

KumhoSunny ABS BM510

Acrylonitrile Butadiene Styrene
Shanghai KumhoSunny Plastics Co., Ltd.

Message:
ABS BM510 is a high impact ABS resin for blow molding.
Application:automobile rear spoiler, side step, car seat, fiber reinforced plastic jar inner liner.

General Information			
Features	High Impact Resistance		
Uses	Automotive Applications		
	Automotive Exterior Parts		
	Child Safety Seats		
	Liners		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Blow Molding		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.0	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 to 0.70	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	106		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	45.0	MPa	ISO 527-2/50
Flexural Modulus ¹	2200	MPa	ISO 178
Flexural Stress ²	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	15	kJ/m ²	
23°C	33	kJ/m ²	
Charpy Unnotched Impact Strength ⁴ (23°C)	No Break		ISO 179
Notched Izod Impact Strength ⁵ (23°C)	32	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed)	85.0	°C	ISO 75-2/A
Vicat Softening Temperature	95.0	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	170 to 190	°C	
Middle Temperature	180 to 200	°C	
Front Temperature	190 to 220	°C	
Nozzle Temperature	180 to 210	°C	
Processing (Melt) Temp	180 to 220	°C	
Mold Temperature	30.0 to 50.0	°C	
Back Pressure	1.00 to 5.00	MPa	
Screw Speed	30 to 70	rpm	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	Condition: 4 J		
4.	Condition: 4 J		
5.	Condition: 5.5 J		
6.	120°C/h		

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