

PPR ABS04

Acrylonitrile Butadiene Styrene
Premier Plastic Resins, Inc.

Message:

PPR ABS04 is an acrylonitrile butadiene styrene (ABS) product. It can be processed by injection molding and is available in North America. The main characteristics are: low gloss.

General Information			
Features	Gloss, low		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	41.4	MPa	ASTM D638
Tensile Elongation (Break)	35	%	ASTM D638
Flexural Modulus - Tangent	2140	MPa	ASTM D790
Flexural Strength	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	140	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	91.0	°C	ASTM D648
1.8 MPa, not annealed	85.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	77.0 - 82.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	227 - 254	°C	
Middle Temperature	232 - 260	°C	
Front Temperature	232 - 260	°C	
Nozzle Temperature	243 - 254	°C	
Processing (Melt) Temp	227 - 260	°C	
Mold Temperature	49.0 - 77.0	°C	
Injection Pressure	5.00 - 55.0	MPa	
Injection Rate	Moderate-Fast		
Holding Pressure	3.00 - 45.0	MPa	

Back Pressure	0.00 - 1.00	MPa
Cushion	6.35 - 12.7	mm
Injection instructions		

Screw Speed: Moderate-FastDecompression: 3.81 to 7.6 mm

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