

UMG ABS® GF20

Acrylonitrile Butadiene Styrene

UMG ABS, Ltd.

Message:

UMG ABS® GF20 is an Acrylonitrile Butadiene Styrene (ABS) material filled with 20% glass fiber. It is available in Asia Pacific or North America for injection molding.

Important attributes of UMG ABS® GF20 are:

Flame Rated

RoHS Compliant

General Information			
UL YellowCard	E47016-237423		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
RoHS Compliance	RoHS Compliant		
UL File Number	E47016		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.20	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (23°C)	0.10 to 0.40	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	117		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	7000	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	96.0	MPa	ISO 527-2
Flexural Modulus ¹ (23°C)	6200	MPa	ISO 178
Flexural Stress ² (23°C)	126	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	3.0	kJ/m ²	
23°C	7.0	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	101	°C	ISO 75-2/Af
CLTE - Flow	4.0E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0	°C	
Drying Time	3.0 to 4.0	hr	

Rear Temperature	190 to 210	°C
Middle Temperature	210 to 230	°C
Front Temperature	220 to 250	°C
Nozzle Temperature	200 to 230	°C
Processing (Melt) Temp	220 to 260	°C
Mold Temperature	60.0 to 80.0	°C
Injection Pressure	70.0 to 140	MPa
Injection Rate	Moderate	
Back Pressure	5.00 to 15.0	MPa
Screw Speed	50 to 80	rpm

NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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