

ABS MP230

Injection Molding Grade

Description

High HDT Metal Platng ABS

Application

Automobile Radiator Grill, Molding

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Density		ISO 1183	g/cm ³	1.05
Molding Shrinkage (Flow), 3.2mm		ISO 294-4	%	0.4~0.7
Melt Flow Rate	220℃/10kg	ISO 1133	g/10min	11.0
Mechanical				
Tensile Strength @ Yield	50mm/min	ISO 527	MPa	41
Tensile Modulus	1mm/min	ISO 527	MPa	1,900
Flexural Strength	2mm/min	ISO 178	MPa	63
Flexural Modulus	2mm/min	ISO 178	MPa	2,000
IZOD Impact Strength, 80*10*4mm (Notched)	23℃	ISO 180/1A	kJ/m ²	26.0
	-30℃		kJ/m ²	-
Charpy Impact Strength, 80*10*4mm (Notched)	23℃	ISO179/1eA	kJ/m ²	26.0
	-30℃		kJ/m ²	-
Rockwell Hardness		ISO 2039	-	105
Thermal				
Heat Deflection Temp. 120*10*4mm	1.8MPa	ISO 75/Be	℃	85
	0.45MPa	ISO 75/Ae	℃	94
Vicat Softening Temperature		ISO 306		
	50N, 50℃/h		℃	100
Flammability		UL94		HB

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℃, 50% relative humidity.

Updated : 14-Oct-14

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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		℃	240~260
Cylinder Temperature	Rear	℃	210~230
	Middle	℃	220~240
	Front	℃	230~250
Nozzle Temperature		℃	230~250
Mold Temperature		℃	50~70
Back Pressure		kg/cm ²	700 ~ 900
Screw Speed		rpm	under 80

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.

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