Clariant ABS ABS3400

Acrylonitrile Butadiene Styrene

Clariant Corporation

Message:

Clariant ABS ABS3400 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 ABS3400 are:
high gloss
Good dimensional stability
beautiful
Impact resistance
chemical resistance

General Information			
Features	Good dimensional stability Highlight Impact resistance, good Good chemical resistance General Excellent appearance		
Uses	General		
Appearance	Black Available colors Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.05	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.40	%	ASTM D955
Water Absorption (24 hr)	0.35	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	44.8	MPa	ASTM D638
Tensile Elongation (Yield)	20	%	ASTM D638
Flexural Modulus	2340	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.18 mm)	170	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	7.2E-5	cm/cm/°C	ASTM D696

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength	16	kV/mm	ASTM D149

Additional Information
Notched Izod Impact, ASTM D256, Colors: 3.0 ft-lb/inNotched Izod Impact, ASTM D256, Black: 2.8 ft-lb/in

Injection	Nominal Value	Unit
Drying Temperature	82.2	°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.

Recommended distributors for this material

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