

NEXUS Reprocessed ABS Black Repro

Acrylonitrile Butadiene Styrene

Nexus Resin Group, LLC.

Message:

NEXUS Reprocessed ABS Black Repro is an Acrylonitrile Butadiene Styrene (ABS) material. It is available in North America for injection molding.

Important attributes of NEXUS Reprocessed ABS Black Repro are:

Flame Rated

Eco-Friendly/Green

General Information			
Recycled Content	Yes		
Appearance	Black		
Forms	Pellets, Reprocessed		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.05	g/cm ³	ASTM D792
--	0.952	g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	4.0 to 5.0	g/10 min	ASTM D1238
Spiral Flow	86.4	cm	
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.80	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2200	MPa	ASTM D638
Tensile Strength ² (Yield)	47.6	MPa	ASTM D638
Flexural Modulus ³	2410	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.8 mm Span)	71.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	190 to 210	J/m	ASTM D256
Instrumented Dart Impact (23°C)	3.39	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	93.9	°C	
1.8 MPa, Unannealed, 3.18 mm	81.1	°C	
1.8 MPa, Unannealed, 6.35 mm	85.0	°C	
CLTE - Flow (-40 to 60°C)	1.5E-4	cm/cm/°C	ASTM E831
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI Str	60.0	°C	UL 746
Electrical	Nominal Value		Test Method
Comparative Tracking Index (CTI)	PLC 1		UL 746
High Amp Arc Ignition (HAI)	PLC 0		UL 746

Hot-wire Ignition (HWI)	PLC 4		UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.47 mm)	HB		UL 94
Optical	Nominal Value		Test Method
Gardner Gloss (60°)	25		ASTM D523
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (127°C, 1000 sec^-1)	155	Pa·s	ASTM D3835
Injection	Nominal Value	Unit	
Drying Temperature	87.8 to 93.3	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.010	%	
Suggested Shot Size	50 to 70	%	
Rear Temperature	193 to 238	°C	
Middle Temperature	210 to 249	°C	
Front Temperature	221 to 254	°C	
Nozzle Temperature	232 to 277	°C	
Processing (Melt) Temp	232 to 277	°C	
Mold Temperature	48.9 to 82.2	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	30 to 60	rpm	
Vent Depth	0.038 to 0.051	mm	
NOTE			
1.	5.1 mm/min		
2.	Type I, 5.1 mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		

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