772

ABS

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	**8.5**	g/10min	ASTM D 1238
Temperature	**220**	°C	-
Load	**10**	kg	-
Mold Shrinkage, MD	**0.0045**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	**52**	MPa	ASTM D 638
Elongation at Break	**25**	%	ASTM D 638
Flexural Modulus	**2200**	MPa	ASTM D 790
Flexural Strength	**70**	MPa	ASTM D 790
Izod Impact notched, 1/8 in	**350**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	**HB**	-	UL 94
DTUL @ 264 psi	**88**	°C	ASTM D 648
Vicat Temperature	**98**	°C	ASTM D 1525

Electrical properties	Value	Unit	Test Standard
ISO Data			
Volume resistivity	**1E14**	Ohm*m	IEC 62631-3-1
Surface resistivity	**1E14**	Ohm	IEC 62631-3-2

Other properties	Value	Unit	Test Standard
Density	**1040**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80 - 90**	°C	-
Pre-drying - Time	**3 - 4**	h	-
Processing humidity	**≤0.05**	%	-
Melt temperature	**200 - 230**	°C	-
Mold temperature	**50 - 80**	°C	-
Zone 1	**170 - 190**	°C	-
Zone 2	**180 - 200**	°C	-
Zone 3	**190 - 220**	°C	-
Nozzle temperature	**180 - 210**	°C	-
Screw speed	**30 - 60**	rpm	-
Back pressure	**1 - 5**	MPa	-

Characteristics

Processing

Injection Molding

Applications

Refrigeration

Special Characteristics

High impact or impact modified

Regional Availability

Asia Pacific