

# NEXUS ABS ABSLG3030

Acrylonitrile Butadiene Styrene

Nexus Resin Group, LLC.

Message:

Molding Grade ABS, Low Gloss

| General Information                                              |                   |                   |             |
|------------------------------------------------------------------|-------------------|-------------------|-------------|
| Features                                                         | Low Gloss         |                   |             |
| Processing Method                                                | Injection Molding |                   |             |
| 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)                         | 3.0               | g/10 min          | ASTM D1238  |
| Molding Shrinkage - Flow                                         | 0.40 to 0.80      | %                 | ASTM D955   |
| Mechanical                                                       | Nominal Value     | Unit              | Test Method |
| Tensile Modulus                                                  | 2280              | MPa               | ASTM D638   |
| Tensile Strength (Yield)                                         | 41.4              | 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, 3.18 mm)                              | 160               | J/m               | ASTM D256   |
| Thermal                                                          | Nominal Value     | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm) | 82.2              | °C                | ASTM D648   |
| Optical                                                          | Nominal Value     | Test Method       |             |
| Gardner Gloss (60°)                                              | < 60              | ASTM D523         |             |
| Injection                                                        | Nominal Value     | Unit              |             |
| Drying Temperature                                               | 82.2 to 93.3      | °C                |             |
| Drying Time                                                      | 2.0 to 4.0        | hr                |             |
| Suggested Max Moisture                                           | 0.15              | %                 |             |
| Rear Temperature                                                 | 188 to 218        | °C                |             |
| Middle Temperature                                               | 204 to 232        | °C                |             |
| Front Temperature                                                | 218 to 246        | °C                |             |
| Nozzle Temperature                                               | 218 to 274        | °C                |             |
| Processing (Melt) Temp                                           | 218 to 274        | °C                |             |
| Mold Temperature                                                 | 37.8 to 48.9      | °C                |             |
| Back Pressure                                                    | 0.172 to 0.689    | MPa               |             |
| Screw Speed                                                      | 25 to 75          | rpm               |             |

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