

EnCore 1009

ABS



Product Description					
High Heat, Chemically Resistant, with Proprietary Additive					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding, Profile Extrusion				
Applications	Automotive, Business Equip., Thin Wall Applications				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	3,800	psi	26	MPa
Tensile Strength @ Break	ASTM D638	5,500	psi	38	MPa
Flexural Modulus	ASTM D790	320,000	psi	2,206	MPa
Flexural Strength	ASTM D790	8,000	psi	55	MPa
Notched Izod Impact (73°F)	ASTM D256	5.0	ft-lb/in	267	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.10	sp gr	1.10	sp gr
Melt Flow 260°C/3.8 kg	ASTM D1238	20.0	g/10min	20.0	g/10min
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	210	°F	99	°C
Injection Molding		Value			
Drying Temperature		180 - 200	°F		
Drying Time		3.0 - 4.0	hr		
Maximum Drying Time		8.0	hr		
Suggested Maximum Moisture		0.10%	%		
Rear Barrel Temperatures		400 - 450	°F		
Middle Barrel Temperatures		410 - 460	°F		
Front Barrel Temperatures		420 - 470	°F		
Nozzle Temperature		420 - 470	°F		
Melt (processing) Temperatures		430 - 480	°F		
Mold Temperatures		90 - 150	°F		
Back Pressure		25 - 100	psi		
Screw speed		25 - 75	rpm		

These Data Sheet Values are Typical Values and are not intended for specification purposes. These values should only be used as a guide and no assurances by EnCom, Inc. can be granted that all molded articles will exhibit duplicate properties as those listed above. Each material user should perform their own testing for suitability.