

PRL ABS-GP-IM

Acrylonitrile Butadiene Styrene

Polymer Resources Ltd.

Message:

PRL ABS-GP-IM is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by injection molding and is available in North America.

Characteristics include:

RoHS Compliant

Impact Modified

General Information			
Additive	Impact Modifier		
Features	General Purpose		
	Impact Modified		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.02	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	7.0 to 11	g/10 min	
230°C/3.8 kg	1.0 to 3.0	g/10 min	
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (3.18 mm)	1930	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield, 3.18 mm	37.9	MPa	
Break, 3.18 mm	30.4	MPa	
Tensile Elongation			ASTM D638
Yield, 3.18 mm	2.0	%	
Break, 3.18 mm	25	%	
Flexural Modulus (3.18 mm)	1890	MPa	ASTM D790
Flexural Strength (3.18 mm)	58.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	28	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	370	J/m	ASTM D256
-30°C	9.0	kJ/m ²	ISO 180/1A
23°C	28	kJ/m ²	ISO 180/1A
Gardner Impact (3.18 mm)	22.6	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	87.8	°C	
1.8 MPa, Unannealed, 3.18 mm	82.2	°C	
Vicat Softening Temperature	98.9	°C	ASTM D1525 ¹
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 93.3	°C	
Drying Time	2.0 to 5.0	hr	
Drying Time, Maximum	8.0	hr	
Rear Temperature	193 to 210	°C	
Middle Temperature	216 to 238	°C	
Front Temperature	227 to 254	°C	
Processing (Melt) Temp	232 to 274	°C	
Mold Temperature	48.9 to 82.2	°C	
NOTE			
1.	Rate B (120°C/h), Loading 2 (50 N)		

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