

EnCore 603-CL1002

Transparent ABS



Product Description					
Molding Grade Transparent ABS with Exceptional Impact					
General Properties					
Appearance	90% Light transmission optically clear				
Processing Methods	Injection Molding				
Applications	Automotive, Business Equip. Thin Wall Applications				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	7,500	psi	52	MPa
Tensile Elongation at Break	ASTM D638	14.00	%	14.00	%
Flexural Modulus	ASTM D790	330,000	psi	2,276	MPa
Flexural Strength	ASTM D790	11,000	psi	76	MPa
Notched Izod Impact (73°F)	ASTM D256	2.5	ft-lb/in	134	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.09	sp gr	1.09	sp gr
Melt Flow 230°C/3.8 kg	ASTM D1238	6.0	g/10min	6.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.004 - 0.008	in/in	0.004 - 0.008	mm
Mold Shrink -XFlow: 0.126 in (3.20 mm)	ASTM D955	0.004 - 0.008	in/in	0.004 - 0.008	mm
Flame Rating 0.125	UL 94	HB		HB	
Flame Rating 0.062	UL 94	HB		HB	
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	175	°F	79	°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.

EnCom Polymers, Inc.

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