

**PRL ABS-G25**Units **Polymer Resources Ltd. - Acrylonitrile Butadiene Styrene****Action****Legend (Open)****General Information****General**

Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Filler / Reinforcement	<ul style="list-style-type: none"> <li>Glass Fiber, 25% Filler by Weight</li> </ul>
RoHS Compliance	<ul style="list-style-type: none"> <li>RoHS Compliant</li> </ul>
Forms	<ul style="list-style-type: none"> <li>Pellets</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**ASTM & ISO Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	0.50 to 5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	1.0E-3 to 3.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 0.125 in)	13500	psi	ASTM D638
Tensile Strength (Break, 0.125 in)	13500	psi	ASTM D638
Tensile Elongation (Yield, 0.125 in)	1.5	%	ASTM D638
Flexural Modulus (0.125 in)	1.10E+6	psi	ASTM D790
Flexural Strength (0.125 in)	18500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 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)	230	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	220	°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	380 to 410	°F
Middle Temperature	410 to 430	°F
Front Temperature	410 to 440	°F
Processing (Melt) Temp	410 to 460	°F
Mold Temperature	120 to 160	°F

**Notes**

<sup>1</sup> Typical properties: these are not to be construed as specifications.

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