EnCore 2005

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 220°C/10.0 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