

## Optilac MH102

The Materials Group - Acrylonitrile Butadiene Styrene

### General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Features	• High Heat Resistance
Uses	• Automotive Applications
Appearance	• Black • Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density	1.09	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	19	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	8410	psi	ISO 527-2
Flexural Modulus	319000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	8.6	ft·lb/in <sup>2</sup>	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	201	°F	ISO 75-2/A

### Processing Information

	Nominal Value	Unit
Drying Temperature - Desiccant Dryer	190 to 200	°F
Drying Time - Desiccant Dryer	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	440 to 450	°F
Middle Temperature	450 to 460	°F
Front Temperature	450 to 460	°F
Nozzle Temperature	460 to 470	°F
Processing (Melt) Temp	440 to 470	°F
Mold Temperature	120 to 160	°F
Back Pressure	50.0 to 150	psi
Screw Speed	30 to 60	rpm

Injection Notes
Desiccant / Dehumidifying Drying Required

### Notes

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

