Polymer Resources
Classic® Engineering Plastic Compounds

Wednesday, August 30, 2023

PRL ABS-G15

Polymer Resources Ltd. - *Acrylonitrile Butadiene Styrene*

Units English

Action **Legend (Open)**

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.15		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)	10000	psi	ASTM D638
Tensile Strength (Break, 0.125 in)	10000	psi	ASTM D638
Flexural Modulus (0.125 in)	825000	psi	ASTM D790
Flexural Strength (0.125 in)	14000	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)	220	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	209	°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.