

# EnCom ABS 4050

Acrylonitrile Butadiene Styrene

EnCom, Inc.

Message:

Molding Grade ABS

| General Information |                         |
|---------------------|-------------------------|
| Uses                | Automotive Applications |
|                     | Business Equipment      |
|                     | Thin-walled Parts       |
| Appearance          | Black                   |
|                     | Colors Available        |
|                     | Natural Color           |
| Forms               | Pellets                 |
| Processing Method   | Injection Molding       |
|                     | Profile Extrusion       |

| Physical                                                | Nominal Value | Unit              | Test Method |
|---------------------------------------------------------|---------------|-------------------|-------------|
| Specific Gravity                                        | 1.05          | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)                | 3.5           | g/10 min          | ASTM D1238  |
| Molding Shrinkage - Flow (3.18 mm)                      | 0.40 to 0.80  | %                 | ASTM D955   |
| Mechanical                                              | Nominal Value | Unit              | Test Method |
| Tensile Modulus                                         | 2280          | MPa               | ASTM D638   |
| Tensile Strength (Yield)                                | 43.4          | MPa               | ASTM D638   |
| Flexural Modulus                                        | 2410          | MPa               | ASTM D790   |
| Flexural Strength (Yield)                               | 68.9          | MPa               | ASTM D790   |
| Impact                                                  | Nominal Value | Unit              | Test Method |
| Notched Izod Impact (23°C)                              | 240           | J/m               | ASTM D256   |
| Thermal                                                 | Nominal Value | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed) | 82.2          | °C                | ASTM D648   |
| Flammability                                            | Nominal Value |                   | Test Method |
| Flame Rating (1.57 mm)                                  | HB            |                   | UL 94       |
| Injection                                               | Nominal Value | Unit              |             |
| Drying Temperature                                      | 82.2 to 93.3  | °C                |             |
| Drying Time                                             | 2.0 to 4.0    | hr                |             |
| Drying Time, Maximum                                    | 7.0           | hr                |             |
| Suggested Max Moisture                                  | 0.15          | %                 |             |

|                        |                |     |
|------------------------|----------------|-----|
| Rear Temperature       | 188 to 232     | °C  |
| Middle Temperature     | 204 to 246     | °C  |
| Front Temperature      | 218 to 260     | °C  |
| Nozzle Temperature     | 218 to 274     | °C  |
| Processing (Melt) Temp | 218 to 274     | °C  |
| Mold Temperature       | 48.9 to 76.7   | °C  |
| Back Pressure          | 0.172 to 0.689 | MPa |
| Screw Speed            | 25 to 75       | rpm |

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