

TECHNICAL DATASHEET

TRIBS® ML687

ABS

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.05
Melt Flow Rate (220℃, 10kg)	g/10min	D1238	42
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	450
Tensile Elongation at break	%	D638	40
Flexural Strength at yield	kg _f /cm ²	D790	650
Flexural Modulus	kg _f /cm ²	D790	24,000
Izod Impact Strength, notched, 23℃ (1/8")	kg _f ·cm/cm	D256	8
Rockwell Hardness	R scale	D785	109
THERMAL			
HDT, 18.6 kg _f /cm ²	℃	D648	87
ELECTRICAL			
OTHERS			
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® ML687 GRADE

ABS

- General processing conditions for TRIBSML687 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	℃	220-240
Nozzle Temperature	℃	220-240
Front Temperature	℃	220-240
Middle Temperature	℃	220-240
Rear Temperature	℃	190-220
Mold Temperature	℃	30-50
Back Pressure	MPa	0.0-0.1
Screw Speed	rpm	10-50
Vent Depth	mm	0.02-0.08

Global Network

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