

Calsak ABS CS-72L

Acrylonitrile Butadiene Styrene

Calsak Polymers

Message:

Calsak ABS CS-72L is an acrylonitrile butadiene styrene (ABS) product. It can be processed by injection molding and is available in North America. Features include:
flame retardant/rated flame
high gloss
Impact resistance

General Information			
Features	Highlight		
	Impact resistance, high		
	General		
Uses	General		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 kg	2.0	g/10 min	ASTM D1238
230°C/3.8 kg	7.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	107		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.18 mm)	2080	MPa	ASTM D638
Tensile Strength ² (Yield, 3.18 mm)	44.8	MPa	ASTM D638
Tensile Elongation (Break)	40	%	ASTM D638
Flexural Modulus ³ (3.18 mm)	2450	MPa	ASTM D790
Flexural Strength ⁴ (3.18 mm)	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	340	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	91.1	°C	ASTM D648
Vicat Softening Temperature	93.0	°C	ASTM D1525
Flammability	Nominal Value		Test Method
Flame Rating (1.59 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2 - 87.8	°C	
Drying Time	2.0	hr	

Rear Temperature	235 - 249	°C
Middle Temperature	241 - 254	°C
Front Temperature	246 - 260	°C
Nozzle Temperature	246 - 260	°C
Processing (Melt) Temp	246 - 302	°C
Mold Temperature	43.3 - 65.6	°C
Injection Pressure	68.9 - 110	MPa
Injection Rate	Fast	
Back Pressure	0.00 - 0.172	MPa
Clamp Tonnage	2.8 - 5.5	kN/cm ²

Injection instructions

Hold Pressure: 50 to 75% of injection pressureScrew Speed: Moderate

NOTE

1. Type 1
2. Type 1
3. Type 1
4. Type 1

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