Optilac MH100

The Materials Group - *Acrylonitrile Butadiene Styrene*

General Information

General		
Material Status	• Commercial: Active	
Availability	• North America	
Features	• Medium Heat Resistance	
Appearance	• Black	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	16	g/10 min	ISO 1133
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (Yield)	6380	psi	ISO 527-2
Flexural Modulus	305000	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	8.1	ft·lb/in²	ISO 179
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	198	°F	ISO 75-2/B

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	190 to 200	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.010	%
Rear Temperature	380 to 460	°F
Middle Temperature	410 to 480	°F
Front Temperature	430 to 490	°F
Nozzle Temperature	450 to 525	°F
Processing (Melt) Temp	450 to 525	°F
Mold Temperature	120 to 180	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm

Notes

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