

Product Description					
High impact ABS					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding, Profile Extrusion, Sheet Extrusion				
Applications	Sporting goods, electronic displays construction applications				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	5,660	psi	39	MPa
Tensile Elongation at Break	ASTM D638	4.40	%	4.40	%
Flexural Modulus	ASTM D790	313,000	psi	2,159	MPa
Flexural Strength	ASTM D790	9,570	psi	66	MPa
Notched Izod Impact (73°F)	ASTM D256	8.1	ft-lb/in	433	J/m
Notched Izod Impact (-22F)	ASTM D256	5.6	ft-lb/in	299	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.03	sp gr	1.03	sp gr
Melt Flow 220°C/10 kg	ASTM D1238	4.5	g/10min	4.5	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.006 to 0.008	in/in	0.006 to 0.008	mm
Mold Shrink -XFlow: 0.126 in (3.20 mm)	ASTM D955	0.006 to 0.008	in/in	0.006 to 0.008	mm
Flame Rating 0.062	UL-94V	HB		HB	
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi	ASTM D648	170	°F	77	°C
Injection Molding		Value			
Drying Temperature		180 - 200	°F		
Drying Time		2.0 - 4.0	hr		
Maximum Drying Time		7.0	hr		
Suggested Maximum Moisture		0.10	%		
Rear Barrel Temperatures		370 - 450	°F		
Middle Barrel Temperatures		400 - 475	°F		
Front Barrel Temperatures		425 - 500	°F		
Nozzle Temperature		425 - 525	°F		
Melt (processing) Temperatures		425 - 525	°F		
Mold Temperatures		120 - 170	°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.