

NEXUS ABS ABS450FR

Acrylonitrile Butadiene Styrene
Nexus Resin Group, LLC.

Message:
Molding Grade ABS

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
UL File Number	E205256		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2210	MPa	ASTM D638
Tensile Strength (Yield)	37.9	MPa	ASTM D638
Flexural Modulus	2280	MPa	ASTM D790
Flexural Strength (Yield)	65.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	190	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	76.7	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (1.57 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	76.7 to 87.8	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.15	%	
Rear Temperature	166 to 182	°C	
Middle Temperature	177 to 204	°C	
Front Temperature	191 to 232	°C	
Nozzle Temperature	191 to 232	°C	
Processing (Melt) Temp	191 to 232	°C	
Mold Temperature	48.9 to 76.7	°C	
Back Pressure	0.172 to 0.689	MPa	
Screw Speed	25 to 75	rpm	

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