Optilac MH106

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	1.03	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	8.5	g/10 min	ASTM D1238
Molding Shrinkage	0.30 to 0.60	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (Yield)	6380	psi	ISO 527-2
Tensile Strain (Break)	40	%	ISO 527-2
Flexural Modulus	319000	psi	ISO 178
Flexural Stress	9720	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	10	ft·lb/in²	ISO 179
Notched Izod Impact Strength	10	ft·lb/in²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Annealed)	223	°F	ISO 75-2/B
Vicat Softening Temperature	223	°F	ISO 306/B50

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	194 to 203	°F
Drying Time	3.0	hr
Suggested Max Moisture	0.010	%
Rear Temperature	428 to 464	°F
Middle Temperature	446 to 482	°F
Front Temperature	446 to 482	°F
Nozzle Temperature	450 to 525	°F
Processing (Melt) Temp	450 to 525	°F
Mold Temperature	86 to 158	°F
Back Pressure	71.0 to 213	psi
Screw Speed	30 to 60	rpm

Notes

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