

Generic MABS

Methyl Methacrylate / ABS

Generic

Message:

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General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.07 - 1.16	g/cm ³	ASTM D792
23°C	1.08 - 1.12	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
220°C/10.0 kg	2.0 - 19	g/10 min	ASTM D1238
220°C/10.0 kg	13 - 23	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	2.00 - 8.05	cm ³ /10min	ISO 1133
Molding Shrinkage			
Flow: 23°C	0.40 - 0.55	%	ASTM D955
23°C	0.40 - 0.55	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
23°C	108 - 115		ASTM D785
23°C	113 - 116		ISO 2039-2
Ball Indentation Hardness	70.0 - 76.3	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	1950 - 2600	MPa	ASTM D638
23°C	1880 - 2720	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	42.9 - 51.4	MPa	ASTM D638
Yield, 23°C	40.8 - 57.3	MPa	ISO 527-2
Fracture, 23°C	29.0 - 53.9	MPa	ASTM D638
Fracture, 23°C	35.0 - 72.0	MPa	ISO 527-2
Tensile Strain			
Yield, 23°C	3.5 - 4.0	%	ISO 527-2
Fracture, 23°C	10 - 40	%	ASTM D638
Fracture, 23°C	9.7 - 20	%	ISO 527-2
Flexural Modulus			
23°C	1800 - 2610	MPa	ASTM D790
23°C	1490 - 3000	MPa	ISO 178

Flexural Stress			
23°C	55.0 - 85.4	MPa	ISO 178
Fracture, 23°C	64.0 - 87.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.7 - 14	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	6.0 - 120	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	20 - 140	J/m	ASTM D256
23°C	2.0 - 12	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	83.8 - 92.2	°C	ISO 75-2/B
1.8 MPa, not annealed	77.0 - 92.0	°C	ASTM D648
1.8 MPa, not annealed	72.4 - 78.4	°C	ISO 75-2/A
Vicat Softening Temperature	90.0 - 105	°C	ISO 306
Electrical	Nominal Value		Test Method
Dissipation Factor (23°C)	0.013 - 0.016		IEC 60250
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 85.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.048 - 0.051	%	
Rear Temperature	205	°C	
Middle Temperature	215	°C	
Front Temperature	230	°C	
Nozzle Temperature	240	°C	
Processing (Melt) Temp	230 - 246	°C	
Mold Temperature	50.0 - 60.0	°C	
Injection Pressure	126 - 156	MPa	
Back Pressure	1.23 - 1.26	MPa	
Screw Speed	49 - 50	rpm	
Injection instructions			

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