

Sinkral® F 332

Acrylonitrile Butadiene Styrene

Versalis S.p.A.

Message:

Sinkral F 332 is a general purpose injection moulding grade which combines excellent thermal stability during processing with a good balance between flow and impact characteristics.

Designation: Thermoplastic ISO 2580-ABS 1,MGN,105-15-16-20

Suitable for use in a variety of industrial sectors, for the production of small household appliances and white goods, vacuum cleaners and telephones.

Grade available in natural colour only.

The composition of this grade, on request, can meet European Regulations for packaging in contact with foodstuff.

General Information	
Features	General Purpose
	Good Flow
	Good Impact Resistance
	Good Thermal Stability
Uses	Appliances
	General Purpose
	Household Goods
	Industrial Applications
	White Goods & Small Appliances
Appearance	Natural Color
Forms	Pellets
Processing Method	Injection Molding
Multi-Point Data	Specific Volume vs Temperature (ISO 11403-2)
	Viscosity vs. Shear Rate (ISO 11403-2)

Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	14	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.60	%	Internal Method
Water Absorption (23°C, 24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	42.0	MPa	ASTM D638
Tensile Elongation ² (Break)	60	%	ASTM D638
Flexural Modulus ³	2250	MPa	ASTM D790
Flexural Strength ⁴	60.0	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	13	kJ/m ²	DIN 53453
Charpy Unnotched Impact Strength			DIN 53453
-40°C	No Break		
23°C	No Break		
Notched Izod Impact			
-40°C, 3.20 mm	90	J/m	ISO 180/4A
-20°C, 3.20 mm	100	J/m	ISO 180/4A
0°C, 3.20 mm	130	J/m	ISO 180/4A
23°C, 3.20 mm	190	J/m	ISO 180/4A
-40°C ⁵	8.0	kJ/m ²	ISO 180/1A
23°C ⁶	14	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Annealed)	101	°C	ASTM D648
Vicat Softening Temperature			
--	107	°C	ISO 306/A120
--	102	°C	ISO 306/B120
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
Thermal Conductivity	0.17	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Electric Strength	30	kV/mm	IEC 60243-1
Dielectric Constant (1 kHz)	3.10		IEC 60250
Dissipation Factor (1 kHz)	0.015		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Glow Wire Ignition Temperature (3.00 mm)	650	°C	IEC 60695-2-13
Additional Information	Nominal Value		
Designation	Thermoplastic ISO 2580-ABS 1,MGN,105-15-16-20		
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 4.0	hr	
Processing (Melt) Temp	230 to 270	°C	
Mold Temperature	40.0 to 70.0	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	2.0 mm/min		
4.	2.0 mm/min		
5.	4 mm		

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