

PRL ABS-G10

Polymer Resources Ltd. - Acrylonitrile Butadiene Styrene

Units

Action

Legend **General Information****General**

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber, 10% Filler by Weight
RoHS Compliance	<ul style="list-style-type: none"> RoHS Compliant
Forms	<ul style="list-style-type: none"> Pellets
Processing Method	<ul style="list-style-type: none"> Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.10		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	0.10 to 5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	1.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 0.125 in)	6900	psi	ASTM D638
Tensile Strength (Break, 0.125 in)	6700	psi	ASTM D638
Flexural Modulus (0.125 in)	445000	psi	ASTM D790
Flexural Strength (Break, 0.125 in)	11000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed, 0.125 in)	210	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	195	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175 to 185	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Rear Temperature	375 to 390	°F
Middle Temperature	410 to 430	°F
Front Temperature	410 to 440	°F
Processing (Melt) Temp	440 to 460	°F
Mold Temperature	120 to 140	°F

Notes

¹ Typical properties: these are not to be construed as specifications.

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