

CP PRYME® ABS A100-89

Acrylonitrile Butadiene Styrene

Chase Plastics Services Inc.

Message:

Prime ABS, General Purpose

General Information			
UL YellowCard	E313980-102632388		
Uses	General		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	5.6	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	112		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2270	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	44.0	MPa	ASTM D638
Fracture	33.0	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	2.0	%	ASTM D638
Fracture, 23°C	25	%	ASTM D638
Flexural Modulus (50.0 mm Span)	2300	MPa	ASTM D790
Flexural Strength (Yield, 50.0 mm Span)	70.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	320	J/m	ASTM D256
Instrumented Dart Impact	30.1	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	93.9	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	80.0	°C	ASTM D648
Vicat Softening Temperature	81.1	°C	ASTM D1525
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	8.8E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	8.8E-5	cm/cm/°C	ASTM E831
Injection	Nominal Value	Unit	
Drying Temperature	82 - 93	°C	

Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	188 - 210	°C
Middle Temperature	204 - 227	°C
Front Temperature	216 - 238	°C
Nozzle Temperature	218 - 260	°C
Mold Temperature	49 - 71	°C
Back Pressure	0.345 - 0.689	MPa

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