

# Abstron SE-32M

Acrylonitrile Butadiene Styrene  
Bhansali Engineering Polymers Limited

Message:

Abstron SE-32M is an acrylonitrile butadiene styrene (ABS) product. It can be processed by sheet extrusion molding and is available in the Asia-Pacific region. The application fields of Abstron SE-32M include thin plates, automobile industry and consumer goods.

Features include:

- flame retardant/rated flame
- Impact resistance

General Information			
Features	Impact resistance, high		
Uses	Leather case		
	Sheet		
	Application in Automobile Field		
Forms	Particle		
Processing Method	Sheet extrusion molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup> (Yield, 3.20 mm)	43.1	MPa	ASTM D638
Flexural Modulus (6.40 mm)	2010	MPa	ASTM D790
Flexural Strength (Yield, 6.40 mm)	63.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
3.20 mm	440	J/m	ASTM D256
6.40 mm	340	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Annealed)	94.0	°C	ASTM D648
Vicat Softening Temperature	106	°C	ASTM D1525 <sup>2</sup>
Flammability	Nominal Value		Test Method
Flame Rating (3.20 mm)	HB		UL 94
Extrusion	Nominal Value	Unit	
Drying Temperature	85.0 - 90.0	°C	
Drying Time	3.0 - 3.5	hr	

Suggested Max Moisture	0.15	%
Cylinder Zone 1 Temp.	220 - 235	°C
Melt Temperature	220 - 240	°C
Die Temperature	215 - 235	°C

Extrusion instructions

Drying Time (Tray Oven): 3 to 3.5 hrDrying Time (Hopper Dryers): 2.5 to 3 hrDrying Time (Dry Air Ovens): 2 to 2.5 hrVacuum: >600 mm HgRoller Temperature - Down Stack Top: 95°CRoller Temperature - Down Stack Middle: 80°CRoller Temperature - Down Stack Bottom: 90°CRoller Temperature - Up Stack Top: 95°CRoller Temperature - Up Stack Middle: 85°CRoller Temperature - Up Stack Bottom: 95°C

NOTE

- |    |                    |
|----|--------------------|
| 1. | Type 1, 5.0 mm/min |
| 2. | 标准 B (120°C/h)     |

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