

# KRALASTIC® KU-611 R-1

Acrylonitrile Butadiene Styrene

Nippon A&L; Inc.

## Message:

KRALASTIC® KU-611 R-1 is an Acrylonitrile Butadiene Styrene (ABS) material. It is available in Asia Pacific or North America for blow molding.

| General Information                               |               |                        |                 |
|---------------------------------------------------|---------------|------------------------|-----------------|
| Forms                                             | Pellets       |                        |                 |
| Processing Method                                 | Blow Molding  |                        |                 |
| Physical                                          | Nominal Value | Unit                   | Test Method     |
| Density (23°C)                                    | 1.05          | g/cm <sup>3</sup>      | ISO 1183        |
| Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)       | 1.30          | cm <sup>3</sup> /10min | ISO 1133        |
| Molding Shrinkage                                 | 0.40 to 0.60  | %                      | Internal Method |
| Hardness                                          | Nominal Value | Unit                   | Test Method     |
| Rockwell Hardness (R-Scale, 23°C)                 | 114           |                        | ISO 2039-2      |
| Mechanical                                        | Nominal Value | Unit                   | Test Method     |
| Tensile Stress (Yield, 23°C)                      | 54.0          | MPa                    | ISO 527-2       |
| Flexural Modulus (23°C)                           | 2500          | MPa                    | ISO 178         |
| Flexural Stress (23°C)                            | 83.0          | MPa                    | ISO 178         |
| Impact                                            | Nominal Value | Unit                   | Test Method     |
| Charpy Notched Impact Strength (23°C)             | 18            | kJ/m <sup>2</sup>      | ISO 179         |
| Thermal                                           | Nominal Value | Unit                   | Test Method     |
| Heat Deflection Temperature (1.8 MPa, Unannealed) | 94.0          | °C                     | ISO 75-2/A      |
| CLTE - Flow (23 to 80°C)                          | 7.6E-5        | cm/cm/°C               | JIS K7197       |
| Additional Information                            | Nominal Value | Unit                   |                 |
| Blow Molding Barrel Temperature                   | 220 to 270    | °C                     |                 |
| Blow Molding Drying Temperature                   | 90 to 100     | °C                     |                 |
| Blow Molding Drying Time                          | > 3.0         | hr                     |                 |
| Blow Molding Mold Temperature                     | 40 to 80      | °C                     |                 |

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## Recommended distributors for this material

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