

TECHNICAL DATASHEET

# TRIBS<sup>®</sup> 640G20

ABS

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
<b>PHYSICAL</b>			
Specific Gravity	-	D792	1.20
Melt Flow Rate (220°C, 10kg)	g/10min	D1238	10
<b>MECHANICAL</b>			
Tensile Strength at yield	kg <sub>f</sub> /cm <sup>2</sup>	D638	650
Tensile Elongation at break	%	D638	2
Flexural Strength at yield	kg <sub>f</sub> /cm <sup>2</sup>	D790	800
Flexural Modulus	kg <sub>f</sub> /cm <sup>2</sup>	D790	45,000
Izod Impact Strength, notched, 23°C (1/8")	kg <sub>f</sub> ·cm/cm	D256	5
<b>THERMAL</b>			
HDT, 18.6 kg <sub>f</sub> /cm <sup>2</sup>	°C	D648	100
<b>ELECTRICAL</b>			
<b>OTHERS</b>			
UL-94 Flammability (1.5~1.65mm 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® 640G20 GRADE

ABS

- General processing conditions for TRIBS640G20 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	°C	90
Drying Time	hr	3-4
Moisture Content, Max	%	0.02
Melt Temperature	°C	220-240
Nozzle Temperature	°C	220-240
Front Temperature	°C	210-230
Middle Temperature	°C	210-230
Rear Temperature	°C	190-200
Mold Temperature	°C	50-80
Back Pressure	MPa	0.3-0.5
Screw Speed	rpm	40-70
Vent Depth	mm	0.02-0.08

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