

EnCom ABS 6020

Acrylonitrile Butadiene Styrene
EnCom, Inc.

Message:
Molding Grade Utility ABS

General Information			
Uses	Automotive Applications		
	Business Equipment		
	General Purpose		
	Thin-walled Parts		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
	Profile Extrusion		
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)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.40 to 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	106		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	43.1	MPa	ASTM D638
Tensile Elongation (Break)	19	%	ASTM D638
Flexural Modulus	2620	MPa	ASTM D790
Flexural Strength (Yield)	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	92.2	°C	
1.8 MPa, Unannealed	87.8	°C	
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.57 mm	HB		
3.18 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 93.3	°C	

Drying Time	2.0 to 4.0	hr
Drying Time, Maximum	7.0	hr
Suggested Max Moisture	0.15	%
Rear Temperature	188 to 232	°C
Middle Temperature	204 to 246	°C
Front Temperature	218 to 260	°C
Nozzle Temperature	218 to 274	°C
Processing (Melt) Temp	218 to 274	°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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