
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	485	
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	>10	
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²		
Flexural Strength, 3.2mm	15mm/min	ASTM D790	kg/cm ²	780	
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm ²	26,000	
IZOD Impact Strength, 6.4mm (Notched)	23℃	ASTM D256	kg·cm/cm		
	-30℃		kg·cm/cm		
IZOD Impact Strength, 3.2mm (Notched)	23℃	ASTM D256	kg·cm/cm	20	
	-30℃		kg·cm/cm		
Rockwell Hardness	R-Scale	ASTM D785	-	111	
Thermal					
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	℃	91	
	4.6kg		℃		
Vicat Softening Temperature	5kg, 50℃/h		ASTM D1525	℃	
Flammability	UL94		class	HB	
	1.5mm				
3.0mm			class	HB	
Relative Temperature Index	UL 746B		℃	60	
	Electrical				
	Mechanical with Impact				
	Mechanical without Impact				

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23℃, 50% relative humidity.

Updated : 27-Dec-17

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	80	
Drying Time	hrs	2 ~ 4	
Minimum Moisture Content	%	0.01	
Melt Temperature	°C	210 ~ 240	
Cylinder Temperature	Rear	°C	180 ~ 220
	Middle	°C	190 ~ 230
	Front	°C	200 ~ 240
Nozzle Temperature	°C	200 ~ 240	
Mold Temperature	°C	40 ~ 70	
Back Pressure	kg/cm ²	5 ~ 15	
Screw Speed	%	30 ~ 60	

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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