Shinko-Lac® ABS HF-5

Acrylonitrile Butadiene Styrene

Mitsubishi Rayon America Inc.

Message:

Shinko-Lac ABS HF-5 is a ultra-high flow grade of ABS that is suitable for large or thin products and is effective for the remedies of sink marks, weld lines and molding cycle savings. Other features of HF-5 include an excellent balance of rigidity, strength, processability and glossiness.
Typical applications of HF-5 include ventilation accessories and underlying washing machine bodies.

General Information	
Features	Good dimensional stability
	Rigidity, high
	Highlight
	High strength
	Impact resistance, good
	Weldable
	Workability, good
	Sprayable
	Machinable
	High liquidity
	Good chemical resistance
	Good toughness
	Good appearance
	Non-toxic
	High hardness
UL File Number	E54695
Appearance	Available colors
	Natural color
Forms	Particle
Processing Method	Extrusion
	Calendering
	Vacuum forming
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50	%	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method

Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (23°C)	2450	MPa	ASTM D638
Tensile Strength (Yield, 23°C)	40.2	MPa	ASTM D638
Flexural Modulus (23°C, 6.35 mm)	2450	MPa	ASTM D790
Flexural Strength (Yield, 23°C, 6.35 mm)	62.8	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ASTM D256
-40°C, 6.35 mm	69	J/m	ASTM D256
0°C, 6.35 mm	98	J/m	ASTM D256
23°C, 6.35 mm	140	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed, 12.7 mm)	88.0	°C	ASTM D648
CLTE - Flow	8.5E-5	cm/cm/°C	ASTM D696
Specific Heat	1670	J/kg/°C	ASTM C351
Thermal Conductivity	0.21	W/m/K	ASTM C177
Flammability	**Nominal Value**		**Test Method**
Flame Rating (NC)	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0 - 85.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	180 - 250	°C	
Middle Temperature	180 - 250	°C	
Front Temperature	180 - 250	°C	
Mold Temperature	40.0 - 80.0	°C	
Injection Pressure	58.8 - 108	MPa	

Injection instructions

Higher mold temperature provides a product with excellent surface finish and less residual stress.

Recommended distributors for this material

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