

Edgetek™ X AS/018 NC704

Acrylonitrile Butadiene Styrene

PolyOne Corporation

Message:

ABS Resin

General Information			
Features	Good liquidity		
	Good coloring		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50 - 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	55.0	MPa	ASTM D638
Flexural Modulus ²	2500	MPa	ASTM D790
Flexural Strength ³	75.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	250	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	85.0	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+13	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 85.0	°C	
Drying Time	4.0	hr	
Rear Temperature	200 - 240	°C	
Middle Temperature	200 - 240	°C	
Front Temperature	200 - 240	°C	
Mold Temperature	65.0 - 85.0	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	50 mm/min		

2.	1.3 mm/min
3.	1.3 mm/min

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