

TECHNO ABS 77 K4

Acrylonitrile Butadiene Styrene

Techno Polymer Co, Ltd.

Message:

TECHNO ABS 77 K4 is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by injection molding and is available in Asia Pacific or North America. Primary characteristic: flame rated.

General Information			
Features	Laser Markable		
UL File Number	E54297		
Appearance	White		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.09	g/cm ³	ISO 1183, ASTM D1505
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	25	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.60	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	108		ASTM D785
R-Scale	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield	45.1	MPa	ASTM D638
Yield	48.0	MPa	ISO 527-2
Flexural Modulus			
--	2300	MPa	ASTM D790
--	2270	MPa	ISO 178
Flexural Strength			
--	73.5	MPa	ASTM D790
--	72.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	9.0	kJ/m ²	ISO 179
Notched Izod Impact	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	90.0	°C	ASTM D648
0.45 MPa, Unannealed	74.0	°C	ISO 75-2/B
Flammability	Nominal Value	Test Method	
Flame Rating (ALL)	HB	UL 94	
Injection	Nominal Value	Unit	

Drying Temperature	80.0 to 90.0	°C
Drying Time	2.0 to 5.0	hr
Rear Temperature	190 to 260	°C
Middle Temperature	190 to 260	°C
Front Temperature	190 to 260	°C
Mold Temperature	40.0 to 80.0	°C

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