

CP PRYME® ABS A100HI-85

Acrylonitrile Butadiene Styrene

Chase Plastics Services Inc.

Message:

Prime ABS, High Impact, Natural

General Information			
Features	Impact resistance, high		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	3.7	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	15.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.80	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2070	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	41.4	MPa	ASTM D638
Fracture	31.7	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	2.1	%	ASTM D638
Fracture	26	%	ASTM D638
Flexural Modulus (50.0 mm Span)	2140	MPa	ASTM D790
Flexural Strength (Yield, 50.0 mm Span)	68.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	370	J/m	ASTM D256
Instrumented Dart Impact	31.1	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	97.2	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	82.2	°C	ASTM D648
Vicat Softening Temperature	98.9	°C	ASTM D1525
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	8.8E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	8.8E-5	cm/cm/°C	ASTM E831
Injection	Nominal Value	Unit	
Drying Temperature	82 - 93	°C	

Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	188 - 210	°C
Middle Temperature	204 - 227	°C
Front Temperature	216 - 238	°C
Nozzle Temperature	218 - 260	°C
Mold Temperature	49 - 71	°C
Back Pressure	0.345 - 0.689	MPa

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