

Clariant ABS ABS4500

Acrylonitrile Butadiene Styrene

Clariant Corporation

Message:

Clariant ABS ABS4500 is an acrylonitrile butadiene styrene (ABS) material. This product is available in North America and is processed by injection molding.

The main features of Clariant ABS ABS4500 are:

- high gloss
- Good dimensional stability
- Impact resistance
- chemical resistance

General Information			
UL YellowCard	E103015-218174		
Features	Good dimensional stability		
	Highlight		
	Impact resistance, high		
	Good chemical resistance		
	General		
Uses	General		
Appearance	Black		
	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.60	%	ASTM D955
Water Absorption (24 hr)	0.35	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	103		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	44.1	MPa	ASTM D638
Tensile Elongation (Yield)	25	%	ASTM D638
Flexural Modulus	2280	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	87.8	°C	ASTM D648

1.8 MPa, not annealed	82.2	°C	ASTM D648
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength	17	kV/mm	ASTM D149

Additional Information

Notched Izod Impact, ASTM D256, Colors: 3.6 ft-lb/in Notched Izod Impact, ASTM D256, Black: 3.3 ft-lb/in

Injection	Nominal Value	Unit
Drying Temperature	85.0	°C
Drying Time	2.0 - 4.0	hr
Rear Temperature	204 - 249	°C
Middle Temperature	204 - 249	°C
Front Temperature	204 - 249	°C
Processing (Melt) Temp	204 - 246	°C
Melt Temperature (Aim)	227	°C
Mold Temperature	23.9 - 79.4	°C
Injection Rate	Moderate-Fast	
Back Pressure	0.345 - 2.07	MPa
Screw Speed	20 - 100	rpm
Cushion	3.18 - 6.35	mm

Injection instructions

The minimum injection pressure to achieve 95% fill of the part during the boost injection pressure phase should be used. The hold pressure should be between 30% and 75% of the initial injection pressure.

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