

# EnCore F0502

ABS



Product Description					
Flame Retardant Molding Grade ABS,					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding, Profile Extrusion				
Applications	Electrical, Electronic Business Equipment				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	5,500	psi	38	MPa
Tensile Modulus	ASTM D638	320,000	psi	2207	MPa
Tensile Elongation at Break	ASTM D638	4.40	%	4.40	%
Flexural Modulus	ASTM D790	330,000	psi	2,276	MPa
Flexural Strength	ASTM D790	9,500	psi	66	MPa
Notched Izod Impact (73°F)	ASTM D256	2.0	ft-lb/in	107	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.22	sp gr	1.22	sp gr
Melt Flow 230°C/3.8 kg	ASTM D1238	5.0	g/10min	5.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.005 - 0.008	in/in	0.005 - 0.008	mm
Mold Shrink -XFlow: 0.126 in (3.20 mm)	ASTM D955	0.004 to 0.007	in/in	0.004 to 0.007	mm
Flame Rating 0.125	UL 94	V-0		V-0	
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		170 - 190	°F		
Drying Time		2.0 - 4.0	hr		
Maximum Drying Time		7.0	hr		
Suggested Maximum Moisture		0.10	%		
Rear Barrel Temperatures		330 - 360	°F		
Middle Barrel Temperatures		350 - 400	°F		
Front Barrel Temperatures		375 - 450	°F		
Nozzle Temperature		375 - 450	°F		
Melt (processing) Temperatures		375 - 450	°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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