

TECHNICAL DATASHEET

TRIBS® 640U

ABS

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.08
Water Absorption (24 hours at 23°C)	%	D570	0.2
Melt Flow Rate (220°C, 10kg)	g/10min	D1238	35
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	500
Tensile Elongation at break	%	D638	30
Flexural Strength at yield	kg _f /cm ²	D790	650
Flexural Modulus	kg _f /cm ²	D790	23,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	10
Rockwell Hardness	R scale	D785	110
THERMAL			
HDT, 18.6 kgf/cm ²	°C	D648	85
ELECTRICAL			
OTHERS			
UL-94 Flammability (1.5mm thickness)	-	(UL 94)	HB
Mold Shrinkage (3mm thickness)	%	D955	0.5~0.7

※ The figures listed in this table are typical values obtained under the standard test methods and may not be applicable for products that are under different application condition.

PROCESSING GUIDE

TRIBS® 640U GRADE

ABS

- General processing conditions for TRIBS640U are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	75-85
Drying Time	hr	3-4
Moisture Content, Max	%	0.02
Melt Temperature	℃	230-250
Nozzle Temperature	℃	230-250
Front Temperature	℃	220-240
Middle Temperature	℃	210-230
Rear Temperature	℃	200-210
Mold Temperature	℃	60-90

Global Network

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