

ABS MA210

Extrusion Molding

Description

General Purpose, Low Gloss

Application

Automotive Sheet, Semi-Conductor Tray

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.04
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4 - 0.7
Melt Flow Rate	220°C/10kg	ASTM D1238	g/10min	5
Water Absorption	23°C, 24hrs	ASTM D570	%	0.19
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	480
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	> 60
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²	
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm ²	720
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm ²	24,000
IZOD Impact Strength, 6.4mm (Notched)	23°C	ASTM D256	kg-cm/cm	7
	-20°C		kg-cm/cm	6
IZOD Impact Strength, 3.2mm (Notched)	23°C	ASTM D256	kg-cm/cm	10
	-20°C		kg-cm/cm	7
Rockwell Hardness	R-Scale	ASTM D785	-	105
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	91
	4.6kg		°C	
Vicat Softening Temperature	5kg, 50°C/h	ASTM D1525	°C	99
Flammability	0.8mm	UL94	class	HB
	1.6mm		class	HB
	2.5mm		class	HB
	3.2mm		class	HB
Optical				
Gloss	45°	ASTM D2457	-	

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23°C, 50% relative humidity.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要更多物性资料请查阅 www.kedisujiao.com

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	℃	70 ~ 80	
Drying Time	hrs	3 ~ 4	
Minimum Moisture Content	%	0.01	
Melt Temperature	℃	200 ~ 230	
Cylinder Temperature	Rear	℃	180 ~ 200
	Middle	℃	190 ~ 210
	Front	℃	200 ~ 230
Nozzle Temperature	℃	200 ~ 230	
Mold Temperature	℃	40 ~ 60	
Back Pressure	kg/cm ²	300 ~ 600	
Screw Speed	rpm	30 ~ 60	

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

Processing Guide (Extrusion Molding)

Processing Parameters	Unit	Value	
Drying Temperature	℃	70 ~ 80	
Drying Time	hrs	3 ~ 4	
Minimum Moisture Content	%	0.01	
Melt Temperature	℃	200 ~ 230	
Barrel Temperature	Zone 1	℃	180 ~ 200
	Zone 2	℃	190 ~ 210
	Zone 3	℃	200 ~ 230
	Zone 4	℃	200 ~ 230
Adapter Temperature	℃	200 ~ 230	
Die Temperature	℃	200 ~ 230	
Roll Stack Temperature	Top	℃	70 ~ 100
	Middle	℃	70 ~ 90
	Bottom	℃	60 ~ 90

Note) Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.

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